



novalca

NOVALUX® PC HF

PC compound,
General purpose grade

HF: low viscosity grade.

Color: available both in transparent and in opaque colors - for injection molding.

RECOMMENDED PROCESSING PARAMETERS FOR INJECTION MOLDING		
DRYING CONDITIONS	BARREL TEMPERATURE	MOULD TEMPERATURE
100 °C x 3 ÷ 4 hours Recommended moisture level after drying ≤0.02%	270 ÷ 300 °C Standard melt temperature: 290 °C	80 ÷ 120 °C
PACKAGING		
25 Kg Bags, 1000 Kg Octabins, 750 Kg Boxes		

PROPERTIES	METHOD		UNIT	TYPICAL VALUES
PHYSICAL				
Density	ASTM D792	ISO 1183	gr/cm³	1.20
Humidity Absorption – (Equilibrium value, in air, 23°C, 50% RH)	INTERNAL METHOD		%	0.12
Mould Shrinkage	INTERNAL METHOD		%	0.5 ÷ 0.7
Melt Flow Index MFI (300 °C -1.2 Kg)	ASTM D1238	ISO 1133	g/10'	30
MECHANICAL				
Tensile strength: stress at yield	ASTM D638	ISO 527-1,-2	MPa	65
strain at break	ASTM D638	ISO 527-1,-2	%	≥ 50
Flexural modulus	ASTM D790	ISO 178	MPa	2400
IZOD notched impact strength, at 23 °C	ASTM D256	-	J/m	500
Specimen dimensions 62.5 mm x 12.7 mm x 3.2 mm				
THERMAL				
VICAT softening temperature at 49 N-120 °C/h	ASTM D1525/B	ISO 306/B	°C	145
Ball pressure test at 125±2 °C	BS 3456	IEC 60695-10-2	°C	Passed
ELECTRICAL				
Surface resistivity	ASTM D257	IEC 60093	Ohm	1E16
Dielectric strenght	ASTM D149	IEC 60243-1	KV/mm	34
Dielectric constant at 10 ⁶ Hz	ASTM D150	IEC 60250	-	3.0
Dissipation factor -10 ⁶ Hz	ASTM D150	IEC 60250	-	0.009
Comparative tracking index (solution A, CTI)	VDE 0303-P1	IEC 60112	V	250
FLAMMABILITY				
Flammability UL94 (thickness 1.6 mm)	UL94		Class	V2
Glow wire flammability GWFI (thickness 2 mm)	IEC 60695-2-12		°C	850
Burning rate FMVSS302 (thickness 2.2/ 3.2 mm)	ISO 3795		mm/min	passed

Our technical data are provided for guidance purpose only for natural color compound and are based on average values. The data are not meant to be used for specification or warranted purposes. Values may be affected by the design of the mold/die, the processing conditions and coloring/pigmentation of the product. Unless specified to the contrary, the data have been established on standardized test specimens at room temperature. All technical information is subject to continuous update, so the customer shall always ensure that the latest release of technical information is at his own disposal. It is the customer's responsibility to inspect and test our products in order to determine to his own satisfaction whether they are suitable for his intended uses and applications or used in conjunction with third-party materials. Unless specifically stated with reference to the specific color code, the products mentioned herein are not suitable for applications in the pharmaceutical, medical, dental and toys sectors, in contact with foodstuff or for potable water transportation.

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