



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

Technical Data Sheet

LCA® PC/PBT 1731 Type

Polycarbonate/Polybutylene Terephthalate Unfilled

Typical Compound Properties	Value / Measure		Test Methods
Physical Properties			
	English Units (ISO)	Metric Units	
Melt Flow Rate @ 300°/1.2 kg	18 g/10 min		ASTM D-1238
Density	1.19 g/cm ³	1.19 g/cm ³	ASTM D-792
Ash Content	%	0 %	ASTM D-5630
Mechanical Properties			
Izod Impact - Notched	12 ft-lb/in (kJ/m ²)	642 J/m	ASTM D-256
Tensile Strength @ Yield	7,100 psi (Mpa)	49 MPa	ASTM D-638
Tensile Strength @ Break	psi (Mpa)	0 MPa	ASTM D-638
Tensile Elongation @ Yield	%	0 %	ASTM D-638
Tensile Elongation @ Break	%	0 %	ASTM D-638
Flexural Strength @ Yield	13,000 psi (Mpa)	90 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	300,000 psi (Mpa)	2,070 MPa	ASTM D-790
Thermal Properties			
DTUL @ 66 psi (455 kPa)	Deg. F	Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	205 Deg. F	96 Deg. C	ASTM D-648
Vicat Softening Temperature	Deg. F	Deg. C	ASTM D-1525

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

General Product Type Information

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.

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Typical Processing Conditions		
Process Variable	Description	Values
Temperatures		F C
Barrel	Rear	450 - 480
	Center	460 - 490
	Front	460 - 490
	Nozzle	475 - 500
	Mold	150 - 200
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Drying		
Type		Dehumidifier
Temperature		250°F - 280°F
Time		3 - 4 hours
Suggested Max Moisture		0.02%
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Special Requirements		
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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.

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