

Ravago Manufacturing Americas Hylex® P1318LLT 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-P1318LLT-Polycarbonate.php

Physical Properties	Metric	English	Comments
Density	1.18 g/cc	0.0426 lb/in³	ASTM D792
Linear Mold Shrinkage	0.0060 - 0.0080 cm/cm	0.0060 - 0.0080 in/in	ASTM D955
Melt Flow	18 g/10 min @Load 1.20 kg, Temperature 300 °C	18 g/10 min @Load 2.65 lb, Temperature 572 °F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Tensile Strength at Break	57.2 MPa	8300 psi	ASTM D638
Elongation at Break	110 %	110 %	ASTM D638
Flexural Strength	82.7 MPa	12000 psi	ASTM D790
Flexural Modulus	2.14 GPa	310 ksi	ASTM D790
Izod Impact, Notched	6.41 J/cm	12.0 ft-lb/in	0.125 in; ASTM D256
	3.74 J/cm @Temperature -30.0 °C	7.00 ft-lb/in @Temperature -22.0 °F	0.125in; 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	V-2	V-2	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	

Processing Properties	Metric	English	Comments
Nozzle Temperature	266 - 277 °C	510 - 530 °F	
Melt Temperature	271 - 288 °C	520 - 550 °F	
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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