

Panlite® AM-9935FL

TEIJIN LIMITED - Polycarbonate Alloy

General Information

Product Description

Polycarbonate/Polyester alloy, Special fine filament

General

Filler / Reinforcement	• Mineral		
Properties	• Chemical Resistant	• Good Surface Finish	• High Flow
Uses	• Automotive Exterior Parts		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (280°C/1.2 kg)	22	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow : 4.00 mm	0.50 to 0.70	%	
Flow : 4.00 mm	0.40 to 0.60	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	60.0	MPa	ISO 527-2/50
Tensile Stress (Break, 23°C)	45.0	MPa	ISO 527-2/50
Tensile Strain (Break, 23°C)	15	%	ISO 527-2/50
Flexural Modulus ² (23°C)	3300	MPa	ISO 178
Flexural Stress ² (23°C)	92.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	102	°C	
CLTE - Flow	5.0E-5	cm/cm/°C	ISO 11359-2
CLTE - Transverse	7.0E-5	cm/cm/°C	ISO 11359-2

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	120	°C
Drying Time	4.0 to 8.0	hr
Processing (Melt) Temp	260 to 280	°C
Mold Temperature	50 to 80	°C

Notes

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

² 2.0 mm/min