

Product Texts

- MVR (300 °C/1.2 kg) 4.0 cm³/10 min
- 30 % glass fiber reinforced
- milled fiber
- high viscosity
- easy release
- precision parts

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	4	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
^[C] Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.3	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	5100	MPa	ISO 527
^[C] Yield stress	59	MPa	ISO 527
^[C] Yield strain	2.5	%	ISO 527
^[C] Tensile creep modulus, 1h	4700	MPa	ISO 899-1
^[C] Tensile creep modulus, 1000h	3900	MPa	ISO 899-1
^[C] Charpy impact strength, +23°C	40	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	45	kJ/m ²	ISO 179/1eU
^[C] Puncture - maximum force, +23°C	1300	N	ISO 6603-2
^[C] Puncture - maximum force, -30°C	800	N	ISO 6603-2
^[C] Puncture energy, +23°C	5	J	ISO 6603-2
^[C] Puncture energy, -30°C	5	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	135	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	141	°C	ISO 75-1/-2
^[C] Vicat softening temperature, B	147	°C	ISO 306
^[C] Coeff. of linear therm. expansion, parallel	35	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	55	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at 1.5 mm nom. thickn.	V-1	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
^[C] Oxygen index	37	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Relative permittivity, 100Hz	3.5	-	IEC 62631-2-1
^[C] Relative permittivity, 1MHz	3.5	-	IEC 62631-2-1
^[C] Dissipation factor, 100Hz	15	E-4	IEC 62631-2-1
^[C] Dissipation factor, 1MHz	90	E-4	IEC 62631-2-1
^[C] Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
^[C] Surface resistivity	>1E15	Ohm	IEC 62631-3-2
^[C] Electric strength	36	kV/mm	IEC 60243-1
^[C] Comparative tracking index	175	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Water absorption	0.22	%	Sim. to ISO 62

Makrolon® 8035

PC-GF30

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[C] Humidity absorption	0.1	%	Sim. to ISO 62
[C] Density	1420	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
[C] Injection Molding, melt temperature	300	°C	ISO 294
Injection Molding, mold temperature	110	°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	120	°C	-
Pre-drying - Time	2 - 3	h	-
Processing humidity	≤0.02	%	-
Melt temperature	310 - 330	°C	-
Mold temperature	80 - 130	°C	-

Characteristics**Processing**

Injection Molding, Other Extrusion

Special Characteristics

Opaque

Delivery form

Pellets

Regional Availability

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

Additives

Release agent

Other text information**Injection molding**

PREPROCESSING

Max. Water content: 0.01 - 0.02 %

Drying temperature: 120 °C

Drying time:

Circulating air drying oven (50 % fresh air) 4-8 h

Fresh air dryer (high speed dryer) 2-4 h

Dry air dryer 2-3 h

PROCESSING

Melt temperature: 310-330 °C

Mold temperature: 80-130 °C

Use open nozzle.