LOTTE CHEMICAL

کوثرشیمی
Kosar Shimi
+9821 - 43462000
info@kosar.co
www.kosar.co

PC-1100U

Polycarbonate resin

General Information

● Description

PC-1100U is a medium viscosity, clear polycarbonate, which is suitable for outdoor injection applications. PC-1100U have UV stabilized ingredients to prevent degradation of final PC products from lights.

● Applications

SHEET EXTRUSION & INJECTION GRADE

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	℃

Mold	Nozzle	Rear zone	Middle zone	Front zone	Hopper
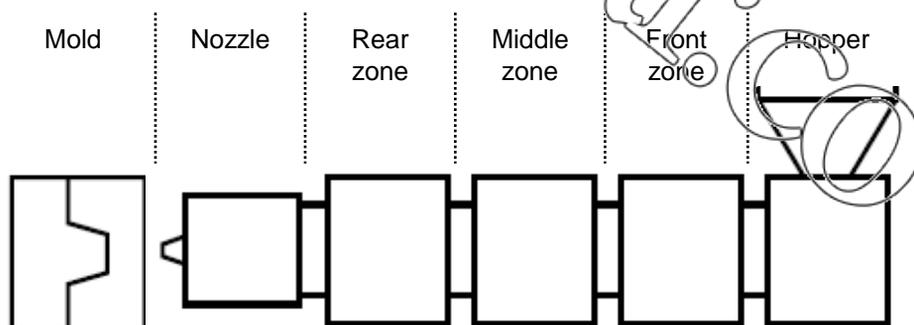
Recycling

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.