

GLS PC MN06

Polycarbonate
GLS Polymers Pvt. Ltd.

Message:
PC FR V0 Precolor

General Information			
Appearance	Colors Available		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.11 to 1.31	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	> 10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.60 to 0.95	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	> 2000	MPa	ASTM D638
Tensile Strength ¹ (Yield)	> 58.0	MPa	ASTM D638
Flexural Modulus	> 2000	MPa	ASTM D790
Flexural Strength	> 80.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	> 600	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	> 127	°C	ASTM D648
Flammability	Nominal Value	Test Method	
Flame Rating (3.00 mm)	V-0	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0	hr	
Processing (Melt) Temp	265 to 290	°C	
Mold Temperature	85.0 to 120	°C	
Injection Pressure	68.0 to 104	MPa	
NOTE			
1.	50 mm/min		

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