

**PRL PC-HM-FR2-(color)-1**

PC-GF10

Polymer Resources, Ltd.

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ASTM Data</b>			
Melt Flow Index, MFI	<b>12</b>	g/10min	ASTM D 1238
Temperature	<b>300</b>	°C	-
Load	<b>1.2</b>	kg	-
Mold Shrinkage, MD	<b>0.0035</b>	mm/mm	ASTM D 955

<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ASTM Data</b>			
Tensile Strength at Yield	<b>65.5</b>	MPa	ASTM D 638
Tensile Strength at Break	<b>55.8</b>	MPa	ASTM D 638
Flexural Modulus	<b>3378</b>	MPa	ASTM D 790
Flexural Strength	<b>103</b>	MPa	ASTM D 790
Izod Impact notched, 1/8 in	<b>107</b>	J/m	ASTM D 256

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ASTM Data</b>			
UL 94 Flame rating	<b>V-0</b>	-	UL 94
Thickness tested	<b>1.5</b>	mm	-
DTUL @ 66 psi	<b>143</b>	°C	ASTM D 648
DTUL @ 264 psi	<b>138</b>	°C	ASTM D 648

<b>Other properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1260</b>	kg/m <sup>3</sup>	ASTM D 792

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>118 - 124</b>	°C	-
Pre-drying - Time	<b>3 - 4</b>	h	-
Melt temperature	<b>302 - 329</b>	°C	-
Mold temperature	<b>82.2 - 116</b>	°C	-
Zone 1	<b>293 - 316</b>	°C	-
Zone 2	<b>304 - 327</b>	°C	-
Zone 3	<b>316 - 338</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Delivery form**

Pellets

**Additives**

Release agent

**Special Characteristics**

Flame retardant

**Regional Availability**

North America