

Samyang Trirex® PC-3020HF 22 MFI Clear Polycarbonate

Category : Polymer , Thermoplastic , Polycarbonate (PC) , Polycarbonate, Optical Grade

Material Notes:

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

Order this product through the following link:

http://www.lookpolymers.com/polymer_Samyang-Trirex-PC-3020HF-22-MFI-Clear-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
Melt Flow	22 g/10 min	22 g/10 min	
	@Load 1.20 kg, Temperature 300 °C	@Load 2.65 lb, Temperature 572 °F	

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell R	120	120	ASTM D785
Tensile Strength, Yield	60.3 MPa	8750 psi	
	@Thickness 3.17 mm	@Thickness 0.125 in	
Elongation at Break	100 %	100 %	
	@Thickness 3.17 mm	@Thickness 0.125 in	
Flexural Yield Strength	89.6 MPa	13000 psi	
	@Thickness 3.17 mm	@Thickness 0.125 in	
Flexural Modulus	2.21 GPa	321 ksi	
	@Thickness 3.17 mm	@Thickness 0.125 in	
Izod Impact, Notched	6.94 J/cm	13.0 ft-lb/in	
	@Thickness 3.17 mm	@Thickness 0.125 in	

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (264 psi)	132 °C	270 °F	ASTM D648
Flammability, UL94	V-2	V-2	
	@Thickness 1.59 mm	@Thickness 0.0625 in	

Optical Properties	Metric	English	Comments
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Optical Properties	80 % Metric	80 % English	Clear grade, but transmission not Comments
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Processing Properties	Metric	English	Comments
Rear Barrel Temperature	243 - 260 Å°C	470 - 500 Å°F	
Middle Barrel Temperature	249 - 260 Å°C	480 - 500 Å°F	
Front Barrel Temperature	260 - 271 Å°C	500 - 520 Å°F	
Nozzle Temperature	254 - 271 Å°C	490 - 520 Å°F	
Melt Temperature	260 - 282 Å°C	500 - 540 Å°F	
Mold Temperature	71.1 - 93.3 Å°C	160 - 200 Å°F	
Drying Temperature	121 Å°C	250 Å°F	
Dry Time	3 - 4 hour	3 - 4 hour	
Injection Pressure	51.7 - 124 MPa	7500 - 18000 psi	
Back Pressure	0.345 - 1.38 MPa	50.0 - 200 psi	
Clamp Pressure	27.6 - 68.9 MPa	4000 - 10000 psi	
Cycle Time - Injection	1.0 - 2.5 sec	1.0 - 2.5 sec	
Cycle Time - Cooling	5.0 - 40 sec	5.0 - 40 sec	
Vent Depth	0.00200 - 0.00800 cm	0.000787 - 0.00315 in	
Screw Speed	40 - 70 rpm	40 - 70 rpm	

Descriptive Properties	Value	Comments
Injection Speed- Edge Gate	Slow-Medium	
Injection Speed- Tab Gate	Medium-Fast	
Injection Speed- Tunnel Gate	Fast	
Shot Size	40-60%	

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