

Technical Data Sheet

Polyflam PC 510GF BLKBLK



Polycarbonate

Product Description

Flame Retardent, 10% Glass Reinforced, Polycarbonate

Processing Method Injection Molding

Additive Flame Retardant

| Typical Properties | Nominal Value | Units | Test Method |
|--|----------------------|-------------------|--------------------|
| Physical | | | |
| Melt Flow Rate, (300 °C/2.16 kg) | 10 | g/10 min | ASTM D1238 |
| Density - Specific Gravity | 1.27 | g/cm ³ | ASTM D792 |
| Mechanical | | | |
| Tensile Strength at Yield, (50 mm/min) | 55.0 | MPa | ASTM D638 |
| Flexural Modulus, (1.3 mm/min) | 3100 | MPa | ASTM D790 |
| Impact | | | |
| Notched Izod Impact | 120 | J/m | ASTM D256 |
| UL Information | | | |
| Flame Rating | | | |
| (1.5 mm) | V-0 | | UL 94 |
| (2.5 mm) | 5VA | | UL 94 |
| (3.4 mm) | 5VA | | UL 94 |

| Injection Parameters | Nominal Value | Units |
|-----------------------------|----------------------|--------------|
| Drying Temperature | 121 | °C |
| Suggested Max Moisture | <0.020 | % |
| Nozzle Temperature | 249 to 288 | °C |
| Screw Speed | 40 to 75 | rpm |
| Processing (Melt) Temp | 249 to 288 | °C |
| Front Temperature | 249 to 288 | °C |
| Middle Temperature | 249 to 288 | °C |
| Rear Temperature | 249 to 277 | °C |
| Back Pressure | <0.689 | MPa |
| Mold Temperature | 71 to 104 | °C |