

**Product Texts**

Injection Molding, Unreinforced, Improved Impact

ISO 1043 (PET+PC)-I

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	30	cm <sup>3</sup> /10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
<sup>[C]</sup> Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
<sup>[C]</sup> Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	2200	MPa	ISO 527
<sup>[C]</sup> Yield stress	50	MPa	ISO 527
<sup>[C]</sup> Yield strain	4.5	%	ISO 527
<sup>[C]</sup> Nominal strain at break	10	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	55	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	20	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Puncture - maximum force, +23°C	4500	N	ISO 6603-2
<sup>[C]</sup> Puncture energy, +23°C	55	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	250	°C	ISO 11357-1/-3
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	90	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	120	°C	ISO 75-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	90	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	80	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Burning Behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Comparative tracking index	600	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
<sup>[C]</sup> Density	1220	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	270	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4 - 8	h	-

Processing humidity	≤0.02	%	-
Melt temperature	260 - 280	°C	-
Mold temperature	70 - 90	°C	-

**Characteristics****Processing**

Injection Molding

**Delivery form**

Pellets

**Special Characteristics**

High impact or impact modified, Heat stabilized or stable to heat

**Regional Availability**

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

**Other text information****Injection molding**

## PREPROCESSING

Residual moisture content: 0.00 - 0.02 %

Drying temperature circulating air dryer: 120 °C

Drying time circulating air dryer: 4 - 8 h

## PROCESSING

Melt temperature (Tmin - Tmax): 260 - 280 °C

admissible residence time at Tmax: ≤10 min

Mold temperature: 70 - 90 °C