

PRL PC-IM1

Polycarbonate

Polymer Resources Ltd.

Message:

PRL PC-IM1 is a Polycarbonate (PC) product. It can be processed by injection molding and is available in North America.

Characteristics include:

RoHS Compliant

Impact Resistant

Impact Modified

General Information			
Additive	Impact Modifier		
Features	Impact Modified		
	Low Flow		
	Low Temperature Impact Resistance		
	Ultra High Impact Resistance		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	5.0 to 10	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	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield, 3.18 mm	55.2	MPa	
Break, 3.18 mm	60.0	MPa	
Tensile Elongation			ASTM D638
Yield, 3.18 mm	6.0	%	
Break, 3.18 mm	100	%	
Flexural Modulus (3.18 mm)	2000	MPa	ASTM D790
Flexural Strength (3.18 mm)	79.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 3.18 mm	530	J/m	
23°C, 3.18 mm	910	J/m	
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	135	°C	
1.8 MPa, Unannealed, 3.18 mm	124	°C	
Vicat Softening Temperature	141	°C	ASTM D1525 ¹
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	271 to 293	°C	
Middle Temperature	282 to 304	°C	
Front Temperature	293 to 316	°C	
Processing (Melt) Temp	282 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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