

Product Texts

Injection Molding, Medical grade, Food Contact Quality

ISO 18064 TPC-ET

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	28	cm ³ /10min	ISO 1133
Temperature	230	°C	-
Load	2.16	kg	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	N	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	N	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	12	kJ/m ²	ISO 179/1eA
^[C] Tensile notched impact strength, +23°C	233	kJ/m ²	ISO 8256/1
^[C] Stress at 10% elongation	17	MPa	ISO 527
^[C] Stress at 100% elongation	18	MPa	ISO 527
^[C] Stress at 300% elongation	20	MPa	ISO 527
^[C] Stress at break TPE	35	MPa	ISO 527
^[C] Strain at break TPE	>300	%	ISO 527
^[C] Compression set at 70 °C, 24h	43	%	ISO 815

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	212	°C	ISO 11357-1/-3
^[C] Glass transition temperature, 10°C/min	-60	°C	ISO 11357-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	115	°C	ISO 75-1/-2
^[C] Vicat softening temperature, B	125	°C	ISO 306
^[C] Coeff. of linear therm. expansion, parallel	185	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	185	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Yellow Card available	yes	-	-

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Relative permittivity, 100Hz	3.8	-	IEC 62631-2-1
^[C] Relative permittivity, 1MHz	3.4	-	IEC 62631-2-1
^[C] Dissipation factor, 100Hz	110	E-4	IEC 62631-2-1
^[C] Dissipation factor, 1MHz	340	E-4	IEC 62631-2-1
^[C] Volume resistivity	1E12	Ohm*m	IEC 62631-3-1
^[C] Electric strength	22	kV/mm	IEC 60243-1
^[C] Comparative tracking index	600	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Water absorption	0.6	%	Sim. to ISO 62
^[C] Humidity absorption	0.2	%	Sim. to ISO 62
^[C] Density	1240	kg/m ³	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	3 - 6	h	-
Melt temperature	230 - 250	°C	-
Mold temperature	20 - 50	°C	-
Zone 1	200 - 220	°C	-
Zone 2	210 - 230	°C	-
Zone 3	220 - 240	°C	-
Nozzle temperature	230 - 250	°C	-
Back pressure	3 - 10	MPa	-

Characteristics

Processing

Injection Molding

Applications

Medical

Delivery form

Pellets

Regional Availability

North America, Europe, Asia Pacific

Certifications

Food contact, Medical Grade

Other text information

Injection molding

[Injection Molding Recommendations](#)

[Steel recommendations for molds screws and barrels](#)

[Trouble shooting guideline for injection molding](#)