

PC-COM™ PC422

Polycarbonate
Polymer Compounders Limited

Message:
PC-COM PC422 is a high flow general purpose polycarbonate grade. Applications include automotive interior covers and lighting.

General Information			
Features	General Purpose		
	High Flow		
Uses	Automotive Interior Parts		
	General Purpose		
	Lighting Applications		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	22	g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.70	%	ISO 294-4
Water Absorption			ISO 62
Saturation, 23°C	0.15	%	
Equilibrium, 23°C, 50% RH	0.35	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2350	MPa	ISO 527-2/1
Tensile Stress (Yield)	63.0	MPa	ISO 527-2/50
Tensile Strain			
Yield	6.0	%	ISO 527-2/50
Break	120	%	ISO 527-2
Flexural Stress	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	8.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	No Break		ISO 179/1eU
Notched Izod Impact Strength (23°C)	8.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	136	°C	ISO 75-2/Be
1.8 MPa, Unannealed	124	°C	ISO 75-2/Ae
Vicat Softening Temperature	144	°C	ISO 306/B50
CLTE - Flow	7.0E-5	cm/cm/°C	ISO 11359-2

Flammability	Nominal Value	Test Method
Flame Rating		UL 94
0.800 mm	HB	
1.50 mm	V-2	
Injection	Nominal Value	Unit
Drying Temperature	110	°C
Drying Time	2.0 to 4.0	hr
Processing (Melt) Temp	280	°C
Mold Temperature	90.0	°C
Injection Velocity	60	mm/sec

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