

Product Texts

Food Contact Quality, Injection Molding

ISO 18064 TPC-ET

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	23	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	25	kJ/m ²	ISO 179/1eA
^[C] Tensile notched impact strength, +23°C	216	kJ/m ²	ISO 8256/1
^[C] Stress at 10% elongation	12.8	MPa	ISO 527
^[C] Stress at 100% elongation	14.6	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	40	%	ISO 815

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	204	°C	ISO 11357-1/-3
^[C] Glass transition temperature, 10°C/min	-64	°C	ISO 11357-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	110	°C	ISO 75-1/-2
^[C] Vicat softening temperature, B	90	°C	ISO 306
^[C] Coeff. of linear therm. expansion, parallel	200	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	200	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Relative permittivity, 100Hz	4.4	-	IEC 62631-2-1
^[C] Relative permittivity, 1MHz	4	-	IEC 62631-2-1
^[C] Dissipation factor, 1MHz	400	E-4	IEC 62631-2-1
^[C] Volume resistivity	1E11	Ohm*m	IEC 62631-3-1
^[C] Electric strength	21	kV/mm	IEC 60243-1
^[C] Comparative tracking index	600	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Water absorption	0.65	%	Sim. to ISO 62
^[C] Humidity absorption	0.2	%	Sim. to ISO 62
^[C] Density	1200	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics

Processing

Injection Molding

Certifications

Food contact

Delivery form

Pellets

Regional Availability

North America, Europe, Asia Pacific

Other text information

Injection molding

[Injection Molding Recommendations](#)

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

[Trouble shooting guideline for injection molding](#)