

TRISTAR® PC-10R-(V4)

PC

Amco Polymers

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	4	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	62.1	MPa	ASTM D 638
Elongation at Break	120	%	ASTM D 638
Flexural Modulus	2213	MPa	ASTM D 790
Rockwell Hardness	R 120	-	ASTM D 785
Izod Impact notched, 1/8 in	801	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	137	°C	ISO 75-1/-2
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-2	-	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 @ 264 psi	135	°C	ASTM D 648

Electrical properties	Value	Unit	Test Standard
ASTM Data			
Arc Resistance	90	s	ASTM D 495
Other Standards^[S]			
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	0.15	%	ASTM D 570
Density	1200	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	316 - 343	°C	-
Mold temperature	82.2 - 116	°C	-
Zone 1	288 - 304	°C	-
Zone 2	299 - 321	°C	-
Zone 3	316 - 338	°C	-
Nozzle temperature	304 - 332	°C	-
Screw speed	40 - 70	rpm	-
Injection pressure	110 - 152	MPa	-
Back pressure	0.345 - 1.38	MPa	-

Characteristics**Processing**

Injection Molding

Certifications

RoHS compliant

Delivery form

Pellets

Additives

Release agent

Special Characteristics

U.V. stabilized or stable to weather

Applications

Electrical and Electronical

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