

**Integra™ PC-5025 R 0002**

PolySource, LLC - Polycarbonate

## General Information

**Product Description**

PC, Medium Flow, FDA, Mold Release, Blue Tint

**General**

Material Status	• Commercial: Active
Availability	• North America
Features	• Good Mold Release • Medium Flow
Agency Ratings	• FDA
Appearance	• Blue

 Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	Internal Method
Water Absorption (Equilibrium, 73°F, 50% RH)	0.35	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	349000	psi	ASTM D638
Tensile Strength (Yield)	8900	psi	ASTM D638
Tensile Strength (Break)	9900	psi	ASTM D638
Tensile Elongation (Yield)	7.0	%	ASTM D638
Tensile Elongation (Break)	130	%	ASTM D638
Flexural Modulus <sup>2</sup> (2.00 in Span)	339000	psi	ASTM D790
Flexural Strength <sup>2</sup> (Yield, 2.00 in Span)	14100	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	15	ft·lb/in	ASTM D3763
Unnotched Izod Impact (73°F)	60	ft·lb/in	ASTM D4812
Tensile Impact Strength <sup>3</sup>	275	ft·lb/in <sup>2</sup>	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed, 0.250 in)	280	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed, 0.250 in)	270	°F	ASTM D648
CLTE - Flow (-40 to 100°F)	3.8E-5	in/in/°F	ASTM E831
CLTE - Transverse (-40 to 100°F)	3.7E-5	in/in/°F	ASTM E831

## Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	520 to 560	°F
Middle Temperature	540 to 580	°F
Front Temperature	560 to 600	°F
Nozzle Temperature	550 to 590	°F
Processing (Melt) Temp	560 to 600	°F
Mold Temperature	160 to 200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm



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<sup>1</sup> Typical properties: these are not to be construed as specifications.

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<sup>2</sup> 0.050 in/min

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<sup>3</sup> Type S

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