

MRC Polymers NAXALOY™, 770 GF10 ABS+PC Alloy, 10% Glass Fiber Filled

Category : Polymer , Thermoplastic , ABS Polymer , Polycarbonate/ABS Alloy, Glass Fiber Filled , Polycarbonate (PC)

Material Notes:

Can be UV Stabilized 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-NAXALOY-770-GF10-ABSPC-Alloy-10-Glass-Fiber-Filled.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.20 g/cc	1.20 g/cc	ISO 1183-A
Filler Content	10 %	10 %	ISO 3451/1-A
Linear Mold Shrinkage	0.0030 - 0.0060 cm/cm	0.0030 - 0.0060 in/in	ISO 294
Melt Flow	5.0 - 9.0 g/10 min @Load 5.00 kg, Temperature 260 Â°C	5.0 - 9.0 g/10 min @Load 11.0 lb, Temperature 500 Â°F	nominal; ISO 1133

Mechanical Properties	Metric	English	Comments
Tensile Strength at Break	69.98 MPa	10150 psi	ISO 527-1
Flexural Modulus	3.80 GPa	551 ksi	ISO 178
Izod Impact, Notched (ISO)	12.0 kJ/mÂ² @Temperature 22.8 Â°C	5.71 ft-lb/inÂ² @Temperature 73.0 Â°F	ISO 180/1eA

Thermal Properties	Metric	English	Comments
CTE, linear	66.0 Âµm/m-Â°C @Temperature -30.0 - 80.0 Â°C	36.7 Âµin/in-Â°F @Temperature -22.0 - 176 Â°F	ASTM E831 (TMA)
CTE, linear, Transverse to Flow	90.0 Âµm/m-Â°C @Temperature -30.0 - 80.0 Â°C	50.0 Âµin/in-Â°F @Temperature -22.0 - 176 Â°F	ASTM E831 (TMA)
Deflection Temperature at 0.46 MPa (66 psi)	116 Â°C	240 Â°F	ISO 75
Deflection Temperature at 1.8 MPa (264 psi)	127 Â°C	260 Â°F	ISO 75

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	260 - 271 Â°C	500 - 520 Â°F	

Middle Barrel Temperature Processing Properties	266 - 277 Â°C Metric	510 - 530 Â°F English	Comments
Front Barrel Temperature	271 - 282 Â°C	520 - 540 Â°F	
Nozzle Temperature	260 - 282 Â°C	500 - 540 Â°F	
Melt Temperature	266 - 282 Â°C	510 - 540 Â°F	
Mold Temperature	60.0 - 82.2 Â°C	140 - 180 Â°F	
Drying Temperature	110 Â°C	230 Â°F	
Dry Time	4 hour	4 hour	
Moisture Content	<= 0.020 %	<= 0.020 %	
Dew Point	<= -17.8 Â°C	<= 0.000 Â°F	
Drying Air Flow Rate	22.7 - 28.3 l/min	0.800 - 1.00 ftÂ³/min (CFM)	per lb/hour resin processed
Injection Pressure	68.9 - 138 MPa	10000 - 20000 psi	
Back Pressure	0.345 - 0.689 MPa	50.0 - 100 psi	
Cushion	0.330 - 0.635 cm	0.130 - 0.250 in	
Screw Speed	40 - 70 rpm	40 - 70 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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