

Product Texts

- (PC PET)-blend, 15% mineral filled, easy flow, low coefficient of linear thermal expansion, easy release, injection molding. Molded parts from UT235M having exceptional dimensional stability.

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	4500	MPa	ISO 527
^[C] Stress at break	67	MPa	ISO 527
^[C] Strain at break	4	%	ISO 527
^[C] Charpy impact strength, +23°C	85	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	85	kJ/m ²	ISO 179/1eU
^[C] Puncture - maximum force, +23°C	4500	N	ISO 6603-2
^[C] Puncture energy, +23°C	36	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	114	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	128	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	45	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	45	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Water absorption	0.4	%	Sim. to ISO 62
^[C] Humidity absorption	0.2	%	Sim. to ISO 62
^[C] Density	1340	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	270	°C	ISO 294
Injection Molding, mold temperature	70	°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	110	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.01	%	-
Melt temperature	260 - 280	°C	-
Mold temperature	60 - 80	°C	-

Characteristics

Processing

Injection Molding

Additives

Release agent

Delivery form

Pellets

Regional Availability

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

Other text information

Injection molding

PREPROCESSING

Max. Water content: 0.01 %

Drying temperature: 110 °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: 260-280 °C
Mold temperature: 60-80 °C

Use open nozzle.