

Manufacturer: LOTTE CHEMICAL 

PC-1220R

General Information

Description

Low viscosity

Easy mold release

Applications

Small and complicated injection product

Typical properties

	Test Method	Typical value	Unit
Physical			
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	%
Mechanical			
Tensile Strength, yield, 50mm/min	ASTM D638	630	kgf/cm ²
Tensile Elongation, break, 50mm/min	ASTM D638	> 100	%
Flexural Strength, yield, 10mm/min	ASTM D790	920	kgf/cm ²
Flexural Modulus, 10mm/min	ASTM D790	24,000	kgf/cm ²
IZOD Impact Strength, notched, 23 °C, 1/8"	ASTM D256	70	kg·cm/cm
notched, 23 °C, 1/4"	ASTM D256	-	kg·cm/cm
Thermal			
Heat Distortion Temp. 4.6kgf/cm ²	ASTM D648	139	°C
18.6kgf/cm ²	ASTM D648	128	°C
Vicat Softening Temp. Rate B/50	ASTM D1525	150	°C
Optical			
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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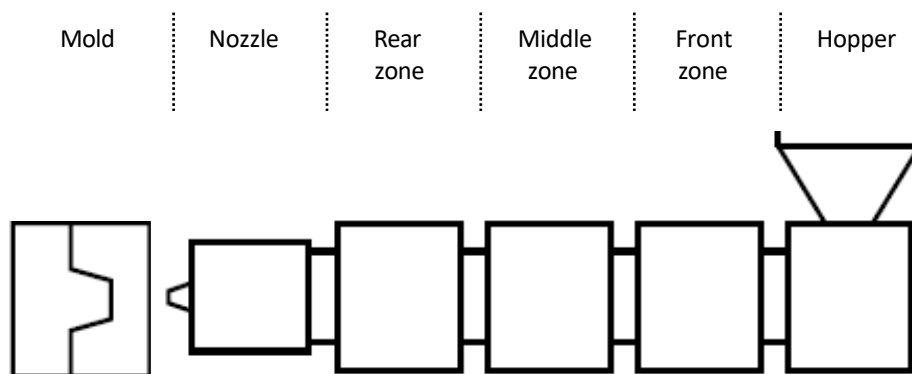
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Processing guides

	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
Barrel	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.