

# PCL-2000

Polycarbonate compound resin

## General information

### Description

Easy mold release  
High ductility in low temperature  
Available in opaque color only

### Applications

Multi purpose grade (electric/electronic housings, etc.)

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

	Test method	Typical value	Unit
<b>Physical</b>			
Melt Flow Index, 300°C, 1.2 kg	ASTM D1238	-	g/10 min
Specific Gravity	ASTM D792	1.20	
Mold Shrinkage	ASTM D955	0.5~0.7	%
<b>Mechanical</b>			
Tensile Strength, yield, 50 mm/min	ASTM D638	580	kg <sub>f</sub> /cm <sup>2</sup>
Tensile Elongation, break, 50 mm/min	ASTM D638	>100	%
Flexural Strength, yield, 10 mm/min	ASTM D790	820	kg <sub>f</sub> /cm <sup>2</sup>
Flexural Modulus, 10 mm/min	ASTM D790	22,000	kg <sub>f</sub> /cm <sup>2</sup>
IZOD Impact Strength, notched, 23°C, 1/8"	ASTM D256	70	kg <sub>f</sub> ·cm/cm
	ASTM D256	-	kg <sub>f</sub> ·cm/cm
	ASTM D256	55	kg <sub>f</sub> ·cm/cm
<b>Thermal</b>			
Heat Distortion Temp.	4.6 kg <sub>f</sub> /cm <sup>2</sup>	ASTM D648	- °C
	18.6 kg <sub>f</sub> /cm <sup>2</sup>	ASTM D648	127 °C
Vicat Softening Temp.	Rate B/50	ASTM D1525	- °C
<b>Flammability</b>			
UL94 HB	UL94	1.5	mm
UL94 HB	UL94	3.0	mm

## Notes

ISO 9001, 14001, TS 16949

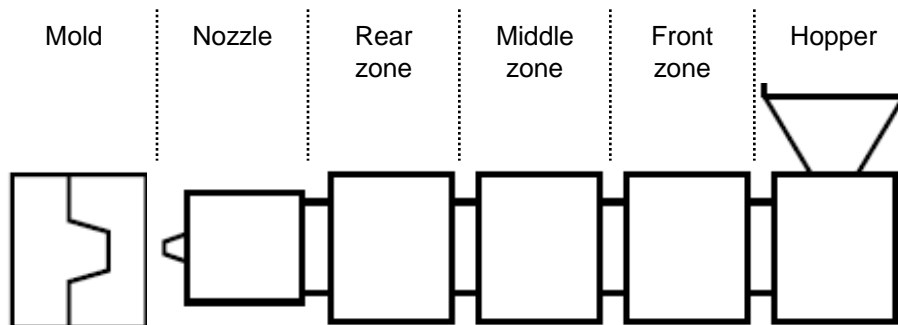
<sup>1</sup> Typical properties : these are not to be construed as specifications.

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

	Typical value	Unit	
<b>Drying condition</b>			
Drying temperature	100	°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	°C
	Middle zone	280 ~ 300	°C
	Front zone	270 ~ 290	°C
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

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<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.