

Product Texts

High Viscosity, Flame Retardant, Molding Release

ISO 1043 PC FR

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Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	5	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
^[C] Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
^[C] Density of melt	1010	kg/m ³	-
^[C] Thermal conductivity of melt	0.24	W/(m K)	-
^[C] Spec. heat capacity of melt	1710	J/(kg K)	-
^[C] Eff. thermal diffusivity	1.4E-7	m ² /s	-
^[C] Ejection temperature	131	°C	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2300	MPa	ISO 527
^[C] Yield stress	60	MPa	ISO 527
^[C] Yield strain	6	%	ISO 527
^[C] Nominal strain at break	>50	%	ISO 527

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	130	°C	ISO 75-1/-2
^[C] Vicat softening temperature, B	150	°C	ISO 306
^[C] Coeff. of linear therm. expansion, parallel	65	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Yellow Card available	yes	-	-
^[C] Burning Behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
Yellow Card available	yes	-	-
^[C] Burning Behav. 5V at thickness h	5VA	class	IEC 60695-11-20
Thickness tested	3.0	mm	-
Yellow Card available	yes	-	-
^[C] Oxygen index	35	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Relative permittivity, 100Hz	3	-	IEC 62631-2-1
^[C] Relative permittivity, 1MHz	2.9	-	IEC 62631-2-1
^[C] Dissipation factor, 100Hz	6.6	E-4	IEC 62631-2-1
^[C] Dissipation factor, 1MHz	92	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	29	kV/mm	IEC 60243-1
^[C] Comparative tracking index	225	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Water absorption	0.35	%	Sim. to ISO 62
^[C] Density	1200	kg/m ³	ISO 1183

[C]: CAMPUS

Material specific properties	Value	Unit	Test Standard
ISO Data			
^[C] Viscosity number	63	cm ³ /g	ISO 307, 1157, 1628

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	300	°C	ISO 294
Injection Molding, mold temperature	90	°C	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.03	%	-
Melt temperature	290 - 320	°C	-
Mold temperature	80 - 120	°C	-
Zone 1	260 - 280	°C	-
Zone 2	270 - 290	°C	-
Zone 3	280 - 300	°C	-
Nozzle temperature	270 - 290	°C	-

Characteristics

Processing

Injection Molding, Other Extrusion, Blow Molding

Special Characteristics

Flame retardant, Heat stabilized or stable to heat

Delivery form

Pellets

Regional Availability

Europe

Additives

Release agent

Other text information

Injection molding

[Injection Molding Recommendations](#)