

**WONDERLOY PC-510**

(PC+ABS)

CHIMEI Corporation

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt volume-flow rate, MVR	21	cm <sup>3</sup> /10min	ISO 1133
Temperature	260	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	20	g/10min	ASTM D 1238
Temperature	260	°C	-
Load	2.16	kg	-
Mold Shrinkage, MD	0.005	mm/mm	ASTM D 955
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Yield stress	55	MPa	ISO 527
Stress at break	45	MPa	ISO 527
Flexural modulus, 23°C	2500	MPa	ISO 178
Flexural strength	80	MPa	ISO 178
Charpy notched impact strength, +23°C	45	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	45	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
Tensile Strength at Yield	49	MPa	ASTM D 638
Elongation at Break	100	%	ASTM D 638
Flexural Modulus	2452	MPa	ASTM D 790
Flexural Strength	78.5	MPa	ASTM D 790
Rockwell Hardness	R 113	-	ASTM D 785
Izod Impact notched, 1/8 in	587	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	73	°C	ISO 75-1/-2
Vicat softening temperature, A	94	°C	ISO 306
Vicat softening temperature, B	85	°C	ISO 306
Coeff. of linear therm. expansion, parallel	80	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Yellow Card available	yes	-	-
Burning behav. 5V at thickness h	5VB	class	IEC 60695-11-20
Thickness tested	2.1	mm	-
Yellow Card available	yes	-	-
<b>ASTM Data</b>			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	77.8	°C	ASTM D 648
Vicat Temperature	85	°C	ASTM D 1525
<b>Electrical properties</b>			
<b>ISO Data</b>			
Relative permittivity, 1MHz	3.1	-	IEC 62631-2-1
Volume resistivity	3.9E15	Ohm*m	IEC 62631-3-1
Surface resistivity	2.9E15	Ohm	IEC 62631-3-2
<b>ASTM Data</b>			
Arc Resistance	90	s	ASTM D 495
<b>Other properties</b>			
Density	1170	kg/m <sup>3</sup>	ISO 1183
Density	1170	kg/m <sup>3</sup>	ASTM D 792

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<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>85</b>	°C	-
Pre-drying - Time	<b>4</b>	h	-
Mold temperature	<b>50 - 100</b>	°C	-
Feed temperature	<b>200 - 230</b>	°C	-
Zone 1	<b>230 - 260</b>	°C	-
Nozzle temperature	<b>220 - 250</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Special Characteristics**

Flame retardant

**Additives**

Flame retarding agent

**Regional Availability**

Asia Pacific