

Technical Data Sheet

PC 0407
Polycarbonate

Polycarbonate (PC) plastics are a naturally transparent amorphous thermoplastic. Polycarbonates used in engineering are strong, tough materials, and some grades are optically transparent. They are easily worked, molded, and thermoformed.

Application:

- This grade Suitable for injection modeling and Extrusion, Business Machines, Packaging, Sports, Appliances, Electrical, Lighting, Wire and Cable, Automotive, Sheets.

TYPICAL PROPERTIES				
Properties	Test. Method	Condition	Unite	Value
MFI (300°C)	ASTM D 1238	1.2 kg, 300 °C	g/10 min	4.1-7
Density	ASTM D 792	25 °C	g/cm3	1.2
Tensile Strength	ASTM D 638	@ yield	Kgf/cm2	630
Modulus of Elasticity	ASTM D 638	--	Kgf/cm2	24000
Elongation	ASTM D 638	@ Break	%	≥100
Dielectric Strength	ASTM D 149	@ 50 Hz	Kv/mm	≥18
Izod Impact Strength	ASTM D 256	Notched	Kj/m2	≥80
Vicat soft. Temp.	ASTM D 1525	50 N, 50 C/h	°C	142-146
Transmittance	ASTM D 01003	Thickness 2mm	%	≥90

NOTE: TYPICAL PROPERTIES ARE NOT TO BE COSTRUED AS SPECIFICATIONS.

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PROCESSING GUIDES		
DRING CONDITION		
	Unite	Typical Value
DRY TEMPERATURE	°C	120
DRYING TIME	hr	4
MAXIMUM MOISTURE CONTENT	%	0.02

PROCESSING GUIDES		
INJECTION MOLDING		
	Unite	Typical Value
MELT TEMPERATURE	°C	290-310
NOZZLE TEMPERATURE	°C	280-300
BARREL REAR ZONE TEMPERATURE	°C	290-310
BARREL MIDDLE ZONE TEMPERATURE	°C	280-300
BARREL FRONT ZONE TEMPERATURE	°C	270-290
HOPPER TEMPERATURE	°C	60-80
MOLD TEMPERATURE	°C	60-90