



HYLEX® P1302B

Entec Polymers - Polycarbonate

Monday, November 4, 2019

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• UV Stabilizer
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Blow Molding • Extrusion

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Melt Mass-Flow Rate (300°C/1.2 kg)	2.3	g/10 min	ASTM D1238
Water Absorption (24 hr)	0.15	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break, 73°F, 0.125 in)	10000	psi	ASTM D638
Tensile Elongation (Break, 73°F, 0.125 in)	100	%	ASTM D638
Flexural Modulus (73°F, 0.125 in)	300000	psi	ASTM D790
Flexural Strength (73°F, 0.125 in)	12800	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	16	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale, 0.125 in)	122		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed, 0.125 in	280	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed, 0.125 in	270	°F	ASTM D648
Glass Transition Temperature	306	°F	ASTM E1356
Optical	Nominal Value	Unit	Test Method
Refractive Index	1.585		ASTM D542
Transmittance (125 mil)	78.0	%	ASTM D1003

Processing Information

Extrusion	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	3.0 to 6.0	hr
Suggested Max Moisture	0.020	%
Cylinder Zone 1 Temp.	445 to 480	°F
Cylinder Zone 2 Temp.	465 to 500	°F
Cylinder Zone 3 Temp.	480 to 520	°F
Cylinder Zone 4 Temp.	480 to 520	°F
Adapter Temperature	475 to 510	°F
Die Temperature	490 to 530	°F

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Extrusion Notes

Extrusion Blow Molding Temperatures:

- Head Temperature Zone 1: 490 - 530°F
- Head Temperature Zone 1: 480 - 520°F
- Mold Temperature: 230 - 265°F
- Screw Speed: 20 - 40 rpm

Notes

¹ Typical properties: these are not to be construed as specifications.