



VYTEEN PCGF10BK

PC 10% Glassfiber Reinforced

Vyteen PCGF10BK is a 10% fiberglass reinforced general purpose Polycarbonate grade.

Features

- Good processability

Typical Applications

- Laptop computer docking
- Laser printer gear
- Toner cartridge

Typical Resin Properties^(a)

Typical Resin Properties ^(a)	ASTM Method	Typical values
Density at 23°C, g/cm ³	D792	1.24
Izod, notched, 23°C, J/m	D256	85
Tensile Strength @ break, (5mm/min), MPa	D638	63
Tensile Modulus, (5mm/min), MPa	D638	3070
Elongation @ Break, (5mm/min), %	D638	11
Flexural Strength, (1.3mm/min), MPa	D790	160
Flexural Modulus (1.3mm/min), MPa	D790	3700
HDT, @ 1.8 Mpa, °C	D648	140
Linear Mold Shrinkage, Flow direction (3.2mmx50mmx76mm), %	D955	0.2 – 0.3
Linear Mold Shrinkage, Transverse direction (3.2mmx50mmx76mm), %	D955	0.4 – 0.6

(a) The property values are based on a limited number of tests and, therefore, should not be construed as product specifications.

PROCESSING GUIDELINES

Drying

The Vyteen PCGF10BK grades process easily but must be thoroughly dried before molding, preferably in a dehumidifying desiccant hopper dryer, operating with an air flow rate of min 1.0 CFM/lb, dew point of -18°C or lower. The material should be dried at 121°C (250° F) for 4 hours and the humidity content of the material should be maintained below 0.02% during molding.

Molding

Vyteen PCGF10BK products have a relatively wide processing window with barrel temperature settings as following:

- Feed zone: 271-293°C (520-559°F)
- Middle zone: 282-304°C (540-579°F)
- Front zone: 293-316°C (550-590°F)
- Nozzle: 288-310°C (550-590°F)
- Melt temperature: 293-316°C (559-601°F)
- Mold temperature: 71-100°C (160-212°F)

Other Molding Parameters

- Injection Pressure: 8000-12000 psi
- Injection Speed: Fast to improve aesthetics and reduce stress
- Back Pressure: Low (25-50 psi)
- Screw Speed: 50-75 rpm



ISO 17025



Conseil canadien des normes
Standards Council of Canada

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