

Diamond PC 1212 FR0 Black 1819

Polycarbonate

Network Polymers, Inc.

Message:

Diamond PC 1212 FR0 is a Polycarbonate (PC) product. It is available in North America.

Characteristics include:

Flame Rated

Flame Retardant

General Information			
UL YellowCard	E51193-101898833	E51193-101898834	
Additive	Flame Retardant		
Features	Flame Retardant		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (300°C/1.2 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield, Injection Molded ²	62.1	MPa	
Break, Injection Molded	59.3	MPa	
Flexural Modulus ³	2280	MPa	ASTM D790B
Flexural Strength ⁴ (Yield)	90.3	MPa	ASTM D790B
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	640	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.18 mm	137	°C	
1.8 MPa, Unannealed, 3.18 mm	132	°C	
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm	V-0		
3.00 mm	5VA		
Injection	Nominal Value	Unit	
Drying Temperature - Desiccant Dryer	104 to 116	°C	
Drying Time - Desiccant Dryer	2.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	249 to 282	°C	
Rear Temperature	260 to 293	°C	
Middle Temperature	260 to 293	°C	

Front Temperature	260 to 293	°C
Nozzle Temperature	260 to 293	°C
Mold Temperature	71.1 to 104	°C
Injection Pressure	82.7 to 103	MPa

NOTE		
1.	Procedure A	
2.	51 mm/min	
3.	Method I (3 point load), 1.3 mm/min	
4.	Method I (3 point load), 1.3 mm/min	

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