

## Grade: PC7231(f1)

Molding Grade: PCFR, PFAS Free w/ UV and Release, All Colors

### Typical Material Properties

| Physical                              | Nominal Values           | ASTM Test |
|---------------------------------------|--------------------------|-----------|
| Specific Gravity                      | 1.20                     | D792      |
| Melt Flow (300°C/1.2kg)               | 15.0 g/10 min            | D1238     |
| <b>Mechanical</b>                     |                          |           |
| Tensile Modulus                       | 350,000 psi              | D638      |
| Tensile Strength @ Yield              | 8,800 psi                | D638      |
| Flexural Modulus                      | 350,000 psi              | D790      |
| Flexural Strength @ Yield             | 13,000 psi               | D790      |
| <b>Impact</b>                         |                          |           |
| Notched Izod Impact (73 °F, 0.125 in) | 14.0 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      |
| <b>UL Rating</b>                      | (f1)                     | UL746C    |
| Flammability                          | V-2 @ 1.5mm, V-1 @ 1.5mm | UL 94     |
| RTI                                   | 125°C, 115°C, 125°C      | UL746B    |

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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 – 600 °F   |
| Nozzle Temperature            | 550°F – 600 °F   |
| Processing (Melt) Temperature | 550°F – 600 °F   |
| Mold Temperature              | 170°F – 220 °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.