

**Product Texts**

- (PC PBT)-blend, impact modified, Injection molding grade, 20% mineral filled, applications: automotive exterior body panels

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	<b>11</b>	cm <sup>3</sup> /10min	ISO 1133
Temperature	<b>260</b>	°C	-
Load	<b>5</b>	kg	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	<b>3600</b>	MPa	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	<b>155</b>	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	<b>115</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

[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, 1.80 MPa	<b>93</b>	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	<b>106</b>	°C	ISO 75-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	<b>70</b>	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	<b>70</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>1.6</b>	mm	-
<sup>[C]</sup> Burning Behav. at thickness h	<b>HB</b>	class	IEC 60695-11-10
Thickness tested	<b>0.8</b>	mm	-
<sup>[C]</sup> Oxygen index	<b>21</b>	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Relative permittivity, 100Hz	<b>3.2</b>	-	IEC 62631-2-1
<sup>[C]</sup> Relative permittivity, 1MHz	<b>3.1</b>	-	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 100Hz	<b>26</b>	E-4	IEC 62631-2-1
<sup>[C]</sup> Dissipation factor, 1MHz	<b>95</b>	E-4	IEC 62631-2-1
<sup>[C]</sup> Volume resistivity	<b>&gt;1E13</b>	Ohm*m	IEC 62631-3-1
<sup>[C]</sup> Surface resistivity	<b>&gt;1E15</b>	Ohm	IEC 62631-3-2
<sup>[C]</sup> Electric strength	<b>34</b>	kV/mm	IEC 60243-1
<sup>[C]</sup> Comparative tracking index	<b>250</b>	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
<sup>[C]</sup> Water absorption	<b>0.8</b>	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	<b>0.2</b>	%	Sim. to ISO 62
<sup>[C]</sup> Density	<b>1300</b>	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Injection Molding, melt temperature	<b>270</b>	°C	ISO 294
Injection Molding, mold temperature	<b>70</b>	°C	ISO 294
Injection Molding, injection velocity	<b>200</b>	mm/s	ISO 294

[C]: CAMPUS

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>100 - 105</b>	°C	-
Pre-drying - Time	<b>2 - 4</b>	h	-
Processing humidity	<b>≤0.01</b>	%	-
Melt temperature	<b>250 - 270</b>	°C	-
Mold temperature	<b>60 - 80</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Special Characteristics**

High impact or impact modified

**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 %

Drying temperature: 100 - 105 °C

Drying time:

Circulating air drying oven (50 % fresh air) 4-12 h

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

Dry air dryer 2-4 h

## PROCESSING

Melt temperature: 250-270 °C

Mold temperature: 60-80 °C

Use open nozzle.