

Panlite® L-1250Y

TEIJIN LIMITED - Polycarbonate

General Information

General

Properties	• Good Mold Release	• Medium Viscosity
Uses	• General Purpose	
Appearance	• Clear/Transparent	
Forms	• Pellets	
Processing Method	• Extrusion	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	8.0	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow : 4.00 mm	0.50 to 0.70	%	
Flow : 4.00 mm	0.50 to 0.70	%	
Water Absorption (24 hr, 23°C)	0.20	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2400	MPa	ISO 527-1/1
Tensile Stress (Yield, 23°C)	61.0	MPa	ISO 527-2/50
Tensile Strain (Yield, 23°C)	6.0	%	ISO 527-2/50
Nominal Tensile Strain at Break (23°C)	> 50	%	ISO 527-2/50
Flexural Modulus ² (23°C)	2300	MPa	ISO 178
Flexural Stress ² (23°C)	91.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	76	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	77		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 0.45 MPa, Unannealed	142	°C	ISO 75-2/B
Deflection Temperature Under Load 1.8 MPa, Unannealed	129	°C	ISO 75-2/A
Vicat Softening Temperature	149	°C	ISO 306/B50
CLTE - Flow	7.0E-5	cm/cm/°C	ISO 11359-2
CLTE - Transverse	7.0E-5	cm/cm/°C	ISO 11359-2
RTI Elec (0.75 mm)	125	°C	UL 746B
RTI Imp (0.75 mm)	115	°C	UL 746B
RTI Str (0.75 mm)	125	°C	UL 746B

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Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093
Electric Strength ³	30	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
100 Hz	3.10		
1 MHz	3.00		
Dissipation Factor			IEC 60250
100 Hz	1.0E-3		
1 MHz	9.0E-3		
Comparative Tracking Index	250	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.5 mm	HB		
0.40 mm	V-2		
Glow Wire Flammability Index			IEC 60695-2-12
1.5 mm	850	°C	
3.0 mm	960	°C	
Glow Wire Ignition Temperature			IEC 60695-2-13
1.5 mm	875	°C	
3.0 mm	875	°C	
Optical	Nominal Value	Unit	Test Method
Refractive Index	1.585		ASTM D542
Light Transmittance (3000 μm)	88.0	%	ASTM D1003

Processing Information		
Injection	Nominal Value	Unit
Drying Temperature	120	°C
Drying Time	> 5.0	hr
Processing (Melt) Temp	270 to 320	°C
Mold Temperature	80 to 120	°C

Notes

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

² 2.0 mm/min

³ short time test