

PRL PC-HM-FR1

Polycarbonate
Polymer Resources Ltd.

Message:

PRL PC-HM-FR1 is a Polycarbonate (PC) product filled with 10% glass fiber. It can be processed by injection molding and is available in North America. Characteristics include:
Flame Rated
RoHS Compliant
Flame Retardant
Heat Resistant
Impact Resistant

General Information			
UL YellowCard	E113219-219247		
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Additive	Flame Retardant		
Features	Flame Retardant		
	Good Impact Resistance		
	High Heat Resistance		
	Self Extinguishing		
RoHS Compliance	RoHS Compliant		
UL File Number	E113219		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.26	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	5.0 to 12	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow : 3.18 mm	0.20 to 0.50	%	
Across Flow : 3.18 mm	0.20 to 0.50	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			ASTM D785
M-Scale	85		
R-Scale	124		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield, 3.18 mm	65.5	MPa	
Break, 3.18 mm	55.8	MPa	
Tensile Elongation			ASTM D638
Yield, 3.18 mm	6.0	%	
Break, 3.18 mm	15	%	

Flexural Modulus (3.18 mm)	3380	MPa	ASTM D790
Flexural Strength (3.18 mm)	103	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.18 mm	143	°C	
1.8 MPa, Unannealed, 3.18 mm	138	°C	
Vicat Softening Temperature	152	°C	ASTM D1525 ¹
RTI Elec			UL 746
1.50 mm	80.0	°C	
3.00 mm	80.0	°C	
RTI Imp			UL 746
1.50 mm	80.0	°C	
3.00 mm	80.0	°C	
RTI Str			UL 746
1.50 mm	80.0	°C	
3.00 mm	80.0	°C	
Electrical	Nominal Value		Test Method
Comparative Tracking Index (CTI) (1.50 mm)	PLC 3		UL 746
High Amp Arc Ignition (HAI)			UL 746
1.50 mm	PLC 1		
3.00 mm	PLC 1		
Hot-wire Ignition (HWI)			UL 746
1.50 mm	PLC 2		
3.00 mm	PLC 1		
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.50 mm, ALL	V-0		
	V-0		
3.00 mm, ALL	5VA		
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	293 to 316	°C	
Middle Temperature	304 to 327	°C	
Front Temperature	316 to 338	°C	
Processing (Melt) Temp	302 to 329	°C	

Mold Temperature	82.2 to 116	°C
NOTE		

1.	Rate B (120°C/h), Loading 2 (50 N)
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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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