

SABIC[®] PC RESIN PC1004R

POLYCARBONATE FOR GENERAL PURPOSE MOLDING MARKET

DESCRIPTION

PC1004R resin is a medium-low flow (MFR = 10 at 300°C/1.2kg), natural, FDA food contact complaint, heat stabilized, polycarbonate product with mold release designed for use in the general purpose molding market.

TYPICAL APPLICATIONS

PC1004R resin is a medium-low flow (MFR = 10 at 300°C/1.2kg), natural, FDA food contact complaint, heat stabilized, polycarbonate product with mold release designed for use in the general purpose molding market.

TYPICAL PROPERTY VALUES

Revision 20191031

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min ⁽¹⁾	63	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	>70	%	ASTM D 638
Tensile Modulus, 50 mm/min	2350	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	90	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D 790
Hardness, Rockwell R	120	-	ASTM D 785
Tensile Stress, yield, 50 mm/min	63	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	>70	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
Hardness, Rockwell R	120	-	ISO 2039-2
IMPACT			
Izod Impact, unnotched, 23°C	NB	J/m	ASTM D 4812
Izod Impact, notched, 23°C	800	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	65	J	ASTM D 3763
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	70	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	12	kJ/m ²	ISO 180/1A
THERMAL			
Vicat Softening Temp, Rate B/50	143	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm	138	°C	ASTM D 648
HDT, 1.82 MPa, 3.2 mm	127	°C	ASTM D 648
CTE, -40°C to 95°C, flow	7.E-05	1/°C	ASTM E 831
Thermal Conductivity	0.2	W/m-°C	ASTM C 177
Thermal Conductivity	0.2	W/m-°C	ISO 8302
CTE, 23°C to 80°C, flow	7.E-05	1/°C	ISO 11359-2

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Ball Pressure Test, 125°C +/- 2°C	Passes	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	143	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	138	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	127	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.2	-	ASTM D 792
Water Absorption, equilibrium, 23C	0.35	%	ASTM D 570
Mold Shrinkage on Tensile Bar, flow	0.5 – 0.7	%	SABIC method
Mold Shrinkage, flow, 3.2 mm ⁽²⁾	0.5 – 0.7	%	SABIC method
Melt Flow Rate, 300°C/ 1.2 kgf	10	g/ 10 min	ASTM D 1238
Density	1.2	g/cm ³	ISO 1183
Water Absorption, (23°C/sat)	0.35	%	ISO 62
Melt Volume Rate, MVR at 300°C/ 1.2 kg	9	cm ³ /10 min	ISO 1133
OPTICAL			
Light Transmission, 2.54 mm	88 – 90	%	ASTM D 1003
Haze, 2.54 mm	<0.8	%	ASTM D 1003
Refractive Index	1.586	-	ASTM D542
Refractive Index	1.586	-	ISO 489
ELECTRICAL			
Volume Resistivity	>1.E+15	Ohm-cm	ASTM D 257
Dielectric Strength, 1.6 mm	27	kV/mm	ASTM D 149
Relative Permittivity, 60 Hz	3	-	ASTM D 150
Relative Permittivity, 1 MHz	3	-	ASTM D 150
Dissipation Factor, 60 Hz	0.001	-	ASTM D 150
Dissipation Factor, 1 MHz	0.01	-	ASTM D 150
Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Dielectric Strength, 1.6 mm	27	kV/mm	IEC 60243-1
Relative Permittivity, 60 Hz	3	-	IEC 60250
Relative Permittivity, 1 MHz	3	-	IEC 60250
Dissipation Factor, 60 Hz	0.001	-	IEC 60250
Dissipation Factor, 1 MHz	0.01	-	IEC 60250
FLAME CHARACTERISTICS			
UL Recognized, 94V-2 Flame Class Rating ⁽³⁾	1.6	mm	UL 94
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	2 – 4	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	280 – 310	°C	
Nozzle Temperature	270 – 290	°C	
Front - Zone 3 Temperature	280 – 310	°C	
Middle - Zone 2 Temperature	270 – 290	°C	
Rear - Zone 1 Temperature	260 – 280	°C	
Hopper Temperature	60 – 80	°C	
Mold Temperature	80 – 110	°C	

- (1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.
- (2) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.
- (3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

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