

InStruc® PCGF5HFMR

Americhem - Polycarbonate

General Information
Product Description

5% GLASS FIBER REINFORCED, HIGH FLOW, MOLD RELEASE POLYCARBONATE

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 5.0% Filler by Weight		
Additive	• Mold Release		
Features	• Filled • Good Dimensional Stability • Good Mold Release	• High Flow • High Stiffness • High Strength	• Lubricated
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	1.10		ASTM D792
Molding Shrinkage - Flow	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical			
Tensile Modulus	440000	psi	ASTM D638
Tensile Strength	10100	psi	ASTM D638
Tensile Elongation (Yield)	4.0 to 6.0	%	ASTM D638
Flexural Modulus	420000	psi	ASTM D790
Flexural Strength	14500	psi	ASTM D790
Impact			
Notched Izod Impact (0.125 in)	2.8	ft·lb/in	ASTM D256
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	275	°F	ASTM D648

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	250	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
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

