

Integra™ PC-5017 U

Polycarbonate

PolySource, LLC

Message:

Polycarbonate, ultra low viscosity, UV

General Information			
Features	Ultra Low Viscosity		
	Good UV resistance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	34	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.50 - 0.70	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.15	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	66.0	MPa	ASTM D638
Tensile Elongation (Break)	130	%	ASTM D638
Flexural Modulus	2250	MPa	ASTM D790
Flexural Strength (Yield)	93.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	750	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	130	°C	ASTM D648
CLTE - Flow	5.0E-5 - 7.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	4.0E+16	ohms · cm	ASTM D257
Dielectric Strength	30	kV/mm	ASTM D149
Arc Resistance	120	sec	ASTM D495
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.6 mm)	V-2		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	3.0 - 5.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	235 - 260	°C	
Middle Temperature	250 - 275	°C	
Front Temperature	265 - 290	°C	

Nozzle Temperature	265 - 300	°C
Processing (Melt) Temp	265 - 300	°C
Mold Temperature	65 - 105	°C
Back Pressure	0.250 - 0.703	MPa
Screw Speed	40 - 70	rpm
Vent Depth	0.020 - 0.079	mm

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