

Integra™ PC-5025 R 0002

Polycarbonate
PolySource, LLC

Message:
PC, Medium Flow, FDA, Mold Release, Blue Tint

General Information			
Features	Medium liquidity		
	Good demoulding performance		
Agency Ratings	FDA not rated		
Appearance	Blue		
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)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.50 - 0.70	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	0.35	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2410	MPa	ASTM D638
Tensile Strength			ASTM D638
Yield	61.4	MPa	ASTM D638
Fracture	68.3	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	7.0	%	ASTM D638
Fracture	130	%	ASTM D638
Flexural Modulus ¹ (50.8mm span)	2340	MPa	ASTM D790
Flexural Strength ² (Yield, 50.8 mm Span)	97.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	800	J/m	ASTM D3763
Unnotched Izod Impact (23°C)	3200	J/m	ASTM D256
Tensile Impact Strength ³	578	kJ/m ²	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.35mm	138	°C	ASTM D648
1.8 MPa, unannealed, 6.35mm	132	°C	ASTM D648
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 38°C	6.8E-5	cm/cm/°C	ASTM E831
Horizontal: -40 to 38°C	6.6E-5	cm/cm/°C	ASTM E831
Injection	Nominal Value	Unit	

Drying Temperature	121	°C
Drying Time	3.0 - 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	271 - 293	°C
Middle Temperature	282 - 304	°C
Front Temperature	293 - 316	°C
Nozzle Temperature	288 - 310	°C
Processing (Melt) Temp	293 - 316	°C
Mold Temperature	71 - 93	°C
Back Pressure	0.345 - 0.689	MPa
Screw Speed	40 - 70	rpm

NOTE

1. 1.3 mm/min
2. 1.3 mm/min
3. Type S

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