

## PC-1220U

Polycarbonate resin

### General Information

#### Description

PC-1220U is a low viscosity, clear polycarbonate, which is suitable for outdoor injection applications. PC-1220U have UV stabilized ingredients to prevent degradation of final PC products from lights.

#### Applications

OUTDOOR AND LIGHT EXPOSED INJECTION PRODUCTS

### Typical properties<sup>1</sup>

	Test Method	Typical value	Unit
<b>Physical</b>			
Melt Flow Index, 300 °C, 1.2kg	ASTM D1238	22	g/10min
Specific Gravity	ASTM D792	1.20	
Mold Shrinkage	ASTM D955	0.5-0.7	%
<b>Mechanical</b>			
Tensile Strength, yield, 50mm/min	ASTM D638	630	kgf/cm <sup>2</sup>
Tensile Elongation, break, 50mm/min	ASTM D638	> 100	%
Flexural Strength, yield, 10mm/min	ASTM D790	920	kgf/cm <sup>2</sup>
Flexural Modulus, 10mm/min	ASTM D790	24,000	kgf/cm <sup>2</sup>
IZOD Impact Strength, notched, 23 °C, 1/8"	ASTM D256	70	kg-cm/cm
	ASTM D256	-	kg-cm/cm
<b>Thermal</b>			
Heat Distortion Temp. 4.6kgf/cm <sup>2</sup>	ASTM D648	139	°C
	ASTM D648	128	°C
Vicat Softening Temp. Rate B/50	ASTM D1525	150	°C
<b>Optical</b>			
Light Transmittance	ASTM D1003	89	%
Haze	ASTM D1003	< 0.8	%
Refractive Index	ASTM D542	1.585	

### Notes

ISO 9001, 14001, /TS 16949

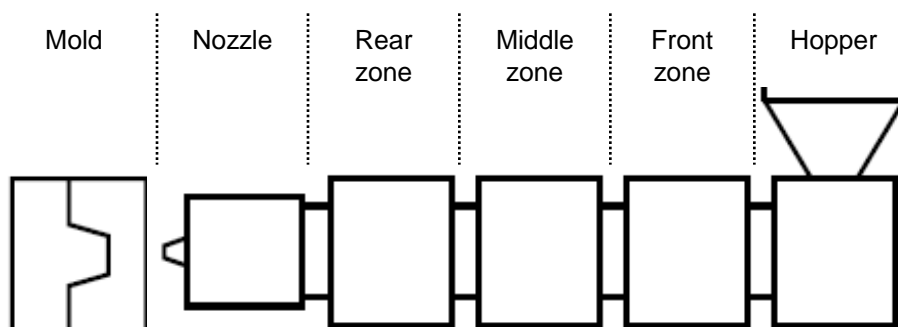
<sup>1</sup> Typical properties : these are not to be construed as specifications.

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### Processing guides<sup>1</sup>

	Typical value	Unit
<b>Drying condition</b>		
Drying temperature	120	°C
Drying time	4	hr
Maximum moisture content	0.02	%
<b>Injection molding</b>		
Melt temperature	290 ~ 310	°C
Nozzle temperature	280 ~ 300	°C
Barrel	Rear zone	290 ~ 310
	Middle zone	280 ~ 300
	Front zone	270 ~ 290
Hopper temperature	60 ~ 80	°C
Mold temperature	60 ~ 90	°C



### Recycling

Sprues and runners can be reground with virgin resin within the ratio of 20%. Care must be taken to ensure that the regrind is free from impurities and regrind should not be used in applications where impact performance and/or agency compliance are required.

### Notes

ISO 9001, 14001, /TS 16949

<sup>1</sup> Processing guides : Typical processing parameters are noted. Actual processing conditions will depend on machine size, mold design, material residence time, shot size, etc.