

Polycarbonate Resin **Dupilon**TM

Properties	Test Method	Terms	Units	GMB2010C1
				Chemical Resistant
				GF 10 %
Physical properties				
Density	ISO1183	–	g/cm3	1.20
Poisson's Ratio				0.37
Water absorption		23degC Underwater	%	0.10
Rheological properties				
MVR	ISO1133		cm3/10min	12
		Temperature	°C	280
		Load	kgf	2.16
Moulding shrinkage (2 mmt)	–	MD	%	0.30
		TD		0.40
Mechanical properties				
Tensile modulus	ISO 527-1, 2	–	MPa	4100
Nominal strain at break				4
Stress at 0.2% strain				8
Stress at break				74
Strain at break			%	5
Flexural strength	ISO178	–	MPa	119
Flexural modulus				4000
Charpy impact strength	ISO 179-1, 2	23°C	kJ/m2	NB
Charpy notched impact strength				13
Thermal properties				
Melting point	ISO 11357-3	–	°C	–
Temperature of deflection under load	ISO 75-1, 2	1.80 MPa	°C	125
		0.45 MPa		138
Coefficient of Linear thermal expansion	ISO 11359-2	MD	1/°C	3.6E-05
		TD		7.9E-05
Flammability	UL94		–	–
Typical Processing Conditions				
Predrying Temperature, Time			°C : hour	120 : 3-5
Molding Temperature			°C	260-280
Mold Temperature			°C	60-80
Screw rotation speed			rpm	80-120
Injection Speed				Middle-High
Injection Pressure			MPa	20-150
Back pressure			MPa	10-20

The listed properties are portrayed as general information only and not product specifications.