

Opticarb 1614

The Materials Group - Polycarbonate

General Information

General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Features	<ul style="list-style-type: none"> High Impact Resistance
Uses	<ul style="list-style-type: none"> Automotive Applications
Forms	<ul style="list-style-type: none"> Pellets
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	18	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	363000	psi	ISO 527-1
Flexural Modulus	334000	psi	ISO 178
Flexural Stress	13100	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	30	ft·lb/in ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	255	°F	ISO 75-2/A

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	245 to 255	°F
Drying Time	4.0	hr
Rear Temperature	520 to 560	°F
Middle Temperature	540 to 580	°F
Front Temperature	560 to 600	°F
Nozzle Temperature	550 to 590	°F
Processing (Melt) Temp	560 to 600	°F
Mold Temperature	160 to 200	°F

Injection Notes

Exact processing temp will vary w/ part. Starting mid-lower range is typical. Contact TMG for on-site technical support.

Notes

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

