

WONDERLOY[®] PC-330

Non-flame retardant, general purpose PC/ABS, widely used in automotive industry, especially plating application

PROPERTIES	CONDITION	VALUE	UNIT	METHOD
<u>PHYSICAL</u>				
Specific Gravity	23°C	1.08		ISO 1183
Melt Volume-Flow Rate	260°C/5kg	13	cm ³ /10min	ISO 1133
Spiral Flow Length	260°C, 2mm V:50%, P:50%	35	cm	Chimei method
Mold Shrinkage		0.4~0.6	%	ISO 2577
Rockwell Hardness	23°C	R-108	---	ISO 2039-2
CLTE	Flow:23-55°C	9.00E-06	cm/cm/°C	ISO11359-2
<u>MECHANICAL</u>				
Tensile Strength @ Yield	50mm/min	50	MPa	ISO 527
Tensile Strength @ break	50mm/min	40	MPa	ISO 527
Tensile Elongation @ Break	50mm/min	100	%	ISO 527
Flexural Strength	2mm/min	70	MPa	ISO 178
Flexural Modulus	2mm/min	2100	MPa	ISO 178
Izod Impact (3.2mm)	Notched, 23°C	40	kJ/m ²	ISO 180
Izod Impact (3.2mm)	Notched, -30°C	35	kJ/m ²	ISO 180
Charpy Impact (3.2mm)	Notched, 23°C	40	kJ/m ²	ISO 179
Charpy Impact (3.2mm)	Notched, -30°C	35	kJ/m ²	ISO 179
<u>THERMAL</u>				
Heat Distortion Temp. (unannealed、4mm)	1.82MPa, 120°C/hr 0.45MPa,120°C/hr	88 103	°C	ISO 75
Vicat Softening Temp. (unannealed)	1kg, 50°C/hr 5kg, 50°C/hr	116 106	°C	ISO 306
<u>ELECTRICAL</u>				
Dielectric Constant	1MHz	3.1	--	IEC 60250
Volume Resistivity	--	1E+16	Ohm*m	IEC 60093
Surface Resistivity	--	1E+16	Ohm	IEC 60093

PROCESSING PARAMETERS

Drying Temperature	80~100	°C
Drying Time	4	Hrs
Barrel Temperature	230~270	°C
Mold Temperature	50~100	°C
