

PTS Tristar® PC-10 10 MFI Extrusion Grade Polycarbonate

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

Material Notes:

Information provided by Polymer Technology and Services, LLC (PTS).

Order this product through the following link:

http://www.lookpolymers.com/polymer_PTS-Tristar-PC-10-10-MFI-Extrusion-Grade-Polycarbonate.php

Physical Properties	Metric	English	Comments
Density	1.20 g/cc	0.0434 lb/in ³	ASTM D792
Water Absorption	0.15 %	0.15 %	24 hours at 73°F; ASTM D570
Melt Flow	10 g/10 min @Load 1.20 kg, Temperature 300 °C	10 g/10 min @Load 2.65 lb, Temperature 572 °F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell R	120	120	ASTM D785
Tensile Strength, Yield	62.1 MPa @Thickness 3.17 mm	9010 psi @Thickness 0.125 in	ASTM D638
Elongation at Break	100 % @Thickness 3.17 mm	100 % @Thickness 0.125 in	ASTM D638
Flexural Yield Strength	89.6 MPa @Thickness 3.17 mm	13000 psi @Thickness 0.125 in	ASTM D790
Flexural Modulus	2.21 GPa @Thickness 3.17 mm	321 ksi @Thickness 0.125 in	ASTM D790
Izod Impact, Notched	6.41 J/cm @Thickness 3.17 mm	12.0 ft-lb/in @Thickness 0.125 in	ASTM D256

Thermal Properties	Metric	English	Comments
CTE, linear, Parallel to Flow	70.2 µm/m-°C @Temperature -40.0 - 95.0 °C	39.0 µin/in-°F @Temperature -40.0 - 203 °F	ASTM E831-06
CTE, linear, Transverse to Flow	68.4 µm/m-°C @Temperature -40.0 - 95.0 °C	38.0 µin/in-°F @Temperature -40.0 - 203 °F	ASTM E831-06

Deflection Temperature at 1.8 MPa Thermal Properties (104 psi)	127 °C Metric	261 °F English	ASTM D648 Comments
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Processing Properties	Metric	English	Comments
Rear Barrel Temperature	266 - 277 °C	510 - 530 °F	
Middle Barrel Temperature	271 - 282 °C	520 - 540 °F	
Front Barrel Temperature	282 - 299 °C	540 - 570 °F	
Nozzle Temperature	277 - 304 °C	530 - 580 °F	
Melt Temperature	288 - 316 °C	550 - 600 °F	
Mold Temperature	71.1 - 93.3 °C	160 - 200 °F	
Drying Temperature	121 °C	250 °F	
Dry Time	3 - 4 hour	3 - 4 hour	48 hours max.
Injection Pressure	82.7 - 124 MPa	12000 - 18000 psi	
Back Pressure	0.345 - 1.38 MPa	50.0 - 200 psi	
Clamp Pressure	27.6 - 68.9 MPa	4000 - 10000 psi	
Shot Size	40 - 60 %	40 - 60 %	
Screw Speed	40 - 70 rpm	40 - 70 rpm	

Descriptive Properties	Value	Comments
Injection Speed- Edge Gate	Slow to Medium	
Injection Speed- Tab Gate	Medium to Fast	
Injection Speed- Tunnel Gate	Fast	

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