

**PRODUCT INFORMATION**

Material: Polycarbonate
Grade: PC-HM-FR1
Description: 10% Glass Reinforced, Flame Retardant

Effective Date: June-03

TYPICAL PROPERTIES	VALUE	UNIT	TEST METHOD
Physical*			
Melt Flow Rate 300C/1.2kg	5-12	g/10 min	ASTM D1238
Specific Gravity	1.26		ASTM D792
Mold Shrinkage	2-5	E-3 in/in	ASTM D955
Mechanical*			
Tensile Strength, Break	9,500	psi	ASTM D638
Tensile Strength, Yield	8,100	psi	ASTM D638
Flexural Strength	14,900	psi	ASTM D790
Flexural Modulus	490	psi x 1000	ASTM D790
Impact*			
Notched Izod Impact Strength	2.0	ft-lb/in.	ASTM D256
Gardner Falling Dart Impact (minimum)	NA	in-lbs.	ASTM D3029
Thermal*			
HDT @ 66 psi	290	°F	ASTM D648
HDT @ 264 psi	280	°F	ASTM D648
Flammability			
UL File Number, USA	E113219		
UL 94 rating	V-0, 5VA (0.125 in)		
	V-0 (0.0625 in)		

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

Nylon grades are

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

Drying Temperature	245-255	°F	
Drying Time	3-4	Hours	Do not exceed 8 hours
Melt Temperature	575-625	°F	
Mold Temperature	180-240	°F	
Front Zone	600-640	°F	
Middle Zone	580-620	°F	
Rear Zone	560-600	°F	

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