



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

Technical Data Sheet

LCA® PC-120 Black

General Purpose, Molding Grade Polycarbonate

	Value / Measure	Test Methods
Physical Properties		
	English Units	
Melt Flow Rate	18 g/10 min	ASTM D-1238
Density	1.2 g/cm ³	ASTM D-792
Mechanical Properties		
Izod Impact	20 ft-lb/in	ASTM D-256
Thermal Properties		

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	475-525	
	Center	500-550	
	Front	525-575	
	Nozzle	525-575	
	Mold	160 - 210	
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Drying			
Type		Dehumidifier	
Temperature		250	
Time		4	
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Special Requirements			

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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