

**PRODUCT INFORMATION**

Material: PC/Polyester Alloy **Effective Date:** January-07
Grade: PC/TP-FR2
Description: Flame Retardant, High Impact, Excellent Chemical Resistance, Weatherable

TYPICAL PROPERTIES	VALUE	UNIT	TEST METHOD
Physical*			
Melt Flow Rate 265C/2.16kg	5-12	g/10 min	ASTM D1238
Specific Gravity	1.25		ASTM D792
Mold Shrinkage	6-9	E-3 in/in	ASTM D955
Mechanical*			
Tensile Strength, Break	7,000	psi	ASTM D638
Tensile Strength, Yield	7,300	psi	ASTM D638
Flexural Strength	11,000	psi	ASTM D790
Flexural Modulus	290	psi x 1000	ASTM D790
Impact*			
Notched Izod Impact Strength	13.0	ft-lb/in.	ASTM D256
	7.0 (-40 F)		
Gardner Falling Dart Impact (minimum)	320	in-lbs.	ASTM D3029
Thermal*			
HDT @ 66 psi	195	°F	ASTM D648
HDT @ 264 psi	180	°F	ASTM D648
Flammability			
UL File Number, USA	E113219		
UL 94 rating	V-0 (0.125 in)		
	V-0 (0.0625 in)		

* All physical, mechanical and thermal testing conducted on 1/8-inch thick, un-pigmented, test samples. Nylon grades are tested dry as molded(DAM) and foam grades tested with un-foamed parts.

TYPICAL PROCESSING CONDITIONS**Processing Method: Injection Molding**

Drying Temperature	220-230	°F	
Drying Time	4-6	Hours	Do not exceed 8 hours
Melt Temperature	475-525	°F	
Mold Temperature	150-190	°F	
Front Zone	500-540	°F	
Middle Zone	490-530	°F	
Rear Zone	480-520	°F	

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