

**InStruc® PCGF10HFMR**

Americhem - Polycarbonate

## General Information

**Product Description**

10% GLASS FIBER REINFORCED, HIGH FLOW POLYCARBONATE WITH MOLD RELEASE

**General**

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight
Additive	• Mold Release
Features	• Filled • High Flow • Lubricated • Good Dimensional Stability • High Stiffness • Good Mold Release • High Strength
Uses	• Automotive Applications • Electrical/Electronic Applications • Industrial Applications • Closures • Engineering Parts • Industrial Parts • Connectors • Household Goods • Office Automation Equipment • Consumer Applications • Housings
Forms	• Pellets
Processing Method	• Injection Molding

 Properties <sup>1</sup>

	Nominal Value	Unit	Test Method
<b>Physical</b>			
Density / Specific Gravity	1.26		ASTM D792
Molding Shrinkage - Flow	5.0E-3 to 7.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.18	%	ASTM D570
<b>Mechanical</b>			
Tensile Modulus	550000	psi	ASTM D638
Tensile Strength	9200	psi	ASTM D638
Tensile Elongation (Yield)	8.0 to 9.0	%	ASTM D638
Flexural Modulus	500000	psi	ASTM D790
Flexural Strength	15000	psi	ASTM D790
<b>Impact</b>			
Notched Izod Impact (0.125 in)	2.0	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	35	ft·lb/in	ASTM D4812
<b>Thermal</b>			
Deflection Temperature Under Load (264 psi, Unannealed)	275	°F	ASTM D648
<b>Flammability</b>			
Flame Rating (0.12 in)	HB		UL 94

## Processing Information

	Nominal Value	Unit
<b>Injection</b>		
Drying Temperature	250	°F
Drying Time	3.0 to 4.0	hr
Processing (Melt) Temp	580 to 620	°F
Mold Temperature	180 to 240	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm

