Opticarb 6085C

The Materials Group - *Polycarbonate + ABS*

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Features	• General Purpose
Uses	• General Purpose
Appearance	• Black
Forms	• Pellets

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	19	g/10 min	ISO 1133
Molding Shrinkage - Flow	0.50 to 0.80	%	ISO 294-4
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	305000	psi	ISO 527-1
Tensile Stress (Yield)	7540	psi	ISO 527-2
Tensile Strain (Yield)	8.0	%	ISO 527-2
Flexural Modulus	371000	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (73°F)	25	ft·lb/in²	ISO 179
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	221	°F	ISO 75-2/A
Vicat Softening Temperature	239	°F	ISO 306
CLTE - Flow (-22 to 86°F)	3.8E-5	in/in/°F	ISO 11359-2
CLTE - Transverse (-22 to 86°F)	4.0E-5	in/in/°F	ISO 11359-2

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	200 to 220	°F
Drying Time	2.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	440 to 480	°F
Middle Temperature	460 to 500	°F
Front Temperature	480 to 520	°F
Nozzle Temperature	480 to 520	°F
Processing (Melt) Temp	480 to 520	°F
Mold Temperature	140 to 190	°F
Back Pressure	80.0 to 100	psi

Notes

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