

WONDERLOY® PC-385

PC/ABS alloy, Ultra high impact.

PROPERTIES	CONDITION	VALUE	UNIT	METHOD
<u>PHYSICAL</u>				
Melt Flow Index	260°C/5kg	21	g/10min	ASTM D-1238
Spiral Flow Length	260°C,2mm V:50%, P:50%	30	cm	Chimei method
Specific Gravity	23°C	1.15	---	ASTM D-792
Mold Shrinkage		0.4~0.6	%	ASTM D-955
Rockwell Hardness	23°C	R-114	---	ASTM D-785
CLTE	Flow:23-55°C	7.50E-05	cm/cm/°C	ISO11359-2
<u>MECHANICAL</u>				
Tensile Strength @ Yield	50mm/min	540	kg/cm ²	ASTM D-638
Tensile Strength @ Break	50mm/min	-	kg/cm ²	ASTM D-638
Tensile Elongation @ Yield	50mm/min	-	%	ASTM D-638
Tensile Elongation @ Break	50mm/min	90	%	ASTM D-638
Flexural Strength	1.3mm/min	800	kg/cm ²	ASTM D-790
Flexural Modulus	1.3mm/min	23500	kg/cm ²	ASTM D-790
Izod Impact (1/8")	Notched, 23°C	60	kg-cm/cm	ASTM D-256
Izod Impact (1/8")	Notched,-30°C	50	kg-cm/cm	ASTM D-256
<u>THERMAL</u>				
Heat Distortion Temp. (unannealed)	3.2mm,1.82Mpa 120°C/hr 6.4mm,1.82Mpa 120°C/hr	110 118	°C	ASTM D-648
Vicat Softening Temp. (unannealed)	1kg, 50°C/hr 5kg, 50°C/hr	140 133	°C	ASTM D-1525
<u>ELECTRICAL</u>				
Dielectric Constant	1MHz	3.0	--	IEC 60250
Volume Resistivity	--	1E+16	Ohm*m	IEC 60093
Surface Resistivity	--	1E+16	Ohm	IEC 60093
<u>FLAMMABILITY</u>				
Flame Class Rating		1.5 mm HB		UL-94



PROCESSING PARAMETERS

Drying Temperature	80~100	°C
Drying Time	4	Hrs
Barrel Temperature	240~280	°C
Mold Temperature	50~100	°C

All figures listed here is for reference, not guaranteed.

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