



A~Star Plastics Pte Ltd

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Company & GST Registration #: 201504765Z

Technical Data Sheet

Material Type: POLYCARBONATE COMPOUNDED RESIN

Grade: PC-CP09IJ-HBIZ55(H)

Colour: Black

Application: For General Purpose Injection Molding

<u>Physical</u>	<u>Value</u>	<u>Unit</u>	<u>Test Method</u>
Density	1.2	g/cm ³	ASTM D792
Melt Flow Index at 300°C, 1.2 kgf	20 ± 5	g/10min	ASTM D1238
Water Absorption, 23°C	0.3	%	ASTM D570
<u>Mechanical</u>	<u>Value</u>	<u>Unit</u>	<u>Test Method</u>
Tensile Strength at yield	58 ± 2	MPa	ASTM D638
Tensile Elongation at break	> 60	%	ASTM D638
Izod Impact, notched, 23°C	55 ± 5	kgf.cm/cm	ASTM D256
Rockwell Hardness	115 - 118		ASTM D785
<u>Thermal</u>	<u>Value</u>	<u>Unit</u>	<u>Test Method</u>
Heat Deflection Temperature at 0.45 Mpa	120 - 130	°C	ASTM D648
Heat Deflection Temperature at 1.82 Mpa	110 - 115	°C	ASTM D648
Flammability	HB	-	UL94

Processing Condition

<u>Temperature</u>	<u>Value</u>	<u>Unit</u>
Melt Temperature	280 - 310	°C
Rear Barrel Temperature	280 - 300	°C
Middle Barrel Temperature	290 - 310	°C
Front Barrel Temperature	290 - 310	°C
Nozzle Temperature	280 - 290	°C
Mould Temperature	60 - 90	°C
Drying Temperature	110 - 115	°C
Drying Time	4	hour

The information should only be used as a reference guide.

A~Star Plastics makes no warranties of the product for any particular use or purpose.

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