

Electrafil® PC MCF/GB 1525 01 FR BK

Techmer Polymer Modifiers - *Polycarbonate*

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber\Glass Bead
Additive	• Flame Retardant
Features	• Flame Retardant
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.51		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 9.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	200000	psi	ASTM D638
Tensile Strength (Yield)	10000	psi	ASTM D638
Tensile Strength (Break)	9500	psi	ASTM D638
Tensile Elongation (Break)	1.1	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.70	ft-lb/in	ASTM D256
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+2 to 1.0E+6	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.12 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	550 to 590	°F
Middle Temperature	560 to 600	°F
Front Temperature	570 to 610	°F
Nozzle Temperature	580 to 620	°F
Processing (Melt) Temp	560 to 615	°F
Mold Temperature	200 to 275	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Moderate	

