PC-1100U
Polycarbonate resin

General Information

Description
Medium viscosity
UV-stability, Mold release

Applications
Outdoor and light exposed extrusion & injection product

Typical properties

<table>
<thead>
<tr>
<th>Test Method</th>
<th>Typical value</th>
<th>Unit</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Physical</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Melt Flow Index, 300 ℃, 1.2kg</td>
<td>ASTM D1238</td>
<td>10</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>ASTM D792</td>
<td>1.20</td>
</tr>
<tr>
<td>Mold Shrinkage</td>
<td>ASTM D955</td>
<td>0.5~0.7</td>
</tr>
<tr>
<td><strong>Mechanical</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Tensile Strength, yield, 50mm/min</td>
<td>ASTM D638</td>
<td>630</td>
</tr>
<tr>
<td>Tensile Elongation, break, 50mm/min</td>
<td>ASTM D638</td>
<td>&gt;100</td>
</tr>
<tr>
<td>Flexural Strength, yield, 10mm/min</td>
<td>ASTM D790</td>
<td>920</td>
</tr>
<tr>
<td>Flexural Modulus, 10mm/min</td>
<td>ASTM D790</td>
<td>24,000</td>
</tr>
<tr>
<td>IZOD Impact Strength, notched, 23 ℃, 1/8&quot;</td>
<td>ASTM D256</td>
<td>80</td>
</tr>
<tr>
<td>IZOD Impact Strength, notched, 23 ℃, 1/4&quot;</td>
<td>ASTM D256</td>
<td>-</td>
</tr>
<tr>
<td><strong>Thermal</strong></td>
<td></td>
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<tr>
<td>Heat Distortion Temp.</td>
<td>4.6kgf/cm²</td>
<td>ASTM D648</td>
</tr>
<tr>
<td></td>
<td>18.6kgf/cm²</td>
<td>ASTM D648</td>
</tr>
<tr>
<td>Vicat Softening Temp.</td>
<td>Rate B/50</td>
<td>ASTM D1525</td>
</tr>
<tr>
<td><strong>Optical</strong></td>
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<tr>
<td>Light Transmittance</td>
<td>ASTM D1003</td>
<td>89</td>
</tr>
<tr>
<td>Haze</td>
<td>ASTM D1003</td>
<td>&lt; 0.8</td>
</tr>
<tr>
<td>Refractive Index</td>
<td>ASTM D542</td>
<td>1.585</td>
</tr>
</tbody>
</table>

Notes
ISO 9001, 14001, /TS 16949

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

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**PC-1100U**

**Polycarbonate resin**

### Processing guides

<table>
<thead>
<tr>
<th>Drying condition</th>
<th>Typical value</th>
<th>Unit</th>
</tr>
</thead>
<tbody>
<tr>
<td>Drying temperature</td>
<td>120</td>
<td>℃</td>
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<tr>
<td>Drying time</td>
<td>4</td>
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</tr>
<tr>
<td>Maximum moisture content</td>
<td>0.02</td>
<td>%</td>
</tr>
</tbody>
</table>

#### 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 ~ 80 | ℃ |

### 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

* 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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