



**Grade: PC5GFMBFR, R, UV, RUV**

Molding Grade PCFR w/ 5% Glass, Release, UV, Release & UV

**Typical Material Properties**

Physical	Nominal Values	ASTM Test
Specific Gravity	1.27	D792
Melt Flow (300°C/1.2 kg)	12.0 g/10 min	D1238
<b>Mechanical</b>		
Tensile Modulus	350,000 psi	D638
Tensile Strength @ Yield	7,500 psi	D638
Flexural Modulus	400,000 psi	D790
Flexural Strength @ Yield	13,000 psi	D790
<b>Impact</b>		
Notched Izod Impact (73°F, 0.125 in)	2.5 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.125 in)	275°F	D648
<b>Mold Shrinkage</b>		
Linear Flow	.003 - .005 in/in	D955
<b>UL Rating</b>		
Flammability RTI	V-0 @ 3.0mm & 6.0mm 125°C, 115°C, 125°C	UL 94 UL 746B

**Recommended Processing Guidelines**

	Nominal Values
Drying Time and Temperature	4.0 hrs, 250°F
Suggested Max Moisture	0.020%
Rear Temperature	490°F – 520°F
Middle Temperature	510°F – 560°F
Front Temperature	560°F – 590°F
Nozzle Temperature	520°F – 590°F
Processing (Melt) Temperature	500°F – 575°F
Mold Temperature	160°F – 200°F
Back Pressure	40 – 100 psi
Screw Speed	25 – 75 RPM