

Integra™ PC-75024 UV BK-4000

PolySource, LLC - Polycarbonate

General Information

Product Description

Polycarbonate, UV Stabilized, Flame Retardant, Black

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Flame Retardant • UV Stabilizer
Features	• Flame Retardant • UV Stabilized
Appearance	• Black

 Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	14	g/10 min	ASTM D1238
Molding Shrinkage - Flow	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	9400	psi	ASTM D638
Tensile Elongation (Break)	100	%	ASTM D638
Flexural Modulus	320000	psi	ASTM D790
Flexural Strength	13000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	13	ft·lb/in	ASTM D256
Gardner Impact ² (73°F)	400	in·lb	ASTM D5420
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed, 0.125 in)	277	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed, 0.125 in)	265	°F	ASTM D648
Vicat Softening Temperature	304	°F	ASTM D1525 ³
RTI Elec	176	°F	UL 746B
RTI Imp	176	°F	UL 746B
RTI Str	176	°F	UL 746B
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	V-2		
0.13 in	V-2		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	230	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	500 to 540	°F
Middle Temperature	500 to 540	°F
Front Temperature	500 to 540	°F
Nozzle Temperature	480 to 520	°F
Mold Temperature	180 to 210	°F
Injection Rate	Moderate-Fast	
Back Pressure	0.00 to 50.0	psi
Screw Speed	40 to 70	rpm



¹ Typical properties: these are not to be construed as specifications.

² N.F.E.

³ Rate B (120°C/h), Loading 2 (50 N)

