

PRL PC-UV4-(color)-1

PC

Polymer Resources, Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	24	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.006	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	62.1	MPa	ASTM D 638
Tensile Strength at Break	65.5	MPa	ASTM D 638
Elongation at Yield	6	%	ASTM D 638
Elongation at Break	120	%	ASTM D 638
Flexural Modulus	2275	MPa	ASTM D 790
Flexural Strength	92.4	MPa	ASTM D 790
Rockwell Hardness	M70	-	ASTM D 785
Izod Impact notched, 1/8 in	641	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 66 psi	129	°C	ASTM D 648
DTUL @ 264 psi	124	°C	ASTM D 648
Vicat Temperature	141	°C	ASTM D 1525

Optical properties	Value	Unit	Test Standard
ASTM Data			
Haze	1	%	ASTM D 1003
Light Transmittance	88	%	ASTM D 1003

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	118 - 124	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	266 - 293	°C	-
Mold temperature	65.6 - 93.3	°C	-
Zone 1	249 - 271	°C	-
Zone 2	260 - 282	°C	-
Zone 3	271 - 293	°C	-

Characteristics**Processing**

Injection Molding

Special Characteristics

U.V. stabilized or stable to weather

Delivery form

Pellets

Regional Availability

North America

Additives

Release agent