

PC-COM™ PC415

Polycarbonate

Polymer Compounders Limited

Message:

PC-COM PC415 is a medium flow general purpose polycarbonate grade with external GWT approval. Applications include electrical enclosures and lighting.

General Information			
Features	General Purpose		
	Medium Flow		
Uses	Electrical/Electronic Applications		
	General Purpose		
	Lighting Applications		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	15	g/10 min	ISO 1133
Molding Shrinkage	0.40 to 0.70	%	ISO 294-4
Water Absorption			ISO 62
Saturation, 23°C	0.15	%	
Equilibrium, 23°C, 50% RH	0.35	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2350	MPa	ISO 527-2/1
Tensile Stress (Yield)	63.0	MPa	ISO 527-2/50
Tensile Strain			
Yield	6.0	%	ISO 527-2/50
Break	120	%	ISO 527-2
Flexural Stress	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	25	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	No Break		ISO 179/1eU
Notched Izod Impact Strength (23°C)	25	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	136	°C	ISO 75-2/Be
1.8 MPa, Unannealed	124	°C	ISO 75-2/Ae
Vicat Softening Temperature	144	°C	ISO 306/B50

CLTE - Flow	7.0E-5	cm/cm/°C	ISO 11359-2
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.800 mm	HB		
1.50 mm	V-2		
Glow Wire Flammability Index	850	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	2.0 to 4.0	hr	
Processing (Melt) Temp	280	°C	
Mold Temperature	90.0	°C	
Injection Velocity	65	mm/sec	

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