

PRL PC/ASA FR1

Polymer Resources Ltd. - Polycarbonate + ASA

Units

Action

Legend **General Information****Product Description**

PRL PC/ASA FR1 is an Acrylonitrile Styrene Acrylate + PC product that is formulated to have a V-0 flame performance.

General

Material Status	<ul style="list-style-type: none"> Commercial: Active 		
Availability	<ul style="list-style-type: none"> North America 		
Features	<ul style="list-style-type: none"> Flame Retardant 	<ul style="list-style-type: none"> Medium Flow 	<ul style="list-style-type: none"> Medium Impact Resistance
RoHS Compliance	<ul style="list-style-type: none"> RoHS Compliant 		
Forms	<ul style="list-style-type: none"> Pellets 		
Processing Method	<ul style="list-style-type: none"> Injection Molding 		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.18		ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	25 to 35	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 0.125 in)	9400	psi	ASTM D638
Tensile Strength (Break, 0.125 in)	8000	psi	ASTM D638
Flexural Modulus (0.125 in)	380000	psi	ASTM D790
Flexural Strength (0.125 in)	14000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	5.0	ft-lb/in	ASTM D256
Gardner Impact (0.125 in)	> 320	in-lb	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed, 0.125 in)	205	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed, 0.125 in)	180	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in, All)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175 to 195	°F
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	8.0	hr
Rear Temperature	390 to 470	°F
Middle Temperature	430 to 500	°F
Front Temperature	445 to 520	°F
Processing (Melt) Temp	445 to 520	°F
Mold Temperature	125 to 160	°F

Notes

¹ Typical properties: these are not to be construed as specifications.

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