

PC-1220R

PC

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	22	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	62	MPa	ASTM D 638
Elongation at Break	100	%	ASTM D 638
Flexural Modulus	2354	MPa	ASTM D 790
Izod Impact notched, 1/8 in	687	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 66 psi	139	°C	ASTM D 648
DTUL @ 264 psi	128	°C	ASTM D 648
Vicat Temperature	150	°C	ASTM D 1525

Optical properties	Value	Unit	Test Standard
ASTM Data			
Haze	0.8	%	ASTM D 1003
Light Transmittance	89	%	ASTM D 1003
Index of Refraction	1.58	-	ASTM D 542

Other properties	Value	Unit	Test Standard
Density	1200	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	290 - 310	°C	-
Mold temperature	60 - 90	°C	-
Feed temperature	60 - 80	°C	-
Zone 1	270 - 290	°C	-
Zone 2	280 - 300	°C	-
Zone 3	290 - 310	°C	-
Nozzle temperature	280 - 300	°C	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Additives

Release agent