



**Grade: PC4503, R, UV, RUV**

Molding Grade, High Flow PC w/ Release, w/ UV, w/ Release & UV

**Typical Material Properties**

Physical	Nominal Values	ASTM Test
Specific Gravity	1.20	D792
Melt Flow (300°C/1.2kg)	45.0 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	340,000 psi	D638
Tensile Strength @ Yield	8,200 psi	D638
Flexural Modulus	330,000 psi	D790
Flexural Strength @ Yield	11,500 psi	D790
<b>Impact</b>		
Notched Izod Impact (73 °F, 0.125 in)	5.0 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.125 in)	260°F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.005 - .007 in/in	D955

**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