

Polyflam 54N5006NONAT

LyondellBasell Industries - Polycarbonate

General Information

Product Description

Polyflam 54N5006NONAT is a Polycarbonate material and is typically used in Injection Molding applications.

General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.23		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	10	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8800	psi	ASTM D638
Flexural Modulus	325000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	13	ft-lb/in	ASTM D256
Gardner Impact	> 320	in-lb	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	264	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed	261	°F	ASTM D648
RTI Str	239	°F	UL 746B
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	4.0	hr
Rear Temperature	480 to 570	°F
Middle Temperature	480 to 570	°F
Front Temperature	480 to 570	°F
Processing (Melt) Temp	540 to 570	°F
Mold Temperature	160 to 219	°F
Injection Rate	Slow-Moderate	
Back Pressure	50.0 to 99.9	psi
Screw Speed	40 to 75	rpm
Cushion	0.250 to 0.500	in