

PRL PC-G20

Polycarbonate
Polymer Resources Ltd.

Message:

PRL PC-G20 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
Flame Retardant
Heat Resistant

General Information			
UL YellowCard	E113219-219243		
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	Flame Retardant		
	High Heat Resistance		
	Self Extinguishing		
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/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	4.0 to 10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	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 (Break, 3.18 mm)	132	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	
RTI Elec			UL 746
1.70 mm	80.0	°C	
3.00 mm	80.0	°C	
RTI Imp			UL 746

1.70 mm	80.0	°C
3.00 mm	80.0	°C
RTI Str		UL 746
1.70 mm	80.0	°C
3.00 mm	80.0	°C
Flammability	Nominal Value	Test Method
Flame Rating		UL 94
1.70 mm, ALL	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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