

Integra™ PC 5020 F1 CL-0001

Polycarbonate
PolySource, LLC

Message:
PC, High Flow, Mold Release, UV-Stablized, Clear

General Information			
Additive	UV stabilizer		
Features	UV Stabilized		
	High liquidity		
	Good demoulding performance		
Appearance	Clear/transparent		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.70	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2370	MPa	ASTM D638
Tensile Strength			ASTM D638
Yield	62.1	MPa	ASTM D638
Fracture	65.5	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	6.0	%	ASTM D638
Fracture	110	%	ASTM D638
Flexural Modulus (50.0 mm Span)	2310	MPa	ASTM D790
Flexural Strength (Yield, 50.0 mm Span)	93.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	640	J/m	ASTM D256
Instrumented Dart Impact (23°C, Peak Load)	54.2	J	ASTM D3763
Tensile Impact Strength	378	kJ/m ²	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	127	°C	ASTM D648
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	120	°C	

Drying Time	3.0 - 5.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	235 - 260	°C
Middle Temperature	250 - 275	°C
Front Temperature	265 - 290	°C
Nozzle Temperature	265 - 300	°C
Processing (Melt) Temp	265 - 300	°C
Mold Temperature	65 - 105	°C
Back Pressure	0.250 - 0.703	MPa
Screw Speed	40 - 70	rpm

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