

Opticarb 2014UR

The Materials Group - Polycarbonate

General Information

General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Additive	<ul style="list-style-type: none"> Mold Release
Features	<ul style="list-style-type: none"> UV Resistant
Appearance	<ul style="list-style-type: none"> Clear/Transparent
Forms	<ul style="list-style-type: none"> Pellets
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	20	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	9140	psi	ISO 527-2
Tensile Strain (Break)	140	%	ISO 527-2
Flexural Modulus	328000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength	33	ft-lb/in ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	257	°F	ISO 75-2/A
Vicat Softening Temperature	284	°F	ISO 306/B50

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	248	°F
Drying Time	4.0	hr
Suggested Max Moisture	0.020	%
Processing (Melt) Temp	500 to 608	°F

Injection Notes

Exact processing temp will vary w/ part. Starting mid-lower range is typical. Contact TMG for on-site technical support.

Notes

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

