Clariant PC PC-1100TF15

Polycarbonate

Clariant Corporation

Message:

Clariant PC PC-1100TF15 is a polycarbonate (PC) material. This product is available in North America and is processed by injection molding.
The main features of Clariant PC PC-1100TF15 are:
flame retardant/rated flame
high strength
Good processability
Hard
Corrosion resistance
Typical application areas include:
engineering/industrial accessories
military applications
Sporting goods

General Information	
UL YellowCard	E103015-538377
Additive	PTFE lubricant (15%)
Features	Good dimensional stability Low friction coefficient Rigidity, high Rigid, good High strength Workability, good Good corrosion resistance Good coloring Good chemical resistance Good wear resistance Good toughness Lubrication Low or no water absorption
Uses	Gear Metal substitution Military application Sporting goods Cam
Appearance	Available colors Natural color
Forms	Particle

Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.28	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.60	%	ASTM D955
Water Absorption			ASTM D570
24 hr	0.12	%	ASTM D570
Saturation	0.26	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (M-Scale)	74		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength	48.3	MPa	ASTM D638
Tensile Elongation (Break)	6.0	%	ASTM D638
Flexural Modulus	2070	MPa	ASTM D790
Flexural Strength	68.9	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (3.18 mm)	130	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	138	°C	ASTM D648
1.8 MPa, not annealed	135	°C	ASTM D648
CLTE - Flow	7.2E-5	cm/cm/°C	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Dielectric Strength	18	kV/mm	ASTM D149
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating	V-1		UL 94
Injection	**Nominal Value**	**Unit**	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	304 - 343	°C	
Middle Temperature	304 - 343	°C	
Front Temperature	304 - 343	°C	
Processing (Melt) Temp	304 - 327	°C	
Melt Temperature (Aim)	316	°C	
Mold Temperature	82.2 - 121	°C	
Injection Rate	Fast		
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	45 - 75	rpm	
Cushion	3.18 - 6.35	mm	
Injection instructions			

The minimum injection pressure required to fill the part should be used for the first stage. The hold pressure should be set between 50% and 75% of the injection pressure.

Recommended distributors for this material

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