

Product Texts

- (PC-I)-Blend
- flame retardant
- Vicat/B 120 temperature = 101 °C
- UL-recognition 94 V-0 at 0.75mm
- rated f1 per UL746 C "Outdoor Suitability"
- improved colorability compared to other PC+ASA grades

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	32	cm ³ /10min	ISO 1133
Temperature	240	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2700	MPa	ISO 527
^[C] Yield stress	64	MPa	ISO 527
^[C] Yield strain	4.1	%	ISO 527
^[C] Nominal strain at break	>50	%	ISO 527
Flexural modulus, 23°C	2700	MPa	ISO 178
Flexural strength	102	MPa	ISO 178
Izod impact strength, +23°C	N	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	12	kJ/m ²	ISO 180/1A
Izod notched impact strength	5	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	83	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	93	°C	ISO 75-1/-2
^[C] Vicat softening temperature, B	98	°C	ISO 306
^[C] Coeff. of linear therm. expansion, parallel	65	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	65	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
Yellow Card available	yes	-	-

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Relative permittivity, 100Hz	3.2	-	IEC 62631-2-1
^[C] Relative permittivity, 1MHz	3.1	-	IEC 62631-2-1
^[C] Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
^[C] Surface resistivity	>1E15	Ohm	IEC 62631-3-2
^[C] Electric strength	35	kV/mm	IEC 60243-1

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Water absorption	0.5	%	Sim. to ISO 62
^[C] Humidity absorption	0.2	%	Sim. to ISO 62
^[C] Density	1210	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	240	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	240	mm/s	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	240 - 270	°C	-
Mold temperature	60 - 90	°C	-
Zone 1	220 - 230	°C	-
Zone 2	225 - 235	°C	-
Zone 3	230 - 240	°C	-
Nozzle temperature	255 - 265	°C	-
Back pressure	5 - 15	MPa	-

Characteristics

Processing

Injection Molding

Special Characteristics

Flame retardant, High impact or impact modified, U.V. stabilized or stable to weather

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa