

CHIMEI

奇美實業股份有限公司
CHI MEI CORPORATION

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WONDERLOY®

PC alloy, general purpose injection molding application

| PROPERTIES | CONDITION | PC-330 | PC-345 | PC-365 | PC-385 | UNIT | METHOD |
|---------------------------------------|------------------------------|------------|------------|------------|------------|------------------------|---------------|
| PHYSICAL | | | | | | | |
| Melt Flow Index | 260°C/5kg | 13 | 18 | 20 | 20 | cm ³ /10min | ISO 1133 |
| Spiral Flow Length | 260°C, 2mm V:50%, P:50% | 35 | 33 | 30 | 28 | cm | Chimei method |
| Specific Gravity | 23°C | 1.08 | 1.10 | 1.13 | 1.15 | --- | ISO 2039 |
| Mold Shrinkage | | 0.4~0.6 | 0.4~0.6 | 0.4~0.6 | 0.4~0.6 | % | ISO-2577 |
| Rockwell Hardness | 23°C | R-108 | R-108 | R-115 | R-114 | --- | ISO 2039-2 |
| CLTE | Flow:23-55°C | 9.0E-06 | 8.5E-06 | 8.0E-05 | 7.5E-05 | cm/cm/°C | ISO11359-2 |
| MECHANICAL | | | | | | | |
| Tensile Strength @ Yield | 50mm/min | 50 | 50 | 54 | 55 | MPa | ISO-527 |
| Tensile Strength @ Break | 50mm/min | 40 | 42 | 50 | 57 | MPa | ISO-527 |
| Tensile Elongation @ Break | 50mm/min | 100 | 100 | 120 | 130 | % | ISO-527 |
| Flexural Strength | 2mm/min | 70 | 75 | 80 | 85 | MPa | ISO-178 |
| Flexural Modulus | 2mm/min | 2100 | 2100 | 2200 | 2300 | MPa | ISO-178 |
| Izod Impact (3.2mm) | Notched, 23°C | 40 | 45 | 50 | 55 | kJ/m ² | ISO-180 |
| Izod Impact (3.2mm) | Notched, -30°C | 35 | 40 | 45 | 45 | kJ/m ² | ISO-180 |
| Charpy Impact (3.2mm) | Notched, 23°C | 40 | 45 | 50 | 55 | kJ/m ² | ISO-179 |
| Charpy Impact (3.2mm) | Notched, -30°C | 35 | 40 | 45 | 45 | kJ/m ² | ISO-179 |
| THERMAL | | | | | | | |
| Heat Distortion Temp. (unannealed) | 4.0mm, 1.82Mpa 120°C/hr | 88 | 93 | 102 | 108 | °C | ISO-75 |
| Vicat Softening Temp. (unannealed) | 1kg, 50°C/hr 5kg, 50°C/hr | 116 106 | 125 110 | 138 127 | 140 125 | °C | ISO-306 |
| FLAMMABILITY | | | | | | | |
| Flame Rating_HB | | 1.5 | 1.5 | 1.5 | 1.5 | mm | UL-94 |
| PROCESSING PARAMETERS | | | | | | | |
| Drying Temperature | | 80~100 | 80~100 | 80~100 | 80~100 | °C | |
| Drying Time | | 4 | 4 | 4 | 4 | Hrs | |
| Barrel Temperature | | 230~270 | 230~270 | 230~270 | 240~280 | °C | |
| Mold Temperature | | 50~100 | 50~100 | 50~100 | 50~100 | °C | |

All figures listed here is for reference, not guaranteed.

Final revised date : 2014/6

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