

Product Texts

High Viscosity, Extrusion

ISO 1043 PC

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	3.9	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
^[C] Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.6	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2400	MPa	ISO 527
^[C] Yield stress	60	MPa	ISO 527
^[C] Yield strain	5.4	%	ISO 527
^[C] Nominal strain at break	>50	%	ISO 527
^[C] Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	88	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	131	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	145	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	65	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	66	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Relative permittivity, 100Hz	3.1	-	IEC 62631-2-1
^[C] Relative permittivity, 1MHz	3.1	-	IEC 62631-2-1
^[C] Dissipation factor, 100Hz	6	E-4	IEC 62631-2-1
^[C] Dissipation factor, 1MHz	90	E-4	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	17	kV/mm	IEC 60243-1

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Density	1200	kg/m ³	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4 - 8	h	-
Processing humidity	≤0.03	%	-
Mold temperature	70 - 100	°C	-
Zone 1	260 - 280	°C	-
Zone 2	270 - 290	°C	-
Zone 3	270 - 310	°C	-
Nozzle temperature	270 - 310	°C	-

Characteristics

Processing

Injection Molding, Other Extrusion

Regional Availability

Asia Pacific

Other text information

Injection molding

[Injection Molding Recommendations](#)