



Phone: (517) 295-4196 Fax: (517) 295-4918

Technical Data Sheet

LCA® PC 120 Type

Polycarbonate

	Value / Measure		Test Methods
Physical Properties			
	English Units (ISO)	Metric Units	
Melt Flow Rate @ 300 / 1.2	15 g/10 min		ASTM D-1238
Density	1.2 g/cm ³	1.2 g/cm ³	ASTM D-792
Linear Mold Shrinkage	0.005 - 0.007 in/in		ASTM D-955
Mechanical Properties			
Izod Impact - Notched	13 ft-lb/in (kJ/m)	695 J/m	ASTM D-256
Tensile Strength @ Yield	9,000 psi (Mpa)	62 MPa	ASTM D-638
Tensile Strength @ Break	10,000 psi (Mpa)	69 MPa	ASTM D-638
Tensile Elongation @ Yield	6.5 %	6.5 %	ASTM D-638
Tensile Elongation @ Break	140 %	140 %	ASTM D-638
Flexural Strength @ Yield	13,900 psi (Mpa)	96 MPa	ASTM D-790
Flexural Stress @ Break	psi (Mpa)	0 MPa	ASTM D-790
Flexural Stress @ 5% Strain	psi (Mpa)	0 MPa	ASTM D-790
Flexural Modulus	335,000 psi (Mpa)	2,311 MPa	ASTM D-790
Thermal Properties			
DTUL @ 66 psi (455 kPa)	275 Deg. F	135 Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	265 Deg. F	129 Deg. C	ASTM D-648
Vicat Softening Temperature	305 Deg. F	152 Deg. C	ASTM D-1525

All tests are performed on dry as molded ASTM (ISO) test bars.

General Product Type Information

Flame Rating (3.0 mm)	V2	V2	UL94
-----------------------	----	----	------

The property values listed above have been obtained using laboratory controlled test methods. They are offered without guarantee since conditions under which the product is used are beyond our control. Therefore, Uniplas, Inc. disclaims any liability for loss or damage incurred in connection with the use of this product.

Uniplas, Inc. 1145 Sutton St. Howell, MI 48843



Phone: (517) 295-4196 Fax: (517) 295-4918

Technical Data Sheet

LCA® PC 120 Type Polycarbonate

Typical Processing Conditions		
Process Variable	Description	Values
Temperatures		F C
Barrel	Rear	520 - 560
	Center	540 - 580
	Front	560 - 600
	Nozzle	550 - 600
	Mold	160 - 200
<hr/>		
Drying		
Type		Dehumidifier
Temperature		245° - 255°F
Time		3 - 4 hours
Maximum Dry Time		8 hours
<hr/>		
Special Requirements		

Optimum processing conditions will depend on such factors as machine size, screw design, part dimension, mold design, runner and gate design, and material residence time. These recommendations are intended only as a guide to achieve stable processing and good part quality.

Uniplas, Inc. 1145 Sutton St. Howell, MI 48843