



Persian Gulf Petrochemical Industry Company
Khuzestan Petrochemical Company
(KZPC)

POLYCARBONATE

PGPC-0710UR

Medium Viscosity, Bluish Polycarbonate
UV-Stability, Mold Release

PROPERTIES	TYPICAL VALUES	UNIT	TEST METHODS
PHYSICAL			
Melt Flow Index (1.2 Kg,300 °C)	7.1 – 10	g/10 min	ASTM D1238
Melt volume Rate(1.2 Kg,300 °C)	6.5 – 9.2	Cm ³ /10 min	ASTM D1238
Density (25 °C)	1.2	g/cm ²	ASTM D792
Mold Shrinkage	0.5 – 0.7	%	ASTM D955
MECHANICAL			
Tensile Strength at Yield	62 – 66	Mpa	ASTM D638
Tensile Elongation at Break	120 – 140	%	ASTM D638
Tensile Modulus	2800 – 2900	Mpa	ASTM D638
Izod Impact Strength (Notched, 23 °C)	80 – 84	Kj/m ²	ASTM D256
THERMAL			
Vicat Softening Temperature (50 N , 50C/h)	141 – 145	°C	ASTM D1525
Coefficient of Thermal Expansion	0.4 – 0.7	10 ⁻⁵ /K	ASTM D696
Burning Behavior (1.6mm)	V2	--	UL-94
OPTICAL			
Gloss	---	%	ASTM D523
Haze(Thickness 2mm)	≤ 0.8	%	ASTM D1003
Transmittance(Thickness 2mm)	≥ 90	%	ASTM D1003
Yellow Index	(-12) – (-8)		ASTM D1003
ELECTRICAL			
Dielectric Strength	≥ 18	Kv/mm	ASTM D149
Volume Resistivity	1E+14	Ohm-m	ASTM D257
Surface Resistivity	1E+16	ohm	ASTM D257
Dissipation Factor	90	1MHZ	ASTM D150

Applications: Outdoor Application, Injection Products

Packing: Each Pallet is 1250 kg ; 50 bags of 25 kg on one pallet

Licensors: Salzgitter , Germany

Handling and Storage :

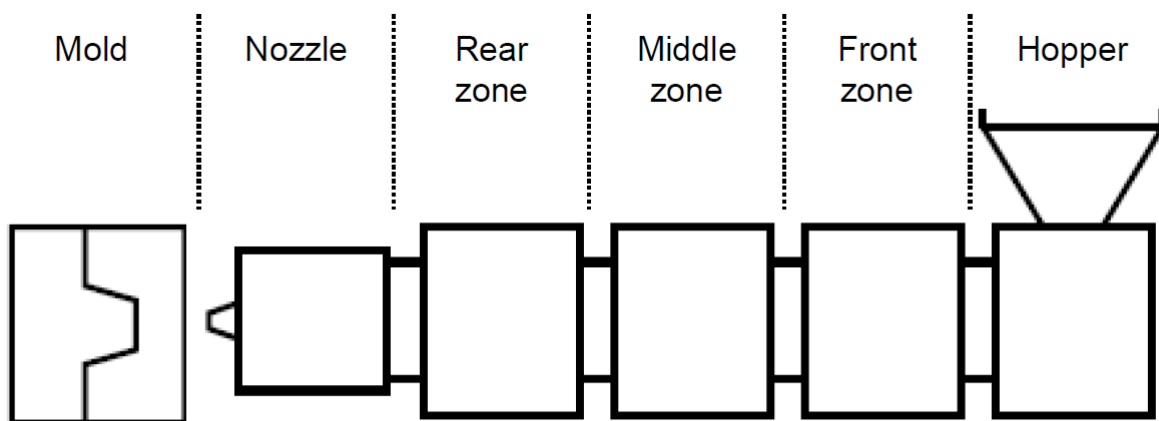
Handling: Polycarbonate can release monomer vapors or gases when heated to high temperatures during processing, cutting or machining.

Storage: The maximum recommended storage temperature for Polycarbonate is 80°C. This material is not Hazardous under normal storage conditions. However, all material of this type release some monomer vapors or gases when stored for prolonged period at elevated temperature. Avoid temperature extremes during storage; ambient temperature preferred. Do not store flammable material together with Polycarbonate.

PROCESSING GUIDES

DRYING CONDITION

	TYPICAL VALUE	UNIT
DRY TEMPERATURE	120	°C
DRYING TIME	4	hr
MAXIMUM MOISTURE CONTENT	0.02	%
INJECTION MOLDING		
MELT TEMPERATURE	280 – 300	°C
NOZZLE TEMPERATURE	290 – 300	°C
BARREL REAR ZONE TEMPERATURE	270 – 280	°C
BARREL MIDDLE ZONE TEMPERATURE	280 – 290	°C
BARREL FRONT ZONE TEMPERATURE	290 – 300	°C
HOPPER TEMPERATURE	60 – 80	°C
MOLD TEMPERATURE	60 – 90	°C



NOTE:TYPICAL PROCESSING ARE NOTED. ACTUAL PROCESSING CONDITIONS WILL DEPEND ON MACHINE SIZE,MOLD DESIGN,MATERIAL RESIDENCE TIME,SHOT SIZE,ETC.

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