

Generic PC+PET

Polycarbonate + PET

Generic

Message:

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General Information			
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.20 - 1.22	g/cm³	ASTM D792
23°C	1.20 - 1.34	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (265°C/5.0 kg)	12 - 30	g/10 min	ASTM D1238
Molding Shrinkage			
Flow: 23°C	0.60 - 0.90	%	ASTM D955
23°C	0.40 - 0.80	%	ISO 294-4
Water Absorption			
23°C, 24 hr	0.098 - 0.19	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.080 - 0.35	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (23°C)	110 - 119		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
23°C	1700 - 4600	MPa	ASTM D638
23°C	1950 - 4310	MPa	ISO 527-2
Tensile Strength			
Yield, 23°C	46.5 - 65.0	MPa	ASTM D638
Yield, 23°C	49.4 - 67.5	MPa	ISO 527-2
Fracture, 23°C	44.7 - 60.5	MPa	ASTM D638
Fracture, 23°C	44.2 - 55.4	MPa	ISO 527-2
23°C	53.9 - 59.8	MPa	ASTM D638
Tensile Elongation			
Yield, 23°C	3.3 - 8.1	%	ASTM D638
Yield, 23°C	3.6 - 5.0	%	ISO 527-2
Fracture, 23°C	56 - 150	%	ASTM D638
Fracture, 23°C	3.0 - 110	%	ISO 527-2
Flexural Modulus			
23°C	1890 - 2540	MPa	ASTM D790
23°C	2110 - 4000	MPa	ISO 178
Flexural Strength			

23°C	66.5 - 91.6	MPa	ASTM D790
23°C	65.0 - 98.0	MPa	ISO 178
Yield, 23°C	86.0 - 104	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.0 - 56	kJ/m ²	ISO 179
Notched Izod Impact			
23°C	90 - 930	J/m	ASTM D256
23°C	8.6 - 51	kJ/m ²	ISO 180
Instrumented Dart Impact (23°C)	5.12 - 60.4	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	126 - 137	°C	ASTM D648
0.45 MPa, not annealed	120 - 132	°C	ISO 75-2/B
1.8 MPa, not annealed	73.9 - 131	°C	ASTM D648
1.8 MPa, not annealed	94.5 - 120	°C	ISO 75-2/A
Vicat Softening Temperature			
--	137 - 155	°C	ASTM D1525
--	128 - 145	°C	ISO 306
Injection	Nominal Value	Unit	
Drying Temperature	104 - 121	°C	
Drying Time	2.9 - 5.1	hr	
Suggested Max Moisture	0.019 - 0.020	%	
Suggested Shot Size	60 - 65	%	
Rear Temperature	235 - 262	°C	
Middle Temperature	254 - 267	°C	
Front Temperature	254 - 280	°C	
Nozzle Temperature	260 - 271	°C	
Processing (Melt) Temp	255 - 281	°C	
Mold Temperature	69.7 - 80.8	°C	
Back Pressure	0.259 - 1.50	MPa	
Screw Speed	36 - 80	rpm	
Injection instructions			

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