

**PRODUCT INFORMATION**

Material: Polycarbonate
Grade: PC-IM2
Description: Impact Modified, Medium Flow

Effective Date: June-04

TYPICAL PROPERTIES	VALUE	UNIT	TEST METHOD
Physical*			
Melt Flow Rate 300C/1.2kg	9-16	g/10 min	ASTM D1238
Specific Gravity	1.19		ASTM D792
Mold Shrinkage	5-7	E-3 in/in	ASTM D955
Mechanical*			
Tensile Strength, Break	7,800	psi	ASTM D638
Tensile Strength, Yield	7,500	psi	ASTM D638
Flexural Strength	11,500	psi	ASTM D790
Flexural Modulus	300	psi x 1000	ASTM D790
Impact*			
Notched Izod Impact Strength	15.0 13 (0 F)	ft-lb/in.	ASTM D256
Gardner Falling Dart Impact (minimum)	320	in-lbs.	ASTM D3029
Thermal*			
HDT @ 66 psi	255	°F	ASTM D648
HDT @ 264 psi	245	°F	ASTM D648
Flammability			
UL File Number, USA	not listed		
UL 94 rating		HB (0.125 in) HB (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	525-575	°F	
Mold Temperature	160-200	°F	
Front Zone	530-570	°F	
Middle Zone	510-550	°F	
Rear Zone	490-530	°F	

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