

Ravago Manufacturing Americas Hylex® P1325L Polycarbonate, UV Stabilized, High Flow, Mold Release

Category : Polymer , Thermoplastic , Polycarbonate (PC) , Polycarbonate, Molded

Material Notes:

Entec's proprietary products include a full range of compounds in the Nylon 6/6, Nylon 6, ABS, PBT, Polycarbonate, PC/ABS, PC/ASA, PC/PBT, and PPO/PPE resin families. Information provided by Entec.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Ravago-Manufacturing-Americas-Hylex-P1325L-Polycarbonate-UV-Stabilized-High-Flow-Mold-Release.php

| Physical Properties | Metric | English | Comments |
|-----------------------|---|---|-------------------|
| Density | 1.20 g/cc | 0.0434 lb/in ³ | ASTM D792 |
| Water Absorption | 0.15 % | 0.15 % | 24 hrs; ASTM D570 |
| Linear Mold Shrinkage | 0.0050 - 0.0070 cm/cm | 0.0050 - 0.0070 in/in | ASTM D955 |
| Melt Flow | 25 g/10 min @Load 1.20 kg, Temperature 300 °C | 25 g/10 min @Load 2.65 lb, Temperature 572 °F | ASTM D1238 |

| Mechanical Properties | Metric | English | Comments |
|---------------------------|-----------|---------------|---------------------------|
| Hardness, Rockwell M | 80 | 80 | ASTM D785 |
| Tensile Strength at Break | 68.9 MPa | 10000 psi | ASTM D638 |
| Elongation at Break | 115 % | 115 % | ASTM D638 |
| Flexural Strength | 91.0 MPa | 13200 psi | ASTM D790 |
| Flexural Modulus | 2.31 GPa | 335 ksi | ASTM D790 |
| Izod Impact, Notched | 6.41 J/cm | 12.0 ft-lb/in | 73°F, 0.125 in; ASTM D256 |

| Thermal Properties | Metric | English | Comments |
|---|---------------------------|-----------------------------|-----------------------|
| Deflection Temperature at 0.46 MPa (66 psi) | 132 °C | 270 °F | Unannealed; ASTM D648 |
| Deflection Temperature at 1.8 MPa (264 psi) | 127 °C | 260 °F | Unannealed; ASTM D648 |
| Vicat Softening Point | 154 °C | 310 °F | ASTM D1525 |
| Flammability, UL94 | V-2 @Thickness 1.50 mm | V-2 @Thickness 0.0591 in | |
| | V-2 | V-2 | |

| Thermal Properties | Metric | English | Comments |
|--------------------|--------------------|---------------------|----------|
| | @Thickness 3.00 mm | @Thickness 0.118 in | |
| | V-0 | V-0 | |
| | @Thickness 6.00 mm | @Thickness 0.236 in | |

| Optical Properties | Metric | English | Comments |
|-----------------------|---------------|---------------|---------------------|
| Refractive Index | 1.585 | 1.585 | ASTM D542 |
| Haze | 0.50 - 0.80 % | 0.50 - 0.80 % | 125 mil; ASTM D1003 |
| Transmission, Visible | 89 - 91 % | 89 - 91 % | 125 mil; ASTM D1003 |

| Electrical Properties | Metric | English | Comments |
|-----------------------|-----------------|-----------------|-----------------------------|
| Volume Resistivity | 4.00e+16 ohm-cm | 4.00e+16 ohm-cm | ASTM D257 |
| Dielectric Strength | 16.1 kV/mm | 410 kV/in | in Air, 0.125 in; ASTM D149 |
| Arc Resistance | 120 sec | 120 sec | ASTM D495 |

| Processing Properties | Metric | English | Comments |
|---------------------------|------------------|----------------|----------|
| Rear Barrel Temperature | 232 - 254 °C | 450 - 490 °F | |
| Middle Barrel Temperature | 243 - 266 °C | 470 - 510 °F | |
| Front Barrel Temperature | 260 - 271 °C | 500 - 520 °F | |
| Nozzle Temperature | 260 - 271 °C | 500 - 520 °F | |
| Melt Temperature | 266 - 277 °C | 510 - 530 °F | |
| Mold Temperature | 65.6 - 87.8 °C | 150 - 190 °F | |
| Drying Temperature | 121 °C | 250 °F | |
| Dry Time | 3 - 12 hour | 3 - 12 hour | |
| Moisture Content | <= 0.020 % | <= 0.020 % | |
| Injection Pressure | 5.52 - 12.4 MPa | 800 - 1800 psi | |
| Back Pressure | 0.483 - 1.03 MPa | 70.0 - 150 psi | |
| Shot Size | 40 - 60 % | 40 - 60 % | |
| Screw Speed | 40 - 70 rpm | 40 - 70 rpm | |

| Descriptive Properties | Value | Comments |
|------------------------|-------|----------|
|------------------------|-------|----------|

| Holding Pressure Descriptive Properties | 500 to 1000 psi Value | Comments |
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