

Diamond PC 1229M

Polycarbonate

Network Polymers, Inc.

Message:

Diamond PC 1229M is a Polycarbonate (PC) product. It can be processed by injection molding and is available in North America. Typical application: Medical/Healthcare.

Characteristics include:

RoHS Compliant

WEEE Compliant

Sterilizable

Biocompatible

Good Mold Release

General Information			
Features	Biocompatible Ethylene Oxide Sterilizable Good Mold Release Low Viscosity Steam Sterilizable		
Uses	Medical/Healthcare Applications		
Agency Ratings	EU 2000/53/EC EU 2002/96/EC (WEEE) EU 2003/11/EC ISO 10993-Part 1		
RoHS Compliance	RoHS Compliant		
Appearance	Clear/Transparent Colors Available Opaque		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.19	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) ¹ (300°C/1.2 kg)	23	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ² (23°C, Injection Molded)	2240	MPa	ASTM D638
Tensile Strength ³ (Yield, 23°C, Injection Molded)	63.8	MPa	ASTM D638
Tensile Elongation ⁴			ASTM D638
Yield, 23°C, Injection Molded	6.1	%	
Break, 23°C, Injection Molded	190	%	

Flexural Modulus (23°C, Injection Molded)	2190	MPa	ASTM D790A
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, Injection Molded)	750	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	125	°C	ASTM D648
Vicat Softening Temperature	143	°C	ASTM D1525
Optical	Nominal Value	Unit	Test Method
Transmittance	89.0	%	ASTM D1003
Haze	< 0.80	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Drying Time, Maximum	6.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	229 to 257	°C	
Middle Temperature	266 to 288	°C	
Front Temperature	277 to 299	°C	
Nozzle Temperature	266 to 277	°C	
Processing (Melt) Temp	280 to 320	°C	
Mold Temperature	65.6 to 104	°C	
Injection Pressure	68.9 to 138	MPa	
Injection Rate	Moderate-Fast		

NOTE

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|----|-------------|
| 1. | Procedure A |
| 2. | 51 mm/min |
| 3. | 51 mm/min |
| 4. | 51 mm/min |

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