Opticarb 3400

The Materials Group - *Polycarbonate + ASA*

General Information

General			
Material Status	• Commercial: Active		
Availability	• North America		
Features	• Good Heat Resistance	• Good Weather Resistance	
Uses	• Automotive Applications	• Automotive Exterior Parts	• Automotive Interior Parts
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	34	g/10 min	ISO 1133
Molding Shrinkage	0.60 to 0.80	%	ISO 294-4
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress (Break)	6240	psi	ISO 527-2
Tensile Strain (Break)	17	%	ISO 527-2
Flexural Modulus	319000	psi	ISO 178
Flexural Stress	12600	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact Strength (73°F)	20	ft·lb/in²	ISO 180

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	200 to 220	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	460 to 490	°F
Middle Temperature	470 to 500	°F
Front Temperature	480 to 510	°F
Nozzle Temperature	470 to 510	°F
Mold Temperature	130 to 160	°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.