

**Product Texts**

Laser Direct Structuring (LDS) \*, Vicat 130°C

ISO 1043 (PC+PET)

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\*The compound is intended specifically for the use in the process of manufacturing conducting path designs according to the German application of the patent 101 32 092 of LPKF Laser & Electronics AG (Osteriede 7 30827 Garbsen Germany). Please address straight to LPKF Laser & Electronics AG ([www.LPKF.de](http://www.LPKF.de)).

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	15	cm <sup>3</sup> /10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
<sup>[C]</sup> Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	2200	MPa	ISO 527
<sup>[C]</sup> Yield stress	50	MPa	ISO 527
<sup>[C]</sup> Yield strain	6	%	ISO 527
<sup>[C]</sup> Nominal strain at break	>50	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	55	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	25	kJ/m <sup>2</sup>	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	110	°C	ISO 75-1/-2
<sup>[C]</sup> Vicat softening temperature, B	130	°C	ISO 306
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	75	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	80	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Burning Behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	1.0	mm	-

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
<sup>[C]</sup> Surface resistivity	>1E15	Ohm	IEC 62631-3-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
<sup>[C]</sup> Water absorption	0.35	%	Sim. to ISO 62
<sup>[C]</sup> Density	1270	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	280	°C	ISO 294
Injection Molding, mold temperature	90	°C	ISO 294

[C]: CAMPUS

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>100 - 120</b>	°C	-
Pre-drying - Time	<b>4 - 6</b>	h	-
Processing humidity	<b>≤0.03</b>	%	-
Melt temperature	<b>270 - 300</b>	°C	-
Mold temperature	<b>80 - 120</b>	°C	-
Zone 1	<b>260 - 280</b>	°C	-
Zone 2	<b>270 - 290</b>	°C	-
Zone 3	<b>270 - 300</b>	°C	-
Nozzle temperature	<b>270 - 290</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Additives**

Release agent

**Delivery form**

Pellets

**Regional Availability**

North America, Europe, Asia Pacific

**Other text information****Injection molding**[/>Injection Molding Recommendations](#)