



Product Data Sheet

Kostrate® PC *Injection Molding*

Product Description: *Kostrate® PC is a clear polycarbonate resin that combines crystal clarity and rigidity with superior toughness.*

Typical Material Properties

General Properties	Test Method / Cert.	Typical Values
Specific Gravity	ASTM D 792	1.20
Mold Shrinkage	ASTM D 955	.005-.008 in/in
Melt Flow (300°C/1.2 kg.)	ASTM D 1238	16.5 g/10 min
Food Contact Acceptable	FDA 21 CFR 177.1580	Compliant

Mechanical Properties

Tensile Strength @ Yield	ASTM D 638	60.3 MPa (8750 psi)
Tensile Elongation	ASTM D 638	120%
Flexural Modulus	ASTM D 790	2248 MPa (326,000 psi)
Flexural Strength @ Yield	ASTM D 790	84.8 MPa (12,300 psi)
Rockwell Hardness	ASTM D 785	122 Shore R

Thermal Properties

Deflection Temp. [@ 0.455 MPa (66psi)]	ASTM D 648	284°F (140°C)
Flammability Classification [3.2 mm (.125 in.)]	UL 94	V-2

Additional: *Dishwasher safe*

Optical Properties

Light Transmittance	ASTM D 1003	87%
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Recommended Processing

Drying Temperature	121°C (250°F)
Rear Temperature	480-520 °F (249-271°C)
Middle Temperature	500-520 °F (260-271°C)
Front Temperature	520-550 °F (271-288°C)
Nozzle/Die Head Temperature	510-540 °F (266-282°C)
Processing (Melt) Temp	530-560 °F (277-293°C)
Mold Temperature	160-200 °F (71-93°C)
Back Pressure	50-200 psi (0.34-1.38 MPa)
Screw Speed	40-80 rpm

The information provided above is based upon typical values. Typical values are intended only as guides. Each customer is responsible for determining whether products and information in this document are appropriate for the customer's use. **NO GUARANTEES OR WARRANTIES ARE EXPRESSED OR IMPLIED.**