

**PRL PC-IM4**

PC

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>25</b>	g/10min	ASTM D 1238
Temperature	<b>300</b>	°C	-
Load	<b>1.2</b>	kg	-
Mold Shrinkage, MD	<b>0.006</b>	mm/mm	ASTM D 955
Mold Shrinkage, TD	<b>0.006</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>53.1</b>	MPa	ASTM D 638
Tensile Strength at Break	<b>51.7</b>	MPa	ASTM D 638
Elongation at Yield	<b>6</b>	%	ASTM D 638
Elongation at Break	<b>100</b>	%	ASTM D 638
Flexural Modulus	<b>1999</b>	MPa	ASTM D 790
Flexural Strength	<b>68.9</b>	MPa	ASTM D 790
Izod Impact notched, 1/8 in	<b>641</b>	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	<b>534</b>	J/m	ASTM D 256
Temperature	<b>-17.8</b>	°C	-

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ASTM Data</b>			
DTUL @ 66 psi	<b>124</b>	°C	ASTM D 648
DTUL @ 264 psi	<b>118</b>	°C	ASTM D 648
Vicat Temperature	<b>141</b>	°C	ASTM D 1525

<b>Other properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1190</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>274 - 302</b>	°C	-
Mold temperature	<b>71.1 - 93.3</b>	°C	-
Zone 1	<b>254 - 277</b>	°C	-
Zone 2	<b>266 - 288</b>	°C	-
Zone 3	<b>277 - 299</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Special Characteristics**

High impact or impact modified

**Delivery form**

Pellets

**Regional Availability**

North America