

PRL PC-FD4

Polycarbonate
Polymer Resources Ltd.

Message:

PRL PC-FD4 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
- Heat Resistant
- High Flow
- Impact Resistant

General Information			
Features	Food Contact Acceptable		
	General Purpose		
	High Flow		
	High Impact Resistance		
	Medium Heat Resistance		
Agency Ratings	FDA Unspecified Rating		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	18 to 30	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	65.5	MPa	
Tensile Elongation			ASTM D638
Yield, 3.18 mm	6.0	%	
Break, 3.18 mm	120	%	
Flexural Modulus (3.18 mm)	2280	MPa	ASTM D790

Flexural Strength (3.18 mm)	92.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	640	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	129	°C	
1.8 MPa, Unannealed, 3.18 mm	124	°C	
Vicat Softening Temperature	141	°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	249 to 271	°C	
Middle Temperature	260 to 282	°C	
Front Temperature	271 to 293	°C	
Processing (Melt) Temp	266 to 293	°C	
Mold Temperature	65.6 to 93.3	°C	
NOTE			

1. Rate B (120°C/h), Loading 2 (50 N)

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