

Jamplast JPPCGP

Polycarbonate

Jamplast, Inc.

Message:

JPPCGP series resins are general purpose PC that exhibit an excellent physical property balance of heat resistance, and impact strength. This product can be supplied with a mold release packaga, a UV stabilizer package or both.

This product is typically used for appliances, storage media housings, extruded sheet, electrical components and lighting.

Available Melt Flow Rates:
4, 6, 10, 15

General Information	
Forms	Pellets
Processing Method	Coextrusion
	Extrusion Blow Molding
	Film Extrusion
	Injection Blow Molding
	Injection Molding
	Profile Extrusion
	Sheet Extrusion
	Thermoforming

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2300	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	60.0	MPa	
Break	72.4	MPa	
Tensile Elongation ³			ASTM D638
Yield	6.0	%	
Break	150	%	
Flexural Modulus ⁴	2410	MPa	ASTM D790
Flexural Strength ⁵	96.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	910	J/m	ASTM D256
Unnotched Izod Impact (23°C)	No Break		ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Annealed	142	°C	

1.8 MPa, Unannealed	122	°C	
1.8 MPa, Annealed	139	°C	
Vicat Softening Temperature	148	°C	ASTM D1525
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.60 mm	V-2		
3.20 mm	V-2		
Optical	Nominal Value	Unit	Test Method
Transmittance	87.0 to 91.0	%	ASTM D1003
Haze	0.70 to 1.5	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	271 to 288	°C	
Middle Temperature	277 to 299	°C	
Front Temperature	299 to 327	°C	
Nozzle Temperature	299 to 327	°C	
Processing (Melt) Temp	299 to 327	°C	
Mold Temperature	76.7 to 110	°C	
Screw Speed	40 to 70	rpm	
Clamp Tonnage	2.8 to 6.9	kN/cm ²	
Screw L/D Ratio	15.0:1.0		
Screw Compression Ratio	1.5:1.0 to 3.0:1.0		
NOTE			
1.	Type I, 51 mm/min		
2.	Type I, 51 mm/min		
3.	Type I, 51 mm/min		
4.	Type I, 1.3 mm/min		
5.	Type I, 1.3 mm/min		

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