



VYTEEN PC-135

General Purpose Medium Viscosity Polycarbonate

Vyteen PC 135, Black, medium viscosity polycarbonate, has an excellent balance of stiffness and impact resistance.

Features

- High heat resistance
- Good processability

Typical Resin Properties ^(a)	ASTM Method	Typical values
Density at 23°C, g/cm ³	D792	1.2
Izod, notched, 23°C, J/m	D256	700
Tensile Strength @ Yield, MPa	D638	60
Elongation @ Yield, %	D638	3.6
Melt flow rate (300°C, 1.2Kg), g/10min	D1238	11
Flexural Strength (1.3mm/min), MPa	D790	65
Flexural Modulus (1.3mm/min), MPa	D790	2300
HDT, @ 1820 Kpa, °C	D648	120
Mold Shrinkage, flow, mil/in	D955	7

(a) The property values are based on a limited number of tests and, therefore, should not be construed as product specifications.

Processing Guidelines

Drying

The Vyteen PC135 grades process easily but must be thoroughly dried before molding, preferably in a dehumidifying desiccant hopper dryer, operating with an air flow rate of min1.0 CFM/lb, dew point of -18°C or lower. The material should be dried at 121°C (250° F) for 4 hours and the humidity content of the material should be maintained below 0.02% during molding.

Molding

Vypet VNT products have a relatively wide processing window with barrel temperature settings as following:

- Feed zone: 255-270°C (490-520°F)
- Middle zone: 265-280°C (510-540°F)
- Front zone: 275-295°C (530-560°F)
- Nozzle: 275-290°C (530-560°F)
- Melt temperature: 275-290°C (530-560°F)

Other Molding Parameters

- Injection Pressure: 10000-20000 psi
- Injection Speed: Moderate
- Screw Speed: 50-75 rpm



ISO 17025



Conseil canadien des normes
Standards Council of Canada

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