



## Product Data Sheet & General Processing Conditions

### ZOVGOV® M21 Polycarbonate (PC) Unreinforced

#### PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.19	1.19	D 792
Melt Flow Rate @ 300 °C, / 1.2 kg	10.00 g/10 min	10.00 g/10 min	D 1238
Molding Shrinkage 1/8 in (3.2 mm) section	0.0060 - 0.0090 in/in	0.60 - 0.90 %	D 955

#### MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	15.0 ft-lbs/in	801 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	8500 psi	59 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.32 x 10 <sup>6</sup> psi	2206 MPa	D 638
Flexural Strength	13500 psi	93 MPa	D 790
Flexural Modulus	0.34 x 10 <sup>6</sup> psi	2344 MPa	D 790

#### THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	270 °F	132 °C	D 648
Ignition Resistance* Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635

#### PROPERTY NOTES

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

\* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.

\*\* Values per MOLAN Company testing.

#### GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	550 - 600 °F	288 - 316 °C
Mold Temperature	180 - 250 °F	82 - 121 °C
Drying	4 hrs @ 250 °F	4 hrs @ 121 °C
Moisture Content	0.02 %	0.02 %
Dew Point	-20 °F	-29 °C

#### PROCESSING NOTES

Desiccant Type Dryer Required.