



Material Datasheet 11

Trade Name : Zinconate PC1100R

Material : Polycarbonate (PC)

Color Code. : All Colors

Color : All Colors



Properties	Test Method	Test Condition	Unit	Typical Value
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Physical

Specific Gravity	ASTM D792	23°C	g/cm ³	1.20 - 1.25
Mold Shrinkage	ASTM D995	3.2mm	%	0.5 - 0.8
Water Absorption	ASTM D570	23°C	%	0.3

Rheological

Melt Flow Index	ASTM D1238	220°C - 5kg	g/10min	18 - 22
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Mechanical

Tensile Strength	ASTM D638	23°C	MPa	2200 - 2400
Flexural Modulus	ASTM D790B	23°C	MPa	2200 - 2400
Izod Impact	ASTM D256	V-notched, 1/8"	kg.cm/cm	40 - 42
Izod Impact (-30°C)	ASTM D256	V-notched, 1/8"	kg.cm/cm	12 - 14

Thermal

Deflection Temperature Under Load	ASTM D648	Unannealed	°C	130 - 135
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Recommended Injection Molding Parameters

Barrel Temperature	Value	Mold Temperature	Value
Front	280 - 290°C	Fixed Half	80 - 120°C
Middle	260 - 280°C	Moving Half	80 - 120°C
Rear	250 - 260°C	Drying Hour	2 - 3
Nozzle	280 - 300°C	Drying Temperature	110 - 120°C
		Melt Temperature	280 - 320°C

The data are intended as a general guide only and do not necessarily represent results that may be obtained elsewhere. For further information, please contact or fax to Zinco Colours Technical Services Department.



Polycarbonate Source

Our PC sources are mainly from Indonesian water bottles and automotive lighting which are cleaner, more reliable and consistent.

Some rejected product samples were collected directly from the factory.

5-Gallon Water Bottle



500ml Water Bottle



PC Gallon Water Bottles



Headlight

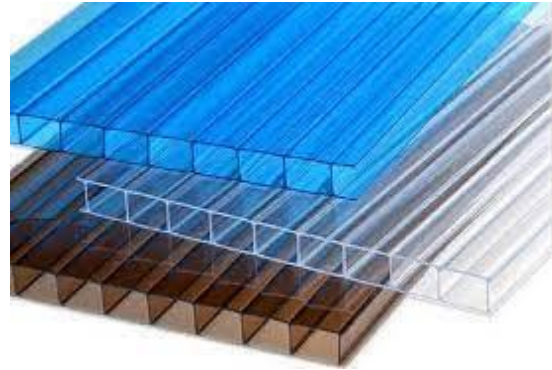




Lighting Cover



PC Sheets



PC Milk Bottles

