

PRL PC-GP1-(color)-LF

Polycarbonate
Polymer Resources Ltd.

Message:

PRL PC-GP1-(color)-LF 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

Food Contact Acceptable

General Information			
Features	Food Contact Acceptable		
	General Purpose		
	Low 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)	3.0 to 4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.50 to 0.70	%	ASTM D955
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	72.4	MPa	
Tensile Elongation			ASTM D638
Yield, 3.18 mm	7.0	%	
Break, 3.18 mm	140	%	
Flexural Modulus (3.18 mm)	2410	MPa	ASTM D790
Flexural Strength (3.18 mm)	96.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	960	J/m	ASTM D256
Gardner Impact	> 36.2	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648

0.45 MPa, Unannealed	141	°C	
1.8 MPa, Unannealed	135	°C	
Vicat Softening Temperature	154	°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	293 to 316	°C	
Middle Temperature	304 to 327	°C	
Front Temperature	316 to 338	°C	
Processing (Melt) Temp	316 to 343	°C	
Mold Temperature	82.2 to 116	°C	
NOTE			

1. Rate B (120°C/h), Loading 2 (50 N)

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