

**Product Texts**

20% Glass Reinforced, Flame Retardant

ISO 1043 PC-GF20 FR

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Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	8	cm <sup>3</sup> /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
<sup>[C]</sup> Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
<sup>[C]</sup> Molding shrinkage, normal	0.5	%	ISO 294-4, 2577
<sup>[C]</sup> Density of melt	1170	kg/m <sup>3</sup>	-
<sup>[C]</sup> Thermal conductivity of melt	0.29	W/(m K)	-
<sup>[C]</sup> Spec. heat capacity of melt	1530	J/(kg K)	-
<sup>[C]</sup> Eff. thermal diffusivity	1.62E-7	m <sup>2</sup> /s	-
<sup>[C]</sup> Ejection temperature	134	°C	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	6000	MPa	ISO 527
<sup>[C]</sup> Stress at break	90	MPa	ISO 527
<sup>[C]</sup> Strain at break	4	%	ISO 527

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	145	°C	ISO 75-1/-2
<sup>[C]</sup> Vicat softening temperature, B	150	°C	ISO 306
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	25	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Burning Behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Yellow Card available	yes	-	-
<sup>[C]</sup> Burning Behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	1.2	mm	-
Yellow Card available	yes	-	-
<sup>[C]</sup> Oxygen index	35	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Relative permittivity, 100Hz	3.25	-	IEC 62631-2-1
<sup>[C]</sup> Relative permittivity, 1MHz	3.2	-	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 100Hz	9	E-4	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 1MHz	90	E-4	IEC 62631-2-1
<sup>[C]</sup> Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
<sup>[C]</sup> Surface resistivity	>1E15	Ohm	IEC 62631-3-2
<sup>[C]</sup> Electric strength	29	kV/mm	IEC 60243-1
<sup>[C]</sup> Comparative tracking index	200	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
<sup>[C]</sup> Water absorption	0.29	%	Sim. to ISO 62
<sup>[C]</sup> Density	1350	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Injection Molding, melt temperature	300	°C	ISO 294
Injection Molding, mold temperature	100	°C	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.03	%	-
Melt temperature	290 - 320	°C	-
Mold temperature	80 - 120	°C	-
Zone 1	260 - 280	°C	-
Zone 2	270 - 290	°C	-
Zone 3	280 - 300	°C	-
Nozzle temperature	270 - 290	°C	-

**Characteristics**

**Processing**

Injection Molding

**Special Characteristics**

Flame retardant, Heat stabilized or stable to heat

**Delivery form**

Pellets

**Regional Availability**

Europe

**Additives**

Release agent

**Other text information**

**Injection molding**

[Injection Molding Recommendations](#)