

Mar-Pol PC GP11

General	
Availability	Global
Processing Method	Injection Molding
Description	General purpose PC

Physical	Nominal Value	Test Method
Density/Specific Gravity	1.2 g/cm ³	ASTM D792
Melt Mass-Flow Rate	11 g/10 min	ASTM D1238

Mechanical	Nominal Value	Test Method
Tensile Modulus	2350 MPa	ASTM D638
Tensile Stress		ASTM D638
Yield	63 MPa	
Break	65 MPa	
Tensile Elongation		ASTM D638
Yield	6%	
Break	110%	
Flexural Modulus	2350 MPa	ASTM D790
Flexural Strength	90 MPa	ASTM D790

Impact	Nominal Value	Test Method
Notched Izod Impact	800 J/m	ASTM D256

Thermal	Nominal Value	Test Method
HDT, 1.82 MPa, 3.2mm, Unannealed	127 C	ASTM D 648
CTE, -40C to 95C, flow	6.84E-05 1/C	ASTM E 831

Flammability		
Flame Rating (1.5mm)	HB	UL 94

These suggestions and data are based on information we believe to be reliable. They are offered in good faith, but without guarantee as conditions and methods of use are beyond our control. We recommend that the prospective user determine the suitability of our materials and suggestions before adopting them on a commercial scale.

Injection Processing	Nominal Value
Drying Temperature	120 C
Drying Time	3 to 4 hours
Suggested Max Moisture	0.02%
Rear Temperature	270 to 295 C
Middle Temperature	280 - 305 C
Front Temperature	295 - 315 C
Nozzle Temperature	290 - 315 C
Processing (melt) Temperature	295 - 315 C
Mold Temperature	70 - 95 C
Back Pressure	.3 - .07 MPa
Screw Speed	40 to 70 rpm
Vent Depth	.025 - .076 mm

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