

InStruc® PCGF10HF

Americhem - Polycarbonate

General Information

Product Description

10% GLASS FIBER REINFORCED, HIGH FLOW POLYCARBONATE

General

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

 Properties ¹

	Nominal Value	Unit	Test Method
Physical			
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
Mechanical			
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
Impact			
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
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	275	°F	ASTM D648
Flammability			
Flame Rating (0.12 in)	HB		UL 94

Processing Information

	Nominal Value	Unit
Injection		
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

