

**Product Texts**

- (PC PET) Blend, 5% mineral filled, easy flow, easy release, good impact strength, for automotive applications

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	49	cm <sup>3</sup> /10min	ISO 1133
Temperature	270	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	3050	MPa	ISO 527
<sup>[C]</sup> Yield stress	65	MPa	ISO 527
<sup>[C]</sup> Yield strain	5	%	ISO 527
<sup>[C]</sup> Nominal strain at break	>50	%	ISO 527
Flexural modulus, 23°C	3100	MPa	ISO 178
Flexural strength	105	MPa	ISO 178
<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	200	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	6	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C	6	kJ/m <sup>2</sup>	ISO 180/1A
<sup>[C]</sup> Puncture - maximum force, +23°C	4700	N	ISO 6603-2
<sup>[C]</sup> Puncture energy, +23°C	45	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	112	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	130	°C	ISO 75-1/-2
Vicat softening temperature, B	140	°C	ISO 306
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	60	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	60	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
<sup>[C]</sup> Water absorption	0.45	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	0.2	%	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	270	°C	ISO 294
Injection Molding, mold temperature	70	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.01	%	-
Melt temperature	270 - 280	°C	-
Mold temperature	70 - 80	°C	-
Zone 1	220 - 230	°C	-

Zone 2	<b>240 - 250</b>	°C	-
Zone 3	<b>260 - 270</b>	°C	-
Nozzle temperature	<b>270 - 280</b>	°C	-
Back pressure	<b>5 - 10</b>	MPa	-

## Characteristics

### Processing

Injection Molding

### Additives

Release agent

### Special Characteristics

High impact or impact modified

### Applications

Automotive

### Regional Availability

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