

Ravago Manufacturing Americas Hylex® P1010LLT Polycarbonate

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

Material Notes:

Information provided by Ravago.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Ravago-Manufacturing-Americas-Hylex-P1010LLT-Polycarbonate.php

Physical Properties	Metric	English	Comments
Density	1.18 g/cc	0.0426 lb/in³	ASTM D792
Linear Mold Shrinkage	0.0050 - 0.0070 cm/cm	0.0050 - 0.0070 in/in	ASTM D955
Melt Flow	11 g/10 min @Load 1.20 kg, Temperature 300 °C	11 g/10 min @Load 2.65 lb, Temperature 572 °F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Tensile Strength at Break	55.2 MPa	8000 psi	ASTM D638
Elongation at Break	130 %	130 %	ASTM D638
Flexural Strength	82.7 MPa	12000 psi	ASTM D790
Flexural Modulus	2.14 GPa	310 ksi	ASTM D790
Izod Impact, Notched	7.47 J/cm	14.0 ft-lb/in	0.125 in; ASTM D256
	5.34 J/cm @Temperature -40.0 °C	10.0 ft-lb/in @Temperature -40.0 °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)	124 °C	255 °F	Unannealed; ASTM D648
Vicat Softening Point	143 °C	290 °F	ASTM D1525
Flammability, UL94	HB	HB	0.0590 in, NA

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	271 - 282 °C	520 - 540 °F	
Middle Barrel Temperature	277 - 288 °C	530 - 550 °F	

Processing Properties	Metric	English	Comments
Nozzle Temperature	277 - 299 °C	530 - 570 °F	
Melt Temperature	288 - 316 °C	550 - 600 °F	
Mold Temperature	76.7 - 93.3 °C	170 - 200 °F	
Drying Temperature	121 °C	250 °F	
Dry Time	3 - 12 hour	3 - 12 hour	
Moisture Content	<= 0.020 %	<= 0.020 %	
Injection Pressure	6.89 - 12.4 MPa	1000 - 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	700 to 1200 psi	

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