

PRL PC/TP-GP2-G20Units **Polymer Resources Ltd. - Polycarbonate + Polyester****Action****Legend (Open)****General Information****General**

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Additive	• Impact Modifier
Features	• Chemical Resistant
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹**Physical**

	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.35		ASTM D792
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	5.0 to 10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	3.0E-3 to 6.0E-3	in/in	ASTM D955

Mechanical

	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 0.125 in)	10500	psi	ASTM D638
Tensile Strength (Break, 0.125 in)	10500	psi	ASTM D638
Flexural Modulus (0.125 in)	680000	psi	ASTM D790
Flexural Strength (0.125 in)	17500	psi	ASTM D790

Impact

	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.0	ft·lb/in	ASTM D256

Thermal

	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed, 0.125 in)	240	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed, 0.125 in)	230	°F	ASTM D648

Processing Information**Injection**

	Nominal Value	Unit
Drying Temperature	220 to 230	°F
Drying Time	4.0 to 6.0	hr
Drying Time, Maximum	8.0	hr
Rear Temperature	505 to 545	°F
Middle Temperature	515 to 555	°F
Front Temperature	525 to 565	°F
Processing (Melt) Temp	500 to 550	°F
Mold Temperature	150 to 190	°F

Notes

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

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