



Grade: PC1105FR, R, UV, RUV
PC with UV and Release

Typical Material Properties

| Physical | Nominal Values | ASTM Test |
|---------------------------------------|-------------------|-----------|
| Specific Gravity | 1.20 | D792 |
| Melt Flow (300°C/1.2kg) | 20.0 g/10 min | D1238 |
| Mechanical | | |
| Tensile Modulus | 355,000 psi | D638 |
| Tensile Strength @ Yield | 8,800 psi | D638 |
| Flexural Modulus | 348,000 psi | D790 |
| Flexural Strength @ Yield | 13,500 psi | D790 |
| Impact | | |
| Notched Izod Impact (73 °F, 0.125 in) | 14.0 ft-lb/in | D256 |
| Thermal | | |
| DTUL @ 264 psi-unannealed (0.125 in) | 260°F | D648 |
| Mold Shrinkage | | |
| Linear Flow | .005 - .007 in/in | D955 |
| UL Rating | V2 (1.5mm) | UL 94 |

Recommended Processing Guidelines

| | Nominal Values |
|-------------------------------|------------------|
| Drying Time and Temperature | 4.0 hrs at 250°F |
| Suggested Max Moisture | 0.020% |
| Rear Temperature | 475°F – 525°F |
| Middle Temperature | 500°F – 550°F |
| Front Temperature | 525°F – 575°F |
| Nozzle Temperature | 525°F – 575°F |
| Processing (Melt) Temperature | 525°F – 575°F |
| Mold Temperature | 160°F – 210°F |
| Back Pressure | 50 – 200 psi |
| Screw Speed | 40 – 100 RPM |