



Wednesday, August 30, 2023

**PRL PC/TP-GP3**Units English ▼Polymer Resources Ltd. - *Polycarbonate + Polyester***Action****Legend** ([Open](#))**General Information****General**

Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier
Features	• Chemical Resistant • Impact Modified • Ultra High Impact Resistance • General Purpose • Low Temperature Impact Resistance
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.24		ASTM D792
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	6.0 to 12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	0.013 to 0.018	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 0.125 in)	6700	psi	ASTM D638
Tensile Strength (Break, 0.125 in)	6400	psi	ASTM D638
Flexural Modulus (0.125 in)	260000	psi	ASTM D790
Flexural Strength (Break, 0.125 in)	9600	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°F, 0.125 in	9.0	ft·lb/in	
73°F, 0.125 in	15	ft·lb/in	
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)	240	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed, 0.125 in)	170	°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	440 to 470	°F
Middle Temperature	450 to 480	°F
Front Temperature	460 to 500	°F
Processing (Melt) Temp	460 to 500	°F
Mold Temperature	120 to 180	°F

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

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