

PRL PCSF-FRG20

Polycarbonate
Polymer Resources Ltd.

Message:
Polymer Resources PCSF-FRG20 is a 20% glass fiber reinforced resin for structural foam molding.

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	Foamable		
Uses	Foam		
RoHS Compliance	RoHS Compliant		
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 (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 (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	
Injection	Nominal Value	Unit	
Drying Temperature	121 to 129	°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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