

PRL PC-FD3-(color)-1

Polycarbonate
Polymer Resources Ltd.

Message:

PRL PC-FD3-(color)-1 is a Polycarbonate (PC) product. It can be processed by injection molding and is available in North America. Typical application: Food Contact Applications.

Characteristics include:

- RoHS Compliant
- Good Mold Release
- High Flow
- Mold Release Agent

General Information			
Additive	Mold Release		
Features	Good Mold Release		
	High Flow		
Agency Ratings	FDA Food Contact, Unspecified Rating		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	14 to 20	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow : 3.18 mm	0.50 to 0.70	%	
Across Flow : 3.18 mm	0.50 to 0.70	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			ASTM D785
M-Scale	70		
R-Scale	118		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield, 3.18 mm	62.1	MPa	
Break, 3.18 mm	68.9	MPa	
Tensile Elongation			ASTM D638
Yield, 3.18 mm	6.0	%	
Break, 3.18 mm	120	%	
Flexural Modulus (3.18 mm)	2310	MPa	ASTM D790
Flexural Strength (3.18 mm)	95.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	690	J/m	ASTM D256

Gardner Impact (3.18 mm)	> 36.2	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.18 mm	132	°C	
1.8 MPa, Unannealed, 3.18 mm	127	°C	
Vicat Softening Temperature	149	°C	ASTM D1525 ¹
Optical	Nominal Value	Unit	Test Method
Transmittance (2540 μm)	88.0	%	ASTM D1003
Haze (2540 μm)	1.0	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	118 to 124	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Rear Temperature	260 to 282	°C	
Middle Temperature	271 to 293	°C	
Front Temperature	282 to 304	°C	
Processing (Melt) Temp	288 to 316	°C	
Mold Temperature	71.1 to 93.3	°C	
NOTE			

1. Rate B (120°C/h), Loading 2 (50 N)

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