



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

**Technical Data Sheet**  
**LCA® PC-ZF1216 Clear**  
**Polycarbonate Clear**

<b>Typical Compound Properties</b>	<b>Value / Measure</b>	<b>Test Methods</b>
<b>Physical Properties</b>		
	<b>Metric Units</b>	
Density	1.2 g/cm <sup>3</sup>	ASTM-D792
Melt Flow	12 g/10 min	ASTM-D1238
<b>Mechanical Properties</b>		
Izod Impact	16.00 ft-lb/inch	ASTM-D256
Tensile Strength	9,200 psi	ASTM-D638
Flexural Modulus	350,000 psi	ASTM-D790
Flexural Strength	13700 psi	ASTM-D790

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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<b>Typical Processing Conditions</b>		
Process Variable	Description	Values
<b>Temperatures</b>		<b>F C</b>
Barrel	Rear	460 - 500
	Center	480 - 520
	Front	500 - 530
	Nozzle	485 - 505
	Mold	100 - 155
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<b>Drying</b>		
Type		Dehumidifier
Temperature		230°
Time		4 Hours
Max. % Moisture		
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<b>Special Requirements</b>		
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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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