

XANTAR™ C MC 3650

(PC+ABS)...

Mitsubishi Engineering-Plastics Corporation

Product Texts

Vicat 110°C, Improved Impact

ISO 1043 (PC+ABS)...

[XANTAR Polycarbonate & Blends, your global partner for innovative added value](#)

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|--|-------|------------------------|-----------------|
| ISO Data | | | |
| ^[C] Melt volume-flow rate, MVR | 27 | cm ³ /10min | ISO 1133 |
| Temperature | 260 | °C | - |
| Load | 5 | kg | - |
| ^[C] Molding shrinkage, parallel | 0.6 | % | ISO 294-4, 2577 |

[C]: CAMPUS

| Mechanical properties | Value | Unit | Test Standard |
|--|-------|-------------------|---------------|
| ISO Data | | | |
| ^[C] Tensile Modulus | 1900 | MPa | ISO 527 |
| ^[C] Yield stress | 40 | MPa | ISO 527 |
| ^[C] Yield strain | 5 | % | ISO 527 |
| ^[C] Nominal strain at break | >50 | % | ISO 527 |
| ^[C] Charpy impact strength, +23°C | N | kJ/m ² | ISO 179/1eU |
| ^[C] Charpy impact strength, -30°C | N | kJ/m ² | ISO 179/1eU |
| ^[C] Charpy notched impact strength, +23°C | 50 | kJ/m ² | ISO 179/1eA |
| ^[C] Charpy notched impact strength, -30°C | 40 | kJ/m ² | ISO 179/1eA |

[C]: CAMPUS

| Thermal properties | Value | Unit | Test Standard |
|--|-------|-------|----------------|
| ISO Data | | | |
| ^[C] Temp. of deflection under load, 1.80 MPa | 93 | °C | ISO 75-1/-2 |
| ^[C] Vicat softening temperature, B | 111 | °C | ISO 306 |
| ^[C] Coeff. of linear therm. expansion, parallel | 70 | E-6/K | ISO 11359-1/-2 |
| ^[C] Coeff. of linear therm. expansion, normal | 70 | E-6/K | ISO 11359-1/-2 |

[C]: CAMPUS

| Other properties | Value | Unit | Test Standard |
|------------------------------------|-------|-------------------|----------------|
| ^[C] Water absorption | 0.7 | % | Sim. to ISO 62 |
| ^[C] Humidity absorption | 0.2 | % | Sim. to ISO 62 |
| ^[C] Density | 1100 | kg/m ³ | ISO 1183 |

[C]: CAMPUS

| Test specimen production | Value | Unit | Test Standard |
|--|-------|------|---------------|
| ISO Data | | | |
| ^[C] Injection Molding, melt temperature | 280 | °C | ISO 294 |
| Injection Molding, mold temperature | 80 | °C | ISO 294 |

[C]: CAMPUS

| Processing Recommendation Injection Molding | Value | Unit | Test Standard |
|---|-----------|------|---------------|
| Pre-drying - Temperature | 100 | °C | - |
| Pre-drying - Time | 4 | h | - |
| Processing humidity | ≤0.03 | % | - |
| Melt temperature | 240 - 270 | °C | - |
| Mold temperature | 50 - 80 | °C | - |
| Zone 1 | 230 - 250 | °C | - |
| Zone 2 | 235 - 255 | °C | - |
| Zone 3 | 240 - 260 | °C | - |
| Nozzle temperature | 230 - 250 | °C | - |

Characteristics**Processing**

Injection Molding

Additives

Release agent

Delivery form

Pellets

Regional Availability

Europe

Other text information**Injection molding**[Injection Molding Recommendations](#)