

Opticarb 8085MF20

The Materials Group - Polycarbonate + ABS

General Information

General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Filler / Reinforcement	<ul style="list-style-type: none"> Mineral
Uses	<ul style="list-style-type: none"> General Purpose
Appearance	<ul style="list-style-type: none"> Black
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 / Specific Gravity	1.22		ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	19	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	3.0E-3 to 5.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	7250	psi	ISO 527-2
Tensile Strain (Break)	10	%	ISO 527-2
Flexural Modulus	508000	psi	ISO 178
Flexural Stress	12900	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	18.0	ft-lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	194 to 230	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	420 to 440	°F
Middle Temperature	470 to 480	°F
Front Temperature	470 to 480	°F
Processing (Melt) Temp	450 to 480	°F
Mold Temperature	122 to 176	°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.

