

**Manufacturer:** LOTTE CHEMICAL 

## PC-1220U

### General Information

#### Description

Low viscosity  
UV-stability, Mold release

#### Applications

Outdoor and light exposed injection product

### Typical properties

|                                              | Test Method | Typical value | Unit                |
|----------------------------------------------|-------------|---------------|---------------------|
| <b>Physical</b>                              |             |               |                     |
| Melt Flow Index, 300°C, 1.2kg                | ASTM D1238  | 22            | g/10min             |
| Specific Gravity                             | ASTM D792   | 1.20          |                     |
| Mold Shrinkage                               | ASTM D955   | 0.5~0.7       | %                   |
| <b>Mechanical</b>                            |             |               |                     |
| Tensile Strength, yield, 50mm/min            | ASTM D638   | 630           | kgf/cm <sup>2</sup> |
| Tensile Elongation, break, 50mm/min          | ASTM D638   | > 100         | %                   |
| Flexural Strength, yield, 10mm/min           | ASTM D790   | 920           | kgf/cm <sup>2</sup> |
| Flexural Modulus, 10mm/min                   | ASTM D790   | 24,000        | kgf/cm <sup>2</sup> |
| IZOD Impact Strength, notched, 23 °C, 1/8"   | ASTM D256   | 70            | kg·cm/cm            |
| notched, 23 °C, 1/4"                         | ASTM D256   | -             | kg·cm/cm            |
| <b>Thermal</b>                               |             |               |                     |
| Heat Distortion Temp. 4.6kgf/cm <sup>2</sup> | ASTM D648   | 139           | °C                  |
| 18.6kgf/cm <sup>2</sup>                      | ASTM D648   | 128           | °C                  |
| Vicat Softening Temp. Rate B/50              | ASTM D1525  | 150           | °C                  |
| <b>Optical</b>                               |             |               |                     |
| Light Transmittance                          | ASTM D1003  | 89            | %                   |
| Haze                                         | ASTM D1003  | < 0.8         | %                   |
| Refractive Index                             | ASTM D542   | 1.585         |                     |

## EGYPTIAN SAUDI COMPANY FOR PLASTIC

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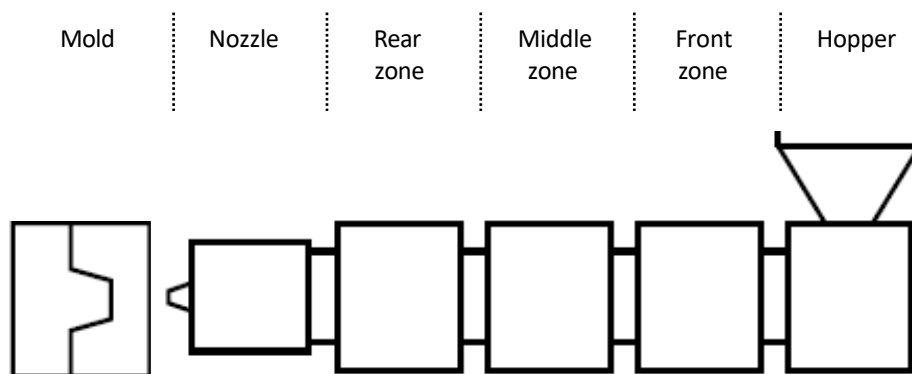
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## Processing guides

|                           | Typical value | Unit |
|---------------------------|---------------|------|
| Drying condition          |               |      |
| Drying temperature        | 120           | °C   |
| Drying time               | 4             | hr   |
| Maximum moisture content  | 0.02          | %    |
| Injection molding         |               |      |
| Melt temperature          | 290 ~ 310     | °C   |
| Nozzle temperature        | 280 ~ 300     | °C   |
| Rear zone                 | 290 ~ 310     | °C   |
| <b>Barrel</b> Middle zone | 280 ~ 300     | °C   |
| Front zone                | 270 ~ 290     | °C   |
| Hopper temperature        | 60 ~ 80       | °C   |
| Mold temperature          | 60 ~ 90       | °C   |



## Recycling

Sprues and runners can be reground with virgin resin within the ratio of 20%. Care must be taken to ensure that the regrind is free from impurities and regrind should not be used in applications where impact performance and/or agency compliance are required.