

Integra™ PC-5022 R UV 0001

Polycarbonate

PolySource, LLC

Message:

PC, 17.5MFI, Mold Release, UV, Clear

General Information			
Features	Good UV resistance		
	Good demoulding performance		
Appearance	Clear/transparent		
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	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.50 - 0.70	%	Internal method
Water Absorption (Equilibrium, 23°C)	0.35	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2380	MPa	ASTM D638
Tensile Strength			ASTM D638
Yield	61.4	MPa	ASTM D638
Fracture	64.8	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	7.0	%	ASTM D638
Fracture	110	%	ASTM D638
Flexural Modulus ¹ (50.8mm span)	2340	MPa	ASTM D790
Flexural Strength ² (Yield, 50.8 mm Span)	92.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	690	J/m	ASTM D3763
Unnotched Izod Impact (23°C)	3200	J/m	ASTM D256
Tensile Impact Strength ³	546	kJ/m ²	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.35mm	137	°C	ASTM D648
1.8 MPa, unannealed, 6.35mm	132	°C	ASTM D648
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 93°C	6.8E-5	cm/cm/°C	ASTM E831
Horizontal: -40 to 93°C	6.8E-5	cm/cm/°C	ASTM E831
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 - 4.0	hr	

Suggested Max Moisture	0.020	%
Rear Temperature	260 - 279	°C
Middle Temperature	271 - 296	°C
Front Temperature	279 - 304	°C
Nozzle Temperature	275 - 300	°C
Processing (Melt) Temp	279 - 304	°C
Mold Temperature	71 - 93	°C
Back Pressure	0.310 - 0.689	MPa
Screw Speed	40 - 70	rpm

NOTE

1. 1.3 mm/min
2. 1.3 mm/min
3. Type S

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