

Entec Hylex® P1317FR Polycarbonate

Category : Polymer , Thermoplastic , Polycarbonate (PC) , Polycarbonate, Unreinforced, Flame Retardant

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_Entec-Hylex-P1317FR-Polycarbonate.php

Physical Properties	Metric	English	Comments
Density	1.24 g/cc	0.0448 lb/in ³	ASTM D792
Linear Mold Shrinkage	0.0050 - 0.0070 cm/cm	0.0050 - 0.0070 in/in	ASTM D955
Melt Flow	17 g/10 min @Load 1.20 kg, Temperature 300 °C	17 g/10 min @Load 2.65 lb, Temperature 572 °F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Tensile Strength at Break	60.0 MPa	8700 psi	ASTM D638
Elongation at Break	110 %	110 %	ASTM D638
Flexural Strength	96.5 MPa	14000 psi	ASTM D790
Flexural Modulus	2.48 GPa	360 ksi	ASTM D790
Izod Impact, Notched	5.34 J/cm	10.0 ft-lb/in	73°F, 0.125 in; ASTM D256

Thermal Properties	Metric	English	Comments
Deflection Temperature at 0.46 MPa (66 psi)	141 °C	285 °F	Unannealed; ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	129 °C	265 °F	Unannealed; ASTM D648
Flammability, UL94	V-0	V-0	0.0620 in, NA

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	243 - 266 °C	470 - 510 °F	
Middle Barrel Temperature	254 - 271 °C	490 - 520 °F	
Front Barrel Temperature	271 - 282 °C	520 - 540 °F	
Nozzle Temperature	266 - 277 °C	510 - 530 °F	

Melt Temperature Processing Properties	271 - 288 °C Metric	520 - 550 °F English	Comments
Mold Temperature	71.1 - 93.3 °C	160 - 200 °F	
Drying Temperature	121 °C	250 °F	
Dry Time	3 - 12 hour	3 - 12 hour	
Moisture Content	<= 0.020 %	<= 0.020 %	
Injection Pressure	6.21 - 12.4 MPa	900 - 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	600 to 1100 psi	

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