

## Ravago Manufacturing Americas Hylex® P1310LLT Polycarbonate

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

### Material Notes:

Information provided by Ravago

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_Ravago-Manufacturing-Americas-Hylex-P1310LLT-Polycarbonate.php](http://www.lookpolymers.com/polymer_Ravago-Manufacturing-Americas-Hylex-P1310LLT-Polycarbonate.php)

| Physical Properties   | Metric                                              | English                                             | Comments   |
|-----------------------|-----------------------------------------------------|-----------------------------------------------------|------------|
| Density               | 1.18 g/cc                                           | 0.0426 lb/in <sup>3</sup>                           | ASTM D792  |
| Linear Mold Shrinkage | 0.0050 - 0.0070 cm/cm                               | 0.0050 - 0.0070 in/in                               | ASTM D955  |
| Melt Flow             | 11 g/10 min<br>@Load 1.20 kg,<br>Temperature 300 °C | 11 g/10 min<br>@Load 2.65 lb,<br>Temperature 572 °F | ASTM D1238 |

| Mechanical Properties     | Metric                             | English                                | Comments            |
|---------------------------|------------------------------------|----------------------------------------|---------------------|
| Tensile Strength at Break | 55.2 MPa                           | 8000 psi                               | ASTM D638           |
| Elongation at Break       | 130 %                              | 130 %                                  | ASTM D638           |
| Flexural Strength         | 82.7 MPa                           | 12000 psi                              | ASTM D790           |
| Flexural Modulus          | 2.14 GPa                           | 310 ksi                                | ASTM D790           |
| Izod Impact, Notched      | 7.47 J/cm                          | 14.0 ft-lb/in                          | 0.125 in; ASTM D256 |
|                           | 5.34 J/cm<br>@Temperature -30.0 °C | 10.0 ft-lb/in<br>@Temperature -22.0 °F | 0.125in; ASTM D256  |

| Thermal Properties                          | Metric | English | Comments              |
|---------------------------------------------|--------|---------|-----------------------|
| Deflection Temperature at 0.46 MPa (66 psi) | 132 °C | 270 °F  | Unannealed; ASTM D648 |
| Deflection Temperature at 1.8 MPa (264 psi) | 124 °C | 255 °F  | Unannealed; ASTM D648 |
| Vicat Softening Point                       | 143 °C | 290 °F  | ASTM D1525            |
| Flammability, UL94                          | HB     | HB      | 0.0590 in, NA         |

| Processing Properties     | Metric       | English      | Comments |
|---------------------------|--------------|--------------|----------|
| Rear Barrel Temperature   | 271 - 282 °C | 520 - 540 °F |          |
| Middle Barrel Temperature | 277 - 288 °C | 530 - 550 °F |          |

| Processing Properties | Metric           | English         | Comments |
|-----------------------|------------------|-----------------|----------|
| Nozzle Temperature    | 277 - 299 °C     | 530 - 570 °F    |          |
| Melt Temperature      | 288 - 316 °C     | 550 - 600 °F    |          |
| Mold Temperature      | 76.7 - 93.3 °C   | 170 - 200 °F    |          |
| Drying Temperature    | 121 °C           | 250 °F          |          |
| Dry Time              | 3 - 12 hour      | 3 - 12 hour     |          |
| Moisture Content      | <= 0.020 %       | <= 0.020 %      |          |
| Injection Pressure    | 6.89 - 12.4 MPa  | 1000 - 1800 psi |          |
| Back Pressure         | 0.483 - 1.03 MPa | 70.0 - 150 psi  |          |
| Shot Size             | 40 - 60 %        | 40 - 60 %       |          |
| Screw Speed           | 40 - 70 rpm      | 40 - 70 rpm     |          |

| Descriptive Properties | Value           | Comments |
|------------------------|-----------------|----------|
| Holding Pressure       | 700 to 1200 psi |          |

## Contact Songhan Plastic Technology Co.,Ltd.

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