

PTS PCA-3015

Polycarbonate + PBT

Polymer Technology and Services, LLC

Message:

PTS PCA-3015 is a Polycarbonate + PBT (PC+PBT) product. It can be processed by injection molding and is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America. Primary characteristic: impact resistant.

General Information			
Features	Low Temperature Impact Resistance		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	2.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.75	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.030	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 3.17 mm)	51.0	MPa	ASTM D638
Tensile Elongation (Break, 3.17 mm)	150	%	ASTM D638
Flexural Modulus (3.17 mm)	1860	MPa	ASTM D790
Flexural Strength (Yield, 3.17 mm)	85.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.17 mm)	800	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	116	°C	
1.8 MPa, Unannealed	96.0	°C	
Injection	Nominal Value	Unit	
Drying Temperature	110	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Shot Size	50 to 80	%	
Rear Temperature	232 to 243	°C	
Middle Temperature	238 to 254	°C	
Front Temperature	246 to 268	°C	
Nozzle Temperature	246 to 266	°C	
Processing (Melt) Temp	243 to 279	°C	
Mold Temperature	65.6 to 82.2	°C	
Back Pressure	0.00 to 3.45	MPa	
Screw Speed	20 to 60	rpm	

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