

TECHNICAL DATA SHEET

Shuman Compound:

Polycarbonate 910 Utility Black, 920 Black, 980Grey, 930 White

Offers this combination of properties:

Good impact strength, Easy processability

TYPICAL PROPERTIES

<u>MECHANICAL PROPERTIES</u>	<u>VALUE</u>	<u>UNITS</u>	<u>TEST METHODS</u>
Izod Impact Strength (Notched, 1/8" Thick Specimen)	12	FT-LBS/IN	ASTM D-256
Rockwell Hardness	70	M	ASTM D-785
Tensile Strength	9500	PSI	ASTM D-638

<u>THERMAL PROPERTIES</u>	<u>VALUE</u>	<u>UNITS</u>	<u>TEST METHODS</u>
Heat Deflection Temperature @ 264 PSI	262	deg. F	ASTM D-648
Vicat Softening Temperature	310	deg. F	ASTM D-1525

<u>OTHER PROPERTIES</u>	<u>VALUE</u>	<u>UNITS</u>	<u>TEST METHODS</u>
Specific Gravity	1.2		ASTM D-792
Melt Flow Rate	10 (+/-2) 15 (+/-2) 20 (+/-2)	GM/10 MIN.	ASTM D-1238

SUGGESTED PROCESSING CONDITIONS

<u>DRYING CONDITIONS:</u>	<u>TEMPERATURE (deg. F)</u>		<u>TIME (HOURS)</u>	
	<u>MIN.</u>	<u>MAX.</u>	<u>MIN.</u>	<u>MAX.</u>
Dehumidifying Dryer	250	260	2-3	24
Tray Dryer NOTE: Depth of granules in tray dryer should not exceed 1 in. (25.4 mm)	250	260	4-6	24

TEMPERATURE CONDITIONS:

510-550F

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