

PRL PC-GP4-(color)-1

Polycarbonate
Polymer Resources Ltd.

Message:

PRL PC-GP4-(color)-1 is a Polycarbonate (PC) product. It can be processed by injection molding and is available in North America.

Characteristics include:

- Flame Rated
- RoHS Compliant
- Good Mold Release
- Mold Release Agent

General Information			
UL YellowCard	E113219-219246		
Additive	Mold Release		
Features	General Purpose		
	Good Flow		
	Good Mold Release		
RoHS Compliance	RoHS Compliant		
UL File Number	E113219		
Forms	Pellets		
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)	18 to 30	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.50 to 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			ASTM D785
M-Scale	70		
R-Scale	118		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield, 3.18 mm	62.1	MPa	
Break, 3.18 mm	65.5	MPa	
Tensile Elongation			ASTM D638
Yield, 3.18 mm	6.0	%	
Break, 3.18 mm	120	%	
Flexural Modulus (3.18 mm)	2280	MPa	ASTM D790
Flexural Strength (3.18 mm)	92.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	640	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	129	°C	
1.8 MPa, Unannealed, 3.18 mm	124	°C	
Vicat Softening Temperature	141	°C	ASTM D1525 ¹
RTI Elec			UL 746
1.70 mm	80.0	°C	
3.00 mm	80.0	°C	
RTI Imp			UL 746
1.70 mm	80.0	°C	
3.00 mm	80.0	°C	
RTI Str			UL 746
1.70 mm	80.0	°C	
3.00 mm	80.0	°C	
Electrical	Nominal Value		Test Method
Comparative Tracking Index (CTI) (1.70 mm)	PLC 2		UL 746
High Amp Arc Ignition (HAI)			UL 746
1.70 mm	PLC 0		
3.00 mm	PLC 0		
Hot-wire Ignition (HWI)			UL 746
1.70 mm	PLC 1		
3.00 mm	PLC 0		
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.70 mm	V-2		
3.00 mm	V-2		
Optical	Nominal Value	Unit	Test Method
Transmittance (2540 µm)	88.0	%	ASTM D1003
Haze (2540 µm)	1.0	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	118 to 124	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Rear Temperature	249 to 271	°C	
Middle Temperature	260 to 282	°C	
Front Temperature	271 to 293	°C	
Processing (Melt) Temp	266 to 293	°C	
Mold Temperature	65.6 to 93.3	°C	
NOTE			

1. Rate B (120°C/h), Loading 2 (50 N)

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