

TRISTAR® PC-10FR-(VIM)S

PC

Amco Polymers

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	10	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	55	MPa	ASTM D 638
Flexural Modulus	2068	MPa	ASTM D 790
Rockwell Hardness	R 120	-	ASTM D 785
Izod Impact notched, 1/8 in	747	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	214	J/m	ASTM D 256
Temperature	-40	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	137	°C	ISO 75-1/-2
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (GWIT)	777	°C	IEC 60695-2-13
ASTM Data			
UL 94 Flame rating	V-1	-	UL 94
Thickness tested	1.52	mm	-
Coefficient of Thermal Expansion, MD	70.2	E-6/K	ASTM D 696
Coefficient of Thermal Expansion, TD	68.4	E-6/K	ASTM D 696
DTUL @ 66 psi	135	°C	ASTM D 648
DTUL @ 264 psi	127	°C	ASTM D 648
Limiting Oxygen Index	37	%	ASTM D 2863

Electrical properties	Value	Unit	Test Standard
ASTM Data			
Arc Resistance	90	s	ASTM D 495
Other Standards^[5]			
Comparative tracking index	325	-	UL 746A

S: These properties are reported by the producer according standards that are different to our defaults.

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	0.18	%	ASTM D 570
Density	1230	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	121	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	282 - 304	°C	-
Mold temperature	71.1 - 93.3	°C	-
Zone 1	254 - 274	°C	-
Zone 2	266 - 277	°C	-
Zone 3	277 - 293	°C	-
Nozzle temperature	271 - 293	°C	-
Screw speed	40 - 70	rpm	-
Injection pressure	75.8 - 124	MPa	-
Back pressure	0.345 - 1.38	MPa	-

Characteristics**Processing**

Injection Molding

Delivery form

Pellets

Additives

Release agent

Special Characteristics

Flame retardant, U.V. stabilized or stable to weather

Certifications

RoHS compliant

Applications

Electrical and Electronical

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa