

Product Texts

High heat resistant polycarbonate copolymer, provides DTUL of 290F at 264 psi. FDA food contact compliant in limited colors. Effective January 15th, 2008 this grade will no longer be supported with biocompatibility information and should not be used for medical applications which require biocompatibility. Alternative grade HPH4504.

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	3	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	65	MPa	ASTM D 638
Tensile Strength at Break	71	MPa	ASTM D 638
Elongation at Break	122	%	ASTM D 638
Flexural Modulus	2020	MPa	ASTM D 790
Rockwell Hardness	R 122	-	ASTM D 785
Izod Impact notched, 1/8 in	640	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	3200	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 264 psi	143	°C	ASTM D 648
Thermal Conductivity, solid state	0.0303	W/(m K)	ASTM C 177
Specific Heat	1260	J/(kg K)	ASTM C 351

Electrical properties	Value	Unit	Test Standard
ASTM Data			
Dissipation Factor, 60 Hz	0.0012	-	ASTM D 150
Dielectric Constant, 60 Hz	3.15	-	ASTM D 150
Dielectric Constant, 1 MHz	3	-	ASTM D 150
Volume Resistivity	>1E15	Ohm*cm	ASTM D 257

Other properties	Value	Unit	Test Standard
Density	1200	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	340 - 360	°C	-
Mold temperature	80 - 115	°C	-
Zone 1	315 - 340	°C	-
Zone 2	325 - 350	°C	-
Zone 3	340 - 360	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 0.7	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

Asia Pacific

Certifications

Food contact, Food approval FDA 21 CFR