

Hylex® P1302B

Polycarbonate

Entec Polymers

Message:

Hylex® P1302B is a polycarbonate (PC) material. This product is available in North America and is processed by blow molding or extrusion.

Hylex® The main features of P1302B are:

ROHS certification

UV stability

General Information			
Additive	UV stabilizer		
RoHS Compliance	RoHS compliance		
Forms	Particle		
Processing Method	Blow molding		
	Extrusion		

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)	2.3	g/10 min	ASTM D1238
Water Absorption (24 hr)	0.15	%	ASTM D570

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale, 3.18 mm)	122		ASTM D785

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break, 23°C, 3.18 mm)	68.9	MPa	ASTM D638
Tensile Elongation (Break, 23°C, 3.18 mm)	100	%	ASTM D638
Flexural Modulus (23°C, 3.18 mm)	2070	MPa	ASTM D790
Flexural Strength (23°C, 3.18 mm)	88.3	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	830	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.18mm	138	°C	ASTM D648
1.8 MPa, unannealed, 3.18mm	132	°C	ASTM D648
Glass Transition Temperature	152	°C	ASTM E1356

Optical	Nominal Value	Unit	Test Method
Refractive Index	1.585		ASTM D542
Transmittance (3180 µm)	78.0	%	ASTM D1003

Extrusion	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 - 6.0	hr	
Suggested Max Moisture	0.020	%	

Cylinder Zone 1 Temp.	229 - 249	°C
Cylinder Zone 2 Temp.	241 - 260	°C
Cylinder Zone 3 Temp.	249 - 271	°C
Cylinder Zone 4 Temp.	249 - 271	°C
Adapter Temperature	246 - 266	°C
Die Temperature	254 - 277	°C

Extrusion instructions

Extrusion Blow Molding Temperatures:
Head Temperature Zone 1: 490 - 530°F
Head Temperature Zone 1: 480 - 520°F
Mold Temperature: 230 - 265°F
Screw Speed: 20 - 40 rpm

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