

### WONDERLOY® PC-330

PC/ABS alloy, general purpose injection molding application

PROPERTIES	CONDITION	VALUE	UNIT	METHOD
<b><u>PHYSICAL</u></b>				
Melt Flow Index	260°C/5kg	13	g/10min	ASTM D-1238
Spiral Flow Length	260°C, 2mm V:50%, P:50%	35	cm	Chimei method
Specific Gravity	23°C	1.08	---	ASTM D-792
Mold Shrinkage		0.4~0.6	%	ASTM D-955
Rockwell Hardness	23°C	R-108	---	ASTM D-785
CLTE	Flow:23-55°C	9.00E-06	cm/cm/°C	ISO11359-2
<b><u>MECHANICAL</u></b>				
Tensile Strength @ Yield	50mm/min	500	kg/cm <sup>2</sup>	ASTM D-638
Tensile Elongation @ Break	50mm/min	85	%	ASTM D-638
Flexural Strength	1.3mm/min	750	kg/cm <sup>2</sup>	ASTM D-790
Flexural Modulus	1.3mm/min	23,000	kg/cm <sup>2</sup>	ASTM D-790
Izod Impact (1/8")	Notched, 23°C	45	kg-cm/cm	ASTM D-256
Izod Impact (1/8")	Notched, -30°C	40	kg-cm/cm	ASTM D-256
<b><u>THERMAL</u></b>				
Heat Distortion Temp. ( unannealed )	3.2mm, 1.82Mpa 120°C/hr 6.4mm, 1.82Mpa 120°C/hr	88 96	°C	ASTM D-648
Vicat Softening Temp. ( unannealed )	1kg, 50°C/hr 5kg, 50°C/hr	118 108	°C	ASTM D-1525
<b><u>ELECTRICAL</u></b>				
Dielectric Constant	1MHz	3.1	--	IEC 60250
Volume Resistivity	--	1E+16	Ohm*m	IEC 60093
Surface Resistivity	--	1E+16	Ohm	IEC 60093
<b><u>FLAMMABILITY</u></b>				
Flame Rating_HB		1.5	mm	UL-94



### PROCESSING PARAMETERS

Drying Temperature	80~100	°C
Drying Time	4	Hrs
Barrel Temperature	230~270	°C
Mold Temperature	50~100	°C

All figures listed here is for reference, not guaranteed.

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