

MRC Polymers NAXALOY™, 770 GF16 ABS+PC Alloy, 16% 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-GF16-ABSPC-Alloy-16-Glass-Fiber-Filled.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.24 g/cc	1.24 g/cc	ASTM D792
Filler Content	16 %	16 %	ASTM D785
Linear Mold Shrinkage	0.002 - 0.003 cm/cm	0.002 - 0.003 in/in	ASTM D955
Melt Flow	3.0 g/10 min @Load 3.80 kg, Temperature 230 Â°C	3.0 g/10 min @Load 8.38 lb, Temperature 446 Â°F	nominal; ASTM D1238

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell R	121	121	ASTM D785
Tensile Strength at Break	96.5 MPa	14000 psi	ASTM D638
Flexural Strength	148 MPa	21500 psi	ASTM D790
Flexural Modulus	4.76 GPa	690 ksi	ASTM D790
Izod Impact, Notched	0.961 J/cm @Temperature -30.0 Â°C	1.80 ft-lb/in @Temperature -22.0 Â°F	ASTM D256
	1.07 J/cm @Temperature 22.8 Â°C	2.00 ft-lb/in @Temperature 73.0 Â°F	ASTM D256
Izod Impact, Unnotched	5.87 J/cm @Temperature 22.8 Â°C	11.0 ft-lb/in @Temperature 73.0 Â°F	ASTM D256
Falling Dart Impact	52.9 J @Temperature -28.9 Â°C	39.0 ft-lb @Temperature -20.0 Â°F	ASTM D3763
	58.3 J @Temperature 22.8 Â°C	43.0 ft-lb @Temperature 73.0 Â°F	ASTM D3763

Thermal Properties	Metric	English	Comments
Deflection Temperature at 0.46 MPa (66 psi)	138 Â°C	280 Â°F	ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	129 Â°C	264 Â°F	ASTM D648
Vicat Softening Point	129 Â°C	264 Â°F	49.0 N; ASTM D1525
	139 Â°C	282 Â°F	9.8 N; ASTM D1525

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	260 - 271 Â°C	500 - 520 Â°F	
Middle Barrel Temperature	266 - 277 Â°C	510 - 530 Â°F	
Front Barrel Temperature	271 - 282 Â°C	520 - 540 Â°F	
Nozzle Temperature	260 - 282 Â°C	500 - 540 Â°F	
Melt Temperature	271 - 293 Â°C	520 - 560 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	Slow to Moderate	
Hold Pressure	40-60% of injection pressure	
Packing Pressure	50-75% of injection pressure	

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