

Clariant PC PC-000-L

Polycarbonate
Clariant Corporation

Message:

Clariant PC PC-000-L is a Polycarbonate (PC) material. It is available in North America for injection molding.
Important attributes of Clariant PC PC-000-L are:
Good Mold Release
Lubricated

General Information			
UL YellowCard	E103015-218200		
Additive	Lubricant		
Features	General Purpose		
	Good Mold Release		
	Lubricated		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm³	ASTM D792
Molding Shrinkage - Flow	0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	60.7	MPa	ASTM D638
Tensile Elongation (Break)	100	%	ASTM D638
Flexural Modulus	2070	MPa	ASTM D790
Flexural Strength	89.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	690	J/m	ASTM D256
Tensile Impact Strength	No Break		ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	132	°C	
1.8 MPa, Unannealed	127	°C	
Melting Temperature	252	°C	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Regrind	20	%	
Rear Temperature	266 to 277	°C	
Middle Temperature	271 to 282	°C	
Front Temperature	282 to 299	°C	

Nozzle Temperature	277 to 304	°C
Processing (Melt) Temp	282 to 293	°C
Mold Temperature	71.1 to 93.3	°C
Injection Pressure	82.7 to 124	MPa
Back Pressure	0.345 to 1.03	MPa
Screw Speed	40 to 70	rpm

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Recommended distributors for this material

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