

# Panlite® AM-9937F

## TEIJIN LIMITED - Polycarbonate Alloy

### General Information

#### Product Description

Polycarbonate/Polyester alloy, Special fine filament

#### General

Filler / Reinforcement	• Mineral
Properties	• Chemical Resistant • Good Surface Finish
Uses	• Automotive Exterior Parts
Forms	• Pellets
Processing Method	• Injection Molding

### ASTM & ISO Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm <sup>3</sup>	ISO 1183
Melt Volume-Flow Rate (MVR) (280°C/2.16 kg)	17	cm <sup>3</sup> /10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow : 4.00 mm	0.50 to 0.80	%	
Flow : 4.00 mm	0.30 to 0.50	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	68.0	MPa	ISO 527-2/50
Tensile Stress (Break, 23°C)	55.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	20	%	ISO 527-2/50
Flexural Modulus <sup>2</sup> (23°C)	3800	MPa	ISO 178
Flexural Stress <sup>2</sup> (23°C)	100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.0	kJ/m <sup>2</sup>	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	105	°C	
CLTE - Flow	3.5E-5	cm/cm/°C	ISO 11359-2
CLTE - Transverse	6.5E-5	cm/cm/°C	ISO 11359-2

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	120	°C
Drying Time	5.0 to 8.0	hr
Processing (Melt) Temp	260 to 280	°C
Mold Temperature	60 to 90	°C

#### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 2.0 mm/min