

**PRL PC-G20-(color)-1****Polymer Resources Ltd. - Polycarbonate**Units **English** ▾**Action****Legend (Open)****General Information****General**

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Additive	• Mold Release
Features	• Good Mold Release
RoHS Compliance	• RoHS Compliant
UL File Number	• E113219
Forms	• Pellets
Processing Method	• Injection Molding

**ASTM & ISO Properties<sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.35		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	4.0 to 10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.0E-3 to 4.0E-3	in/in	ASTM D955
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Strength (Yield, 0.125 in)	17000	psi	ASTM D638
Tensile Strength (Break, 0.125 in)	17000	psi	ASTM D638
Flexural Modulus (0.125 in)	750000	psi	ASTM D790
Flexural Strength (0.125 in)	18000	psi	ASTM D790
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (73°F, 0.125 in)	1.5	ft·lb/in	ASTM D256
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Deflection Temperature Under Load (66 psi, Unannealed, 0.125 in)	300	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed, 0.125 in)	285	°F	ASTM D648
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating			UL 94
0.07 in	V-2		
0.12 in	V-0		

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	245 to 255	°F
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum		8.0 hr
Rear Temperature	560 to 600	°F
Middle Temperature	580 to 620	°F
Front Temperature	600 to 640	°F
Processing (Melt) Temp	575 to 625	°F
Mold Temperature	180 to 240	°F

**Notes**

<sup>1</sup> Typical properties: these are not to be construed as specifications.

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