

DPS DYN-PC1215 CLR

Polycarbonate
Dynamic Polymer Solutions

Technical Data			
Product Description			
Polycarbonate, 12 izod impact, 15 melt clear			
General			
Material Status	• Commercial: Active		
Literature ¹	• Technical Datasheet (English)		
Availability	• North America		
Features	• Good Clarity		
Appearance	• Clear/Transparent		
Processing Method	• Injection Molding		
Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density / Specific Gravity			
--	1.20	1.20 g/cm³	ASTM D792
73°F (23°C)	1.20 g/cm³	1.20 g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	15 g/10 min	15 g/10 min	ASTM D1238 ISO 1133
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus			
-- ³	320000 psi	2210 MPa	ASTM D638
--	320000 psi	2210 MPa	ISO 527-1/10
Tensile Strength			
Yield ⁴	8700 psi	60.0 MPa	ASTM D638
Yield	8560 psi	59.0 MPa	ISO 527-2/50
Tensile Elongation			
Break ⁴	130 %	130 %	ASTM D638
Break	120 %	120 %	ISO 527-2/50
Flexural Modulus ⁵			
--	349000 psi	2410 MPa	ASTM D790
--	3.48E+6 psi	24000 MPa	ISO 178
Flexural Strength ⁵	14100 psi	97.2 MPa	ASTM D790 ISO 178
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength (73°F (23°C))	27 ft·lb/in²	57 kJ/m²	ISO 179
Notched Izod Impact			
73°F (23°C)	12 ft·lb/in	650 J/m	ASTM D256
73°F (23°C)	35 ft·lb/in²	73 kJ/m²	ISO 180
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			
66 psi (0.45 MPa), Unannealed	280 °F	138 °C	ASTM D648
66 psi (0.45 MPa), Unannealed	275 °F	135 °C	ISO 75-2/B
264 psi (1.8 MPa), Unannealed	261 °F	127 °C	ASTM D648
264 psi (1.8 MPa), Unannealed	255 °F	124 °C	ISO 75-2/A

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Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	194 to 248 °F	90 to 120 °C
Drying Time	3.0 to 5.0 hr	3.0 to 5.0 hr
Suggested Max Moisture	< 0.050 %	< 0.050 %
Processing (Melt) Temp	527 to 563 °F	275 to 295 °C
Mold Temperature	158 to 194 °F	70 to 90 °C
Injection Rate	Moderate	Moderate
Back Pressure	80.0 to 120 psi	0.552 to 0.827 MPa

Notes

¹ These links provide you with access to supplier literature. We work hard to keep them up to date; however you may find the most current literature from the supplier.

² Typical properties: these are not to be construed as specifications.

³ 0.39 in/min (10 mm/min)

⁴ 2.0 in/min (50 mm/min)

⁵ 0.20 in/min (5.0 mm/min)

