

## Grade: PC1212, R, UV, RUV

Molding Grade PC, w/ Release, w/ UV, w/ UV and Release

### Typical Material Properties

| Physical                              | Nominal Values    | ASTM Test |
|---------------------------------------|-------------------|-----------|
| Specific Gravity                      | 1.20              | D792      |
| Melt Flow (300°C/1.2kg)               | 12 g/10 min       | D1238     |
| <b>Mechanical</b>                     |                   |           |
| Tensile Modulus                       | 345,000 psi       | D638      |
| Tensile Strength @ Yield              | 8,500 psi         | D638      |
| Flexural Modulus                      | 345,000 psi       | D790      |
| Flexural Strength @ Yield             | 12,500 psi        | D790      |
| <b>Impact</b>                         |                   |           |
| Notched Izod Impact (73 °F, 0.125 in) | 12 ft-lb/in       | D256      |
| <b>Thermal</b>                        |                   |           |
| DTUL @ 264 psi-unannealed (0.125 in)  | 260°F             | D648      |
| <b>Mold Shrinkage</b>                 |                   |           |
| Linear Flow                           | .005 - .007 in/in | D955      |

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### Recommended Processing Guidelines

|                               | Nominal Values   |
|-------------------------------|------------------|
| Drying Time and Temperature   | 4.0 hrs at 250°F |
| Suggested Max Moisture        | 0.020%           |
| Rear Temperature              | 520°F – 550°F    |
| Middle Temperature            | 530°F – 570°F    |
| Front Temperature             | 550°F – 580°F    |
| Nozzle Temperature            | 550°F – 590°F    |
| Processing (Melt) Temperature | 550°F – 600°F    |
| Mold Temperature              | 120°F – 170°F    |
| Back Pressure                 | 50 – 100 psi     |
| Screw Speed                   | 40 – 75 RPM      |

The conditions listed above are only guidelines. You may want to adjust conditions to meet your requirements.