

Technical Data Sheet

Polyflam PC 510GF

Polycarbonate
LyondellBasell Industries
Engineering Plastics

Product Description

Flame Retardant, 10% Glass Reinforced, Polycarbonate

General

Features	• Flame Retardant
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity	1.27	1.27 g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/2.16 Kg)	10 g/10 min	10 g/10 min	ASTM D1238
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Strength ¹ (Yield)	7980 psi	55.0 MPa	ASTM D638
Flexural Modulus ²	450000 psi	3100 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact	2.2 ft·lb/in	120 J/m	ASTM D256
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating			UL 94
0.06 In (1.5 Mm), All	V-0	V-0	
0.10 In (2.5 Mm), All	5VA	5VA	
0.13 In (3.4 Mm), All	5VA	5VA	

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	250 °F	121 °C
Suggested Max Moisture	< 0.02 %	< 0.02 %
Rear Temperature	480 to 530 °F	249 to 277 °C
Middle Temperature	480 to 550 °F	249 to 288 °C
Front Temperature	480 to 550 °F	249 to 288 °C
Nozzle Temperature	480 to 550 °F	249 to 288 °C
Processing (Melt) Temp	480 to 550 °F	249 to 288 °C
Mold Temperature	160 to 220 °F	71 to 104 °C
Back Pressure	< 100 psi	< 0.689 MPa
Screw Speed	40 to 75 rpm	40 to 75 rpm

Notes

¹ 2.0 in/min (50 mm/min)

² 0.051 in/min (1.3 mm/min)

Notes

These are typical property values not to be construed as specification limits.