

TRISTAR® PC-10R-(VE)

PC

Amco Polymers

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	12	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	641	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	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

Certifications

RoHS compliant

Delivery form

Pellets

Applications

Electrical and Electronical

Additives

Release agent

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

U.V. stabilized or stable to weather