**JPPCGP**

PC with excellent physical property balance of heat resistance, and impact strength

**Typical Material Properties**

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| General |  |  |
| Material Status | Commercial: Active |  |
| Availability | North America |  |
| Forms | Pellets |  |
| Processing Method | Coextrusion | Injection Blow Molding |
|  | Sheet Extrusion | Extrusion Blow Molding |
|  | Injection Molding | Thermoforming |
|  | Film Extrusion | Profile Extrusion |

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| Physical Properties | Nominal Values | Test Method |
| Specific Gravity | 1.20  | ASTM D792 |
| Melt Mass-Flow Rate (MFR) (300°C/1.2 kg) | 6.0 g/10 min | ASTM D1238 |
| Molding Shrinkage - Flow  | 5.0E-3 to 7.0E-3 in/in | ASTM D955 |

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| Mechanical Properties |  |  |
| Tensile Modulus1 | 334000 psi | ASTM D638 |
| Tensile Strength1 |    | ASTM D638 |
| Yield | 8700 psi |   |
| Break | 10500 psi |   |
| Tensile Elongation1 |    | ASTM D638 |
| Yield | 6.0 % |   |
| Break | 150 % |   |
| Flexural Modulus2 | 350000 psi | ASTM D790 |
| Flexural Strength2 | 14000 psi | ASTM D790 |

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| Impact |  |  |
| Notched Izod Impact (73°F) | 17 ft·lb/in | ASTM D256 |
| Unnotched Izod Impact (73°F) | No Break  | ASTM D256 |

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| Thermal |  |  |
| Deflection Temperature Under Load |    | ASTM D648 |
| 66 psi, Annealed | 288 °F |   |
| 264 psi, Unannealed | 252 °F |   |
| 264 psi, Annealed | 282 °F |   |
| Vicat Softening Temperature | 298 °F | ASTM D1525 |

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| Flammability |  |  |
| Flame Rating |    | UL 94 |
| 0.0630 in | V-2  |   |
| 0.126 in | V-2  |   |

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| Optical |  |  |
| Transmittance | 87.0 to 91.0 % | ASTM D1003 |
| Haze | 0.70 to 1.5 % | ASTM D1003 |

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| Injection | Nominal Value |
| Drying Temperature | 250 °F |
| Drying Time | 3.0 to 4.0 hr |
| Suggested Max Moisture | 0.020 % |
| Rear Temperature | 520 to 550 °F |
| Middle Temperature | 530 to 570 °F |
| Front Temperature | 570 to 620 °F |
| Nozzle Temperature | 570 to 620 °F |
| Processing (Melt) Temp | 570 to 620 °F |
| Mold Temperature | 170 to 230 °F |
| Screw Speed | 40 to 70 rpm |
| Clamp Tonnage | 2.0 to 5.0 tons/in² |
| Screw L/D Ratio | 15.0:1.0  |
| Screw Compression Ratio | 1.5:1.0 to 3.0:1.0  |

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| Notes |  |  |
| 1Type I, 2.0 in/min |
| 2Type I, 0.050 in/min |