

Opticarb 6085SE

The Materials Group - Polycarbonate + ABS

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Features	• Low Friction
Appearance	• Black
Forms	• Pellets

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	16	g/10 min	ISO 1133
Molding Shrinkage - Flow	7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	7690	psi	ISO 527-2
Tensile Strain (Break)	25	%	ISO 527-2
Flexural Modulus	318000	psi	ISO 178
Flexural Stress	12200	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	12	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	257	°F	ISO 75-2/B

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	220 to 230	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.040	%
Processing (Melt) Temp	475 to 530	°F

Notes

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

