

PRL PC/TP-GP1

Polycarbonate + Polyester

Polymer Resources Ltd.

Message:

PRL PC/TP-GP1 is a Polycarbonate + Polyester (PC+Polyester) product. It can be processed by injection molding and is available in North America. Characteristics include:
RoHS Compliant
Impact Resistant
Chemical Resistant
Impact Modified

General Information			
Additive	Impact Modifier		
Features	General Purpose		
	Good Chemical Resistance		
	Impact Modified		
	Low Temperature Impact Resistance		
	Ultra High Impact Resistance		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	5.0 to 15	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.50 to 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield, 3.18 mm	55.2	MPa	
Break, 3.18 mm	54.5	MPa	
Tensile Elongation (Break, 3.18 mm)	120	%	ASTM D638
Flexural Modulus (3.18 mm)	2170	MPa	ASTM D790
Flexural Strength (3.18 mm)	86.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	800	J/m	ASTM D256
Gardner Impact (3.18 mm)	> 36.2	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.18 mm	121	°C	

1.8 MPa, Unannealed, 3.18 mm	110	°C
Injection	Nominal Value	Unit
Drying Temperature	104 to 110	°C
Drying Time	4.0 to 6.0	hr
Drying Time, Maximum	8.0	hr
Rear Temperature	249 to 271	°C
Middle Temperature	254 to 277	°C
Front Temperature	260 to 282	°C
Processing (Melt) Temp	246 to 274	°C
Mold Temperature	65.6 to 87.8	°C

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