

PRL PC-G20-(color)-1

Polycarbonate

Polymer Resources Ltd.

Message:

PRL PC-G20-(color)-1 is a Polycarbonate (PC) product filled with 20% glass fiber. It can be processed by injection molding and is available in North America.

Characteristics include:

Flame Rated

RoHS Compliant

Good Mold Release

Mold Release Agent

General Information			
UL YellowCard	E113219-219243		
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	Mold Release		
Features	Good Mold Release		
RoHS Compliance	RoHS Compliant		
UL File Number	E113219		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.35	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	4.0 to 10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.10 to 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Yield, 3.18 mm	117	MPa	
Break, 3.18 mm	117	MPa	
Flexural Modulus (3.18 mm)	5170	MPa	ASTM D790
Flexural Strength (3.18 mm)	124	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	80	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.18 mm	149	°C	
1.8 MPa, Unannealed, 3.18 mm	141	°C	
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.70 mm	V-2		
3.00 mm	V-0		
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	293 to 316	°C
Middle Temperature	304 to 327	°C
Front Temperature	316 to 338	°C
Processing (Melt) Temp	302 to 329	°C
Mold Temperature	82.2 to 116	°C

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