

Technical Data Sheet

Polyflam PC 510GF BLKBLK



Polycarbonate

Product Description

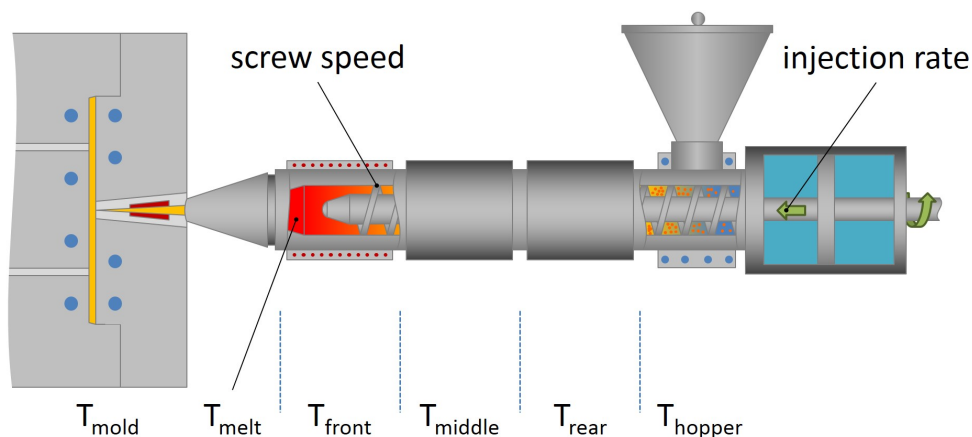
Flame Retardant, 10% Glass Reinforced, Polycarbonate

Regulatory Status

For regulatory compliance information, see *Polyflam* PC 510GF BLKBLK [Product Stewardship Bulletin \(PSB\)](#) and [Safety Data Sheet \(SDS\)](#).

Status	Commercial: Active
Availability	North America
Processing Method	Injection Molding
Additive	Flame Retardant

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (300 °C/2.16 kg)	10	g/10 min	ASTM D1238
Density - Specific Gravity	1.27	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield, (50 mm/min)	55.0	MPa	ASTM D638
Flexural Modulus, (1.3 mm/min)	3100	MPa	ASTM D790
Impact			
Notched Izod Impact	120	J/m	ASTM D256
UL Information			
Flame Rating			
(1.5 mm)	V-0		UL 94
(2.5 mm)	5VA		UL 94
(3.4 mm)	5VA		UL 94



Nominal

Injection Parameters	Nominal Value	Units
Drying Temperature	121	°C
Suggested Max Moisture	<0.020	%
Nozzle Temperature	249 to 288	°C
Screw Speed	40 to 75	rpm
Processing (Melt) Temp	249 to 288	°C
Front Temperature	249 to 288	°C
Middle Temperature	249 to 288	°C
Rear Temperature	249 to 277	°C
Back Pressure	<0.689	MPa
Mold Temperature	71 to 104	°C

Notes

These are typical property values not to be construed as specification limits.

Processing notes

Melt contacting surfaces should be made of a high quality, corrosive resistant steel. Positive experiences have been made with steel qualities containing > 12% chromium.

Avoid processing at very barrel high temperatures or above the recommended melt temperature range as this can increase risk of deposit onto the tool surfaces. Avoid long residence times. At start and end of production, it is recommended to purge clean with non-flame retardant polymer or a polyolefin.

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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