WONDERLOY PC-385

(PC+ABS) CHIMEI Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	**21**	cm³/10min	ISO 1133
Temperature	**260**	°C	-
Load	**5**	kg	-
Molding shrinkage, parallel	**0.5**	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	**21**	g/10min	ASTM D 1238
Temperature	**260**	°C	-
Load	**5**	kg	-
Mold Shrinkage, MD	**0.005**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	**55**	MPa	ISO 527
Stress at break	**57**	MPa	ISO 527
Flexural modulus, 23°C	**2300**	MPa	ISO 178
Flexural strength	**85**	MPa	ISO 178
Charpy notched impact strength, +23°C	**55**	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	**45**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**55**	kJ/m²	ISO 180/1A
Izod notched impact strength	**45**	kJ/m²	ISO 180/1A
Temperature	**-30**	°C	-
ASTM Data			
Tensile Strength at Yield	**53**	MPa	ASTM D 638
Elongation at Break	**90**	%	ASTM D 638
Flexural Modulus	**2305**	MPa	ASTM D 790
Flexural Strength	**78.5**	MPa	ASTM D 790
Rockwell Hardness	**R 114**	-	ASTM D 785
Izod Impact notched, 1/8 in	**587**	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	**491**	J/m	ASTM D 256
Temperature	**-34.4**	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**108**	°C	ISO 75-1/-2
Vicat softening temperature, A	**143**	°C	ISO 306
Vicat softening temperature, B	**135**	°C	ISO 306
Coeff. of linear therm. expansion, parallel	**75**	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	**HB**	class	IEC 60695-11-10
Thickness tested	**1.5**	mm	-
ASTM Data			
UL 94 Flame rating	**HB**	-	UL 94
Thickness tested	**1.5**	mm	-
Coefficient of Thermal Expansion, MD	**135**	E-6/K	ASTM D 696
DTUL @ 264 psi	**110**	°C	ASTM D 648
Vicat Temperature	**140**	°C	ASTM D 1525

Electrical properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 1MHz	**3**	-	IEC 62631-2-1
Volume resistivity	**1E16**	Ohm*m	IEC 62631-3-1
Surface resistivity	**1E16**	Ohm	IEC 62631-3-2
ASTM Data			
Dielectric Constant, 1 MHz	**3**	-	ASTM D 150
Surface Resistivity	**1E16**	Ohm	ASTM D 257
Volume Resistivity	**1E14**	Ohm*cm	ASTM D 257

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Other properties	Value	Unit	Test Standard
Density	**1150**	kg/m³	ISO 1183
Density	**1150**	kg/m³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80 - 100**	°C	-
Pre-drying - Time	**4**	h	-
Mold temperature	**50 - 100**	°C	-
Feed temperature	**200 - 230**	°C	-
Zone 1	**230 - 270**	°C	-
Nozzle temperature	**220 - 260**	°C	-

Characteristics

Processing
Injection Molding

Delivery form
Pellets

Special Characteristics
High impact or impact modified, Heat stabilized or stable to heat

Applications
Automotive, Electrical and Electronical, General Purpose

Regional Availability
Asia Pacific