

PCN-2004G

Polycarbonate compound resin

General information

Description

Medium viscosity, easy mold release
Available in black color only

Applications

Low gloss grade

Typical properties¹

	Test method	Typical value	Unit
Physical			
Melt Flow Index, 300°C, 1.2 kg	ASTM D1238	10	g/10 min
Specific Gravity	ASTM D792	1.20	
Mold Shrinkage	ASTM D955	0.5~0.7	%
Mechanical			
Tensile Strength, yield, 50 mm/min	ASTM D638	640	kg _f /cm ²
Tensile Elongation, break, 50 mm/min	ASTM D638	100	%
Flexural Strength, yield, 10 mm/min	ASTM D790	1,000	kg _f /cm ²
Flexural Modulus, 10 mm/min	ASTM D790	30,000	kg _f /cm ²
IZOD Impact Strength, notched, 23°C, 1/8"	ASTM D256	10	kg _f -cm/cm
notched, 23°C, 1/4"	ASTM D256	-	kg _f -cm/cm
notched, -30°C, 1/8"	ASTM D256	-	kg _f -cm/cm
Thermal			
Heat Distortion Temp. 4.6 kg _f /cm ²	ASTM D648	-	°C
18.6 kg _f /cm ²	ASTM D648	130	°C
Vicat Softening Temp. Rate B/50	ASTM D1525	-	°C
Flammability			
UL94 V-0	UL94	1.0	mm
UL94 V-0	UL94	3.0	mm

Notes

ISO 9001, 14001, TS 16949

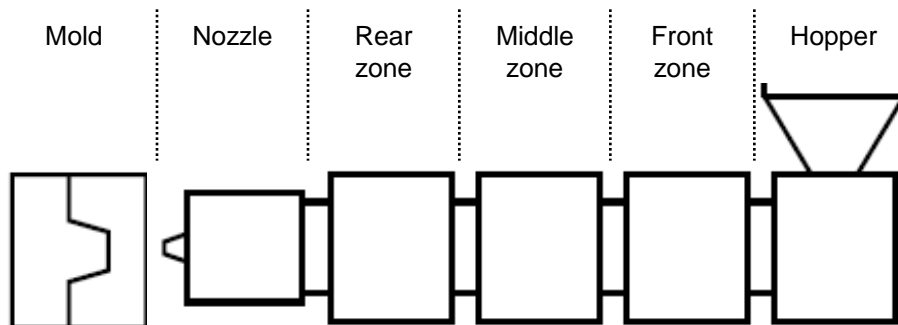
¹ Typical properties : these are not to be construed as specifications.

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Processing guides¹

	Typical value	Unit	
Drying condition			
Drying temperature	120	°C	
Drying time	4	hr	
Maximum moisture content	0.02	%	
Injection molding			
Melt temperature	290 ~ 310	°C	
Nozzle temperature	280 ~ 300	°C	
Barrel	Rear zone	290 ~ 310	°C
	Middle zone	280 ~ 300	°C
	Front zone	270 ~ 290	°C
Hopper temperature	60 ~ 80	°C	
Mold temperature	60 ~ 90	°C	



Recycling

Sprues and runners can be reground with virgin resin within the ratio of 10%. Care must be taken to ensure that the regrind is free from impurities and regrind should not be used in applications where impact performance and/or agency compliance are required.

Notes

ISO 9001, 14001, TS 16949

¹ Processing guides : Typical processing parameters are noted. Actual processing conditions will depend on machine size, mold design, material residence time, shot size, etc.