

Technical Data Sheet

Polyflam PC-FR0EF BK2054BLK

Polycarbonate

Product Description

Polycarbonate, UL Recognized 94 V-0, 94 5VA Elevated RTI - 105°C

Appearance

Colors Available

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Flow Rate, (300 °C/2.16 kg)	12	g/10 min	ASTM D1238
Impact			
Notched Izod Impact, (23 °C, 3.18 mm)	530	J/m	ASTM D256
Thermal			
RTI Elec	105	°C	UL 746B
RTI Imp	105	°C	UL 746B
RTI Str	105	°C	UL 746B
UL Information			
Flame Rating			
(1.5 mm)	V-0		UL 94
(3.0 mm)	5VA		UL 94
UL File Number	E51193		

Injection Parameters	Nominal Value	Units
Drying Temperature	121	°C
Suggested Max Moisture	<0.020	%
Nozzle Temperature	249 to 288	°C
Screw Speed	40 to 75	rpm
Processing (Melt) Temp	249 to 288	°C
Front Temperature	249 to 288	°C
Middle Temperature	249 to 288	°C
Rear Temperature	249 to 277	°C
Back Pressure	<0.689	MPa
Mold Temperature	71 to 104	°C