

**Product Texts**

Injection Molding, Food Contact Quality, Medical grade

ISO 18064 TPC-ET

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	<b>18</b>	cm <sup>3</sup> /10min	ISO 1133
Temperature	<b>230</b>	°C	-
Load	<b>2.16</b>	kg	-
<sup>[C]</sup> Density of melt	<b>950</b>	kg/m <sup>3</sup>	-
<sup>[C]</sup> Thermal conductivity of melt	<b>0.1</b>	W/(m K)	-
<sup>[C]</sup> Spec. heat capacity of melt	<b>1900</b>	J/(kg K)	-
<sup>[C]</sup> Eff. thermal diffusivity	<b>5.54E-8</b>	m <sup>2</sup> /s	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Charpy impact strength, +23°C	<b>N</b>	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	<b>10</b>	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	<b>6</b>	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Stress at 10% elongation	<b>34</b>	MPa	ISO 527
<sup>[C]</sup> Stress at 100% elongation	<b>26</b>	MPa	ISO 527
<sup>[C]</sup> Stress at break TPE	<b>41</b>	MPa	ISO 527
<sup>[C]</sup> Strain at break TPE	<b>&gt;300</b>	%	ISO 527
<sup>[C]</sup> Compression set at 70 °C, 24h	<b>35</b>	%	ISO 815

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	<b>221</b>	°C	ISO 11357-1/-3
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	<b>120</b>	°C	ISO 75-1/-2
<sup>[C]</sup> Vicat softening temperature, B	<b>160</b>	°C	ISO 306
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	<b>165</b>	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	<b>165</b>	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Burning Behav. at 1.5 mm nom. thickn.	<b>HB</b>	class	IEC 60695-11-10
Thickness tested	<b>1.5</b>	mm	-
Yellow Card available	<b>yes</b>	-	-

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Relative permittivity, 100Hz	<b>3.7</b>	-	IEC 62631-2-1
<sup>[C]</sup> Relative permittivity, 1MHz	<b>3.3</b>	-	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 1MHz	<b>300</b>	E-4	IEC 62631-2-1
<sup>[C]</sup> Volume resistivity	<b>1E13</b>	Ohm*m	IEC 62631-3-1
<sup>[C]</sup> Electric strength	<b>23</b>	kV/mm	IEC 60243-1
<sup>[C]</sup> Comparative tracking index	<b>600</b>	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
<sup>[C]</sup> Water absorption	<b>0.6</b>	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	<b>0.15</b>	%	Sim. to ISO 62
<sup>[C]</sup> Density	<b>1290</b>	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

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