

Generic PC - Proprietary

Polycarbonate

Generic

Message:

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General Information			
Filler / Reinforcement		Proprietary packing	
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.21 - 1.34	g/cm ³	ASTM D792
23°C	1.22 - 1.33	g/cm ³	ISO 1183
Molding Shrinkage			
Flow: 23°C	0.29 - 0.91	%	ASTM D955
Transverse flow: 23°C	0.60 - 0.73	%	ASTM D955
23°C	0.40 - 0.75	%	ISO 294-4
Water Absorption			
23°C, 24 hr	0.090 - 0.16	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.12 - 0.25	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
23°C	1860 - 2970	MPa	ASTM D638
23°C	2100 - 6470	MPa	ISO 527-2
Tensile Strength			
Yield, 23°C	47.0 - 65.8	MPa	ASTM D638
Yield, 23°C	49.2 - 62.6	MPa	ISO 527-2
Fracture, 23°C	44.7 - 91.0	MPa	ASTM D638
Fracture, 23°C	43.0 - 90.7	MPa	ISO 527-2
Tensile Elongation			
Yield, 23°C	1.9 - 6.9	%	ASTM D638
Yield, 23°C	1.5 - 6.9	%	ISO 527-2
Fracture, 23°C	1.4 - 21	%	ASTM D638
Fracture, 23°C	1.5 - 23	%	ISO 527-2
Flexural Modulus			
23°C	2040 - 3050	MPa	ASTM D790
23°C	2080 - 5240	MPa	ISO 178
Flexural Strength			
23°C	86.2 - 145	MPa	ASTM D790
23°C	76.1 - 137	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	43 - 160	J/m	ASTM D256
23°C	5.1 - 12	kJ/m ²	ISO 180
Unnotched Izod Impact			
23°C	340 - 2300	J/m	ASTM D256
23°C	20 - 180	kJ/m ²	ISO 180
Instrumented Dart Impact			
23°C	2.96 - 45.3	J	ASTM D3763
23°C	2.04 - 128	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	134 - 144	°C	ASTM D648
0.45 MPa, not annealed	114 - 152	°C	ISO 75-2/B
1.8 MPa, not annealed	122 - 144	°C	ASTM D648
1.8 MPa, not annealed	125 - 142	°C	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	4.0 - 1.3E+7	ohms	ASTM D257
Volume Resistivity (23°C)	5.1E+3 - 6.9E+6	ohms·cm	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Rear Temperature	298 - 299	°C	
Middle Temperature	315 - 316	°C	
Front Temperature	326 - 327	°C	
Processing (Melt) Temp	315 - 316	°C	
Mold Temperature	96.0 - 96.6	°C	
Back Pressure	0.258 - 0.265	MPa	
Screw Speed	45	rpm	
Injection instructions			

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