

MRC Polymers NAXELL, PC23MS Polycarbonate, Impact Modified, High MFR, EZ Flow

Category : Polymer , Thermoplastic , Polycarbonate (PC) , Polycarbonate, Impact Modified

Material Notes:

Economy Grade Impact modified Can be UV stabilized Generally for black only Internal and external lubricant can be added Information provided by MRC Polymers Inc.

Order this product through the following link:

http://www.lookpolymers.com/polymer_MRC-Polymers-NAXELL-PC23MS-Polycarbonate-Impact-Modified-High-MFR-EZ-Flow.php

| Physical Properties | Metric | English | Comments |
|-----------------------|--|--|--|
| Specific Gravity | 1.19 g/cc | 1.19 g/cc | ASTM D792 |
| Linear Mold Shrinkage | 0.0050 - 0.0070 cm/cm @Thickness 3.17 mm | 0.0050 - 0.0070 in/in @Thickness 0.125 in | ASTM D955 |
| Melt Flow | 28 g/10 min @Load 1.20 kg, Temperature 300 Å°C | 28 g/10 min @Load 2.65 lb, Temperature 572 Å°F | Can be modified between 10 and 20 g/10mins; ASTM D1238 |

| Mechanical Properties | Metric | English | Comments |
|-------------------------|--|---|-------------------|
| Tensile Strength, Yield | 56.5 MPa @Thickness 3.17 mm, Temperature 22.8 Å°C | 8200 psi @Thickness 0.125 in, Temperature 73.0 Å°F | ASTM D638 |
| Flexural Strength | 86.2 MPa @Thickness 3.17 mm, Temperature 22.8 Å°C | 12500 psi @Thickness 0.125 in, Temperature 73.0 Å°F | ASTM D790 |
| Flexural Modulus | 2.00 GPa @Thickness 3.17 mm, Temperature 22.8 Å°C | 290 ksi @Thickness 0.125 in, Temperature 73.0 Å°F | Secant; ASTM D790 |
| Izod Impact, Notched | 3.20 J/cm @Thickness 3.17 mm, Temperature 22.8 Å°C | 6.00 ft-lb/in @Thickness 0.125 in, Temperature 73.0 Å°F | ASTM D256 |
| Dart Drop, Total Energy | 39.3 J @Temperature 22.8 Å°C | 29.0 ft-lb @Temperature 73.0 Å°F | ASTM D3763 |

| Thermal Properties | Metric | English | Comments |
|--------------------|--|--|-----------|
| CTE, linear | 65.0 Åµm/m-Å°C @Temperature -40.0 - | 36.1 Åµin/in-Å°F @Temperature -40.0 - | ASTM D696 |

| Thermal Properties | 35.0 Å°C Metric | 95.0 Å°F English | Comments |
|---|-------------------------------|--------------------------------|------------------------|
| Deflection Temperature at 0.46 MPa (66 psi) | 132 Å°C @Thickness 3.17 mm | 270 Å°F @Thickness 0.125 in | un-annealed; ASTM D648 |
| Deflection Temperature at 1.8 MPa (264 psi) | 121 Å°C @Thickness 3.17 mm | 250 Å°F @Thickness 0.125 in | un-annealed; ASTM D648 |

| Processing Properties | Metric | English | Comments |
|---------------------------|-------------------|-----------------------------|-----------------------------|
| Rear Barrel Temperature | 238 - 249 Å°C | 460 - 480 Å°F | |
| Middle Barrel Temperature | 249 - 260 Å°C | 480 - 500 Å°F | |
| Front Barrel Temperature | 260 - 271 Å°C | 500 - 520 Å°F | |
| Nozzle Temperature | 260 - 271 Å°C | 500 - 520 Å°F | |
| Melt Temperature | 254 - 271 Å°C | 490 - 520 Å°F | |
| Mold Temperature | 48.9 - 93.3 Å°C | 120 - 200 Å°F | |
| Drying Temperature | 116 Å°C | 240 Å°F | |
| Dry Time | 3 - 4 hour | 3 - 4 hour | |
| Moisture Content | <= 0.020 % | <= 0.020 % | |
| Dew Point | <= -17.8 Å°C | <= 0.000 Å°F | |
| Drying Air Flow Rate | 22.7 - 28.3 l/min | 0.800 - 1.00 ftÅ³/min (CFM) | per lb/hour resin processed |
| Injection Pressure | 68.9 - 138 MPa | 10000 - 20000 psi | |
| Back Pressure | 0.345 - 1.21 MPa | 50.0 - 175 psi | |
| Cushion | 0.635 cm | 0.250 in | |
| Screw Speed | 50 - 75 rpm | 50 - 75 rpm | |

| Descriptive Properties | Value | Comments |
|------------------------|------------------------------|----------|
| Fill Rate | Moderate | |
| Hold Pressure | 40-60% of injection pressure | |
| Packing Pressure | 50-75% of injection pressure | |

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