LOTTE CHEMICAL

# PC-1100U

**Polycarbonate resin**

## General Information

### Description

**Medium viscosity**
**UV-stability, Mold release**

### Applications

**Outdoor and light exposed extrusion & injection product**

## Typical properties[1]

| | Test Method | Typical value | Unit |
|---|---|---|---|
| **Physical** | | | |
| **Melt Flow Index,** 300℃, 1.2kg | ASTM D1238 | **10** | g/10min |
| **Specific Gravity** | ASTM D792 | **1.20** | |
| **Mold Shrinkage** | ASTM D955 | **0.5~0.7** | % |
| **Mechanical** | | | |
| **Tensile Strength,** yield, 50mm/min | ASTM D638 | **630** | $kgf/cm^2$ |
| **Tensile Elongation,** break, 50mm/min | ASTM D638 | **>100** | % |
| **Flexural Strength,** yield, 10mm/min | ASTM D790 | **920** | $kgf/cm^2$ |
| **Flexural Modulus,** 10mm/min | ASTM D790 | **24,000** | $kgf/cm^2$ |
| **IZOD Impact Strength,** notched, 23 ℃, 1/8” | ASTM D256 | **80** | kg·cm/cm |
| notched, 23 ℃, 1/4” | ASTM D256 | **-** | kg·cm/cm |
| **Thermal** | | | |
| **Heat Distortion Temp.** 4.6kgf/$cm^2$ | ASTM D648 | **143** | ℃ |
| 18.6kgf/$cm^2$ | ASTM D648 | **132** | ℃ |
| **Vicat Softening Temp.** Rate B/50 | ASTM D1525 | **150** | ℃ |
| **Optical** | | | |
| **Light Transmittance** | ASTM D1003 | **89** | % |
| **Haze** | ASTM D1003 | **< 0.8** | % |
| **Refractive Index** | ASTM D542 | **1.585** | |

## Notes

ISO 9001, 14001, /TS 16949

[1] Typical properties : these are not to be construed as specifications.



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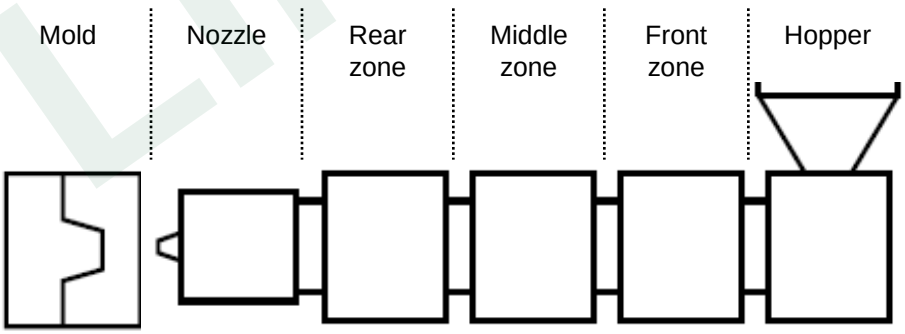
## Processing guides[1]

| | | Typical value | Unit |
|---|---|---|---|
| **Drying condition** | | | |
| **Drying temperature** | | **120** | ℃ |
| **Drying time** | | **4** | hr |
| **Maximum moisture content** | | **0.02** | % |
| **Injection molding** | | | |
| **Melt temperature** | | **290 ~ 310** | ℃ |
| **Nozzle temperature** | | **280 ~ 300** | ℃ |
| **Barrel** | **Rear zone** | **290 ~ 310** | ℃ |
| | **Middle zone** | **280 ~ 300** | ℃ |
| | **Front zone** | **270 ~ 290** | ℃ |
| **Hopper temperature** | | **60 ~ 80** | ℃ |
| **Mold temperature** | | **60 ~ 90** | ℃ |




## 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

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



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