

PTS Tristar® PC-15R-113 15 MFI Clear Utility Grade Polycarbonate With Release

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

Material Notes:

Information provided by Polymer Technology and Services, LLC (PTS).

Order this product through the following link:

http://www.lookpolymers.com/polymer_PTS-Tristar-PC-15R-113-15-MFI-Clear-Utility-Grade-Polycarbonate-With-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 hours at 73°F; ASTM D570
Melt Flow	15 g/10 min @Load 1.20 kg, Temperature 300 °C	15 g/10 min @Load 2.65 lb, Temperature 572 °F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell R	120	120	ASTM D785
Tensile Strength, Yield	58.6 MPa @Thickness 3.17 mm	8500 psi @Thickness 0.125 in	ASTM D638
Elongation at Break	150 % @Thickness 3.17 mm	150 % @Thickness 0.125 in	ASTM D638
Flexural Yield Strength	89.6 MPa @Thickness 3.17 mm	13000 psi @Thickness 0.125 in	ASTM D790
Flexural Modulus	2.28 GPa @Thickness 3.17 mm	331 ksi @Thickness 0.125 in	ASTM D790
Izod Impact, Notched	6.41 J/cm @Thickness 3.17 mm	12.0 ft-lb/in @Thickness 0.125 in	ASTM D256

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (264 psi)	127 °C	261 °F	ASTM D648
Flammability, UL94	V-2 @Thickness 1.59 mm	V-2 @Thickness 0.0625 in	UL94

Optical Properties	Metric	English	Comments
Transmission, Visible	80 %	80 %	Clear grade, but transmission not quantified.

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	249 - 271 °C	480 - 520 °F	
Middle Barrel Temperature	260 - 271 °C	500 - 520 °F	
Front Barrel Temperature	271 - 288 °C	520 - 550 °F	
Nozzle Temperature	266 - 282 °C	510 - 540 °F	
Melt Temperature	277 - 293 °C	530 - 560 °F	
Mold Temperature	71.1 - 93.3 °C	160 - 200 °F	
Drying Temperature	121 °C	250 °F	
Dry Time	3 - 4 hour	3 - 4 hour	48 hours max.
Injection Pressure	68.9 - 124 MPa	10000 - 18000 psi	
Back Pressure	0.345 - 1.38 MPa	50.0 - 200 psi	
Clamp Pressure	27.6 - 68.9 MPa	4000 - 10000 psi	
Shot Size	40 - 60 %	40 - 60 %	
Screw Speed	40 - 70 rpm	40 - 70 rpm	

Descriptive Properties	Value	Comments
Injection Speed- Edge Gate	Slow to Medium	
Injection Speed- Tab Gate	Medium to Fast	
Injection Speed- Tunnel Gate	Fast	

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