

Product Texts

High heat resistant polycarbonate copolymer, provides DTUL of 300F at 264 psi. FDA food contact compliant in limited colors. Effective January 15th, 2008 this grade will no longer be supported with biocompatibility information and should not be used for medical applications which require biocompatibility. Alternative grade HPH4704.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	6	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	5	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2300	MPa	ISO 527
Yield stress	70	MPa	ISO 527
Yield strain	7	%	ISO 527
Strain at break	50	%	ISO 527
Flexural modulus	2300	MPa	ISO 178
Charpy impact strength, +23°C, 3mm	N	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C, 3mm	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C, 3mm	45	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C, 3mm	12	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	N	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C, 3mm	44	kJ/m ²	ISO 180/1A
Izod notched impact strength, -30°C, 3mm	11	kJ/m ²	ISO 180/1A
Rockwell hardness	R 127	-	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
ISO Data			
Vicat softening temperature, A	185	°C	ISO 306
Vicat softening temperature, B	165	°C	ISO 306
Vicat softening temperature, 120°C/h 50N	167	°C	ISO 306
Thermal Conductivity	0.21	W/(m K)	DIN 52616
Glow Wire Flammability Index (GWFI)	850	°C	IEC 60695-2-12
GWFI - thickness tested (2)	2	mm	-

Electrical properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 1MHz	3.1	-	IEC 62631-2-1
Dissipation factor, 100Hz	260	E-4	IEC 62631-2-1

Other properties	Value	Unit	Test Standard
Density	1200	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	125 - 135	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	325 - 360	°C	-
Mold temperature	100 - 125	°C	-
Feed temperature	60 - 80	°C	-
Zone 1	300 - 320	°C	-
Zone 2	310 - 330	°C	-
Zone 3	320 - 340	°C	-

Characteristics

Processing

Injection Molding

Regional Availability

Europe

Certifications

Food contact, Food approval FDA 21 CFR