Technical Data Sheet

Polyflam 54N5006NT3099WHT SF

Polycarbonate

Product Description

Polyflam 54N5006NT3099WHT SF is a Polycarbonate material and is typically used in Injection Molding applications.

Processing Method	Injection Molding
Forms	Pellets
Additive	Flame Retardant

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (300 °C/1.2 kg)	10	g/10 min	ASTM D1238
Density - Specific Gravity	1.23	g/cm³	ASTM D792
Mechanical			
Tensile Strength at Yield	60.7	MPa	ASTM D638
Flexural Modulus	2240	MPa	ASTM D790
Impact			
Gardner Impact	>36.2	J	ASTM D5420
Notched Izod Impact	690	J/m	ASTM D256
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	127	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	129	°C	ASTM D648
RTI Str	115	°C	UL 746B
UL Information			
Flame Rating, (1.5 mm)	V-0		UL 94

Injection Parameters	Nominal Value	Units
Drying Time	4	hr
Drying Temperature	121	°C
Screw Speed	40 to 75	rpm
Processing (Melt) Temp	282 to 299	°C
Front Temperature	249 to 299	°C
Middle Temperature	249 to 299	°C
Rear Temperature	249 to 299	°C
Injection Rate	Slow-Moderate	
Back Pressure	0.345 to 0.689	MPa
Mold Temperature	71 to 104	°C
Cushion	6.35 to 12.7	mm