

## Opticarb 6085LG

The Materials Group - Polycarbonate + ABS

### General Information

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

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density	1.16	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	20	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	283000	psi	ISO 527-1
Tensile Stress (Yield)	6090	psi	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	25	ft·lb/in <sup>2</sup>	ISO 179

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	220 to 230	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Suggested Max Regrind	20	%
Rear Temperature	475 to 510	°F
Middle Temperature	480 to 520	°F
Front Temperature	500 to 530	°F
Nozzle Temperature	475 to 530	°F
Processing (Melt) Temp	475 to 530	°F
Mold Temperature	170 to 210	°F

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

