

PC G1010-F

Physical Properties

Property	Typical Value	Unit	Test Method	Test Condition
Density	1.20-1.21	g/cm ³	ISO 1183-1	23 °C
Melt Mass-Flow Rate (MFR)	10	g/10 min	ISO 1133-1	300 °C, 1.2 kg
Mold Shrinkage	0.5-0.7	%	Internal Method	2 mm thickness
Water Absorption	0.4	%	ISO 62	23 °C, 24 h

Mechanical Properties

Property	Typical Value	Unit	Test Method	Test Condition
Tensile Strength(Yield)	62	MPa	ISO 527-2	50 mm/min
Tensile Strain at Break	113	%	ISO 527-2	50 mm/min
Flexural Strength	94	MPa	ISO 178	2 mm/min
Flexural Modulus	2235	MPa	ISO 178	2 mm/min
Notched Izod Impact Strength	72	kJ/m ²	ISO 180	23 °C

Thermal Properties

Property	Typical Value	Unit	Test Method	Test Condition
Heat Deflection Temperature (HDT)	127	°C	ISO 75-2	1.8 MPa,
Vicat Softening Temperature	148	°C	ISO 306	50 N, 120 °C/h

Optical Properties

Property	Typical Value	Unit	Test Method	Test Condition
Light Transmittance	89.6	%	GB/T 2410	1 mm plaque

Electrical Properties

Property	Typical Value	Unit	Test Method
Volume Resistivity	10 ¹⁴	Ω·cm	IEC 60093
Dielectric Strength	30	kV/mm	IEC 60243-1

Typical Processing Conditions (Reference)

Parameter	Optimum	Range
Melt Temperature	295 °C	280-310 °C
Barrel Temperature-Rear	280 °C	270-290 °C
Barrel Temperature-Center	290 °C	280-300 °C
Barrel Temperature-Front	300 °C	290-310 °C
Mold Temperature	80 °C	70-90 °C

1.This data are provided for general reference only.

2.The typical values listed above are for reference only. During actual processing, process parameters should be adjusted accordingly based on mold design, product geometry, and dimensions.