



GRADE: PC8013

Molding Grade PCFR with Release and UV

Typical Material Properties

| Physical | Nominal Values | ASTM Test |
|---------------------------------------|-------------------|-----------|
| Specific Gravity | 1.20 | D792 |
| Melt Flow (300°C/1.2kg) | 8.0 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) | 260 °F | D648 |
| Mold Shrinkage | | |
| Linear Flow | .005 - .007 in/in | D955 |
| UL Rating | | |
| Flammability | V-0 @ 1.5mm | UL 94 |
| RTI | 80°C, 80°C, 80°C | UL746B |

Recommended Processing Guidelines

| | Nominal Values |
|-------------------------------|----------------|
| Drying Time and Temperature | 4.0 hrs, 250°F |
| Suggested Max Moisture | 0.020% |
| Rear Temperature | 520°F – 550 °F |
| Middle Temperature | 530°F – 570 °F |
| Front Temperature | 550°F – 600 °F |
| Nozzle Temperature | 550°F – 600 °F |
| Processing (Melt) Temperature | 550°F – 600 °F |
| Mold Temperature | 170°F – 220 °F |
| Back Pressure | 50 – 100 psi |
| Screw Speed | 40 – 75 RPM |