

TRISTAR® PC-15R-113

Polycarbonate

Polymer Technology and Services, LLC

Message:

TRISTAR®PC-15R-113 is a polycarbonate (PC) product. It can be processed by injection molding and is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. TRISTAR®PC-15R-113 application areas include electrical/electronic applications and wire and cable. Features include:
flame retardant/rated flame
Comply with REACH standard
ROHS certification
mold release agent
excellent release agent

General Information			
Additive	demoulding		
Features	Good demoulding performance		
Uses	Electrical/Electronic Applications		
	Communication Equipment		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS compliance		
Appearance	Clear/transparent		
Forms	Particle		
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)	15	g/10 min	ASTM D1238
Water Absorption (23°C, 24 hr)	0.15	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 3.17 mm)	58.6	MPa	ASTM D638
Tensile Elongation (Break, 3.17 mm)	150	%	ASTM D638
Flexural Modulus (3.17 mm)	2280	MPa	ASTM D790
Flexural Strength (Yield, 3.17 mm)	89.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.17 mm)	640	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	127	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating (1.59 mm)	V-2		UL 94
Optical	Nominal Value	Unit	

Transmittance	80.0	%
Injection	Nominal Value	Unit
Drying Temperature	121	°C
Drying Time	3.0 - 4.0	hr
Drying Time, Maximum	48	hr
Suggested Shot Size	40 - 60	%
Rear Temperature	249 - 271	°C
Middle Temperature	260 - 271	°C
Front Temperature	271 - 288	°C
Nozzle Temperature	266 - 282	°C
Processing (Melt) Temp	277 - 293	°C
Mold Temperature	71.1 - 93.3	°C
Injection Pressure	68.9 - 124	MPa
Back Pressure	0.345 - 1.38	MPa
Screw Speed	40 - 70	rpm
Clamp Tonnage	2.8 - 6.9	kN/cm ²

Injection instructions

Injection Rates: Edge Gate: Slow to Medium Tab Gate: Medium to Fast Tunnel Gate: Fast

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