



Wednesday, August 30, 2023

PRL PC/TP-GP3-G10Units English ▼Polymer Resources Ltd. - *Polycarbonate + Polyester***Action****Legend** ([Open](#))**General Information****General**

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 10% 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	1.30		ASTM D792
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	2.0 to 10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	7.0E-3 to 0.010	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield, 0.125 in)	9000	psi	ASTM D638
Tensile Strength (Break, 0.125 in)	9000	psi	ASTM D638
Flexural Modulus (0.125 in)	400000	psi	ASTM D790
Flexural Strength (0.125 in)	14000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	3.5	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed, 0.125 in)	325	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed, 0.125 in)	225	°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	480 to 520	°F
Middle Temperature	490 to 530	°F
Front Temperature	500 to 540	°F
Processing (Melt) Temp	500 to 550	°F
Mold Temperature	150 to 190	°F

Notes¹ Typical properties: these are not to be construed as specifications.

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