



TCM-PC

Polycarbonate white - EG19236

General Information

Tuesday, February 25, 2020

Material Status	<ul style="list-style-type: none">Commercial: Active	<ul style="list-style-type: none">Europe
Availability	<ul style="list-style-type: none">Africa & Middle EastAsia Pacific	<ul style="list-style-type: none">Latin AmericaNorth America

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	ASTM D955
Molding Shrinkage - Across Flow (3.20 mm)	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	2260	MPa	ASTM D638
Tensile Strength ² (Yield)	62.8	MPa	ASTM D638
Tensile Strength ² (Break)	62.8	MPa	ASTM D638
Tensile Elongation ² (Break)	110	%	ASTM D638
Flexural Modulus ³	2260	MPa	ASTM D790
Flexural Strength ³	90.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact 23°C, 3.18 mm	850	J/m	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 0.45 MPa, Unannealed, 6.40 mm	137	°C	ASTM D648
Deflection Temperature Under Load 1.8 MPa, Unannealed, 6.40 mm	127	°C	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.8 to 3.0 mm)	V-0		UL 94

TACOMA LIMITED COMPANY

Add: C26 - HH4 - VietHung Township - LongBien Distric - Hanoi City

Factory : 89 - Lamtien stress - Donganh Distict - Hanoi City - Vietnam

Phone: +84 969 161 555

Email: tacoma9102@gmail.com

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	80	°C
Hot Air Dryer	80	°C
Drying Time		
Desiccant Dryer	3.0 to 4.0	hr
Hot Air Dryer	4.0 to 6.0	hr
Suggested Max Moisture	0.040	%
Rear Temperature	100 to 260	°C
Middle Temperature	260 to 270	°C
Front Temperature	260 to 280	°C
Nozzle Temperature	280	°C
Mold Temperature	80 to 110	°C
Injection Pressure	98.1	MPa
Back Pressure	0.981 to 1.96	MPa
Screw Speed	30 to 50	rpm

Injection Notes

Hot Runner Temperature: 280°C

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