

**HARMONIA PC 3D50-24**

PC

MAIP SRL

| <b>Processing/Physical Characteristics</b>         | <b>Value</b>     | <b>Unit</b>       | <b>Test Standard</b> |
|--|------------------|-------------------|----------------------|
| <b>ISO Data</b>                                    |                  |                   |                      |
| Melt flow index, MFI                               | <b>20</b>        | g/10min           | ISO 1133             |
| Temperature  | <b>300</b>       | °C                | -                    |
| Load   | <b>1.2</b>       | kg                | -                    |
| Molding shrinkage, parallel                        | <b>0.7</b>       | %                 | ISO 294-4, 2577      |
| Molding shrinkage, normal                          | <b>0.7</b>       | %                 | ISO 294-4, 2577      |
| <b>Mechanical properties</b>                       |                  |                   |                      |
| <b>ISO Data</b>                                    |                  |                   |                      |
| Stress at break                                    | <b>50</b>        | MPa               | ISO 527              |
| Strain at break                                    | <b>6</b>         | %                 | ISO 527              |
| Flexural modulus, 23°C                             | <b>2400</b>      | MPa               | ISO 178              |
| Flexural strength                                  | <b>95</b>        | MPa               | ISO 178              |
| Izod notched impact strength, +23°C                | <b>10</b>        | kJ/m <sup>2</sup> | ISO 180/1A           |
| <b>Thermal properties</b>                          |                  |                   |                      |
| <b>ISO Data</b>                                    |                  |                   |                      |
| Glass transition temperature, 10°C/min             | <b>144</b>       | °C                | ISO 11357-1/-2       |
| Temp. of deflection under load, 1.80 MPa           | <b>124</b>       | °C                | ISO 75-1/-2          |
| Temp. of deflection under load, 0.45 MPa           | <b>136</b>       | °C                | ISO 75-1/-2          |
| Burning behav. at thickness h                      | <b>V-2</b>       | class             | IEC 60695-11-10      |
| Thickness tested                                   | <b>0.8</b>       | mm                | -                    |
| Burning rate, FMVSS, Thickness 1 mm                | <b>100</b>       | mm/min            | ISO 3795 (FMVSS 302) |
| <b>Other properties</b>                            |                  |                   |                      |
| Density  | <b>1200</b>      | kg/m <sup>3</sup> | ISO 1183             |
| <b>Processing Recommendation Injection Molding</b> |                  |                   |                      |
| Pre-drying - Temperature                           | <b>120</b>       | °C                | -                    |
| Pre-drying - Time                                  | <b>4 - 8</b>     | h                 | -                    |
| Processing humidity                                | <b>≤0.02</b>     | %                 | -                    |
| Melt temperature                                   | <b>280 - 310</b> | °C                | -                    |
| Mold temperature                                   | <b>70 - 90</b>   | °C                | -                    |

**Characteristics****Processing**

Injection Molding

**Special Characteristics**

U.V. stabilized or stable to weather

**Features**

Light Diffusing

**Regional Availability**

Europe