

Entec Hylex® P1302B Polycarbonate

Category : Polymer , Thermoplastic , Polycarbonate (PC) , Polycarbonate, Molded

Material Notes:

Entec's proprietary products include a full range of compounds in the Nylon 6/6, Nylon 6, ABS, PBT, Polycarbonate, PC/ABS, PC/ASA, PC/PBT, and PPO/PPE resin families. Information provided by Entec.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Entec-Hylex-P1302B-Polycarbonate.php

Physical Properties	Metric	English	Comments
Water Absorption	0.15 %	0.15 %	24 hrs; ASTM D570
Melt Flow	2.3 g/10 min @Load 1.20 kg, Temperature 300 °C	2.3 g/10 min @Load 2.65 lb, Temperature 572 °F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell M	122	122	ASTM D785
Tensile Strength at Break	68.9 MPa	10000 psi	ASTM D638
Elongation at Break	100 %	100 %	ASTM D638
Flexural Strength	88.3 MPa	12800 psi	ASTM D790
Flexural Modulus	2.07 GPa	300 ksi	ASTM D790
Izod Impact, Notched	8.33 J/cm	15.6 ft-lb/in	73°F, 0.125 in; ASTM D256

Thermal Properties	Metric	English	Comments
Deflection Temperature at 0.46 MPa (66 psi)	138 °C	280 °F	Unannealed (0.125 in); ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	132 °C	270 °F	Unannealed (0.125 in); ASTM D648
Glass Transition Temp, Tg	152 °C	306 °F	Transition Temperature, tested in accordance with ASTM D1525; ASTM E1356

Optical Properties	Metric	English	Comments
Refractive Index	1.585	1.585	ASTM D542
Transmission, Visible	78 %	78 %	125 mil; ASTM D1003

Processing Properties	Metric	English	Comments
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Processing Properties	Metric	English	Comments
Zone 2	241 - 260 °C	465 - 500 °F	
Zone 3	249 - 271 °C	480 - 520 °F	
Zone 4	249 - 271 °C	480 - 520 °F	
Adapter Temperature	246 - 266 °C	475 - 510 °F	
Die Temperature	254 - 277 °C	490 - 530 °F	
Head Temperature	249 - 271 °C	480 - 520 °F	Zone 2
	254 - 277 °C	490 - 530 °F	Zone 1
Mold Temperature	110 - 129 °C	230 - 265 °F	
Drying Temperature	121 °C	250 °F	
Dry Time	3 - 4 hour	3 - 4 hour	
Moisture Content	<= 0.020 %	<= 0.020 %	
Screw Speed	20 - 40 rpm	20 - 40 rpm	

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