



GRADE: PC731, PC731R

Molding Grade PC, w/ Release *Colors Limited

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.20	D792
Melt Flow (300°C/1.2kg)	4.0 g/10 min	D1238
Mechanical		
Tensile Modulus	350,000 psi	D638
Tensile Strength @ Yield	9,000 psi	D638
Flexural Modulus	350,000 psi	D790
Flexural Strength @ Yield	13,000 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)	265 °F	D648
Mold Shrinkage		
Linear Flow	.005 - .007 in/in	D955
UL Rating	V2 (3.0 mm); V2 (1.5 mm)	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