

Polyflam PC 510GF NAT

LyondellBasell Industries - Polycarbonate

General Information

Product Description

Flame Retardant, 10% Glass Reinforced, Polycarbonate

General

Additive	• Flame Retardant
Features	• Flame Retardant
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.27		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/2.16 kg)	10	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	7980	psi	ASTM D638
Flexural Modulus ³	450000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	2.2	ft-lb/in	ASTM D256
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in		V-0	
0.10 in		5VA	
0.13 in		5VA	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Suggested Max Moisture	< 0.020	%
Rear Temperature	480 to 531	°F
Middle Temperature	480 to 550	°F
Front Temperature	480 to 550	°F
Nozzle Temperature	480 to 550	°F
Processing (Melt) Temp	480 to 550	°F
Mold Temperature	160 to 219	°F
Back Pressure	< 99.9	psi
Screw Speed	40 to 75	rpm

Notes

¹ Typical properties: these are not to be construed as specifications.

² 2.0 in/min

³ 0.051 in/min