

EPC DPONATE 1000U

DESCRIPTION

This PC material is unfilled grade that offers a medium flow rate for easy processing and molding, consistent and predictable behavior during molding, good dimensional stability and minimal warpage, suitable for a wide range of applications UV stabilized easy release for simplified molding. Availability in a range of opaque colors to suit various electrical parts requirement.

TECHNICAL DATA SHEET

PROPERTIES	TEST METHOD	TYPICAL VALUES	UNITS
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RHEOLOGICAL PROPERTIES

MVR at 300°C, 1.2kg Load	ISO 1133	10	CC/10min
MFR at 300°C, 1.2kg Load	ISO 1133	11	g/10min

MECHANICAL PROPERTIES

Tensile Stress, yield, 50 mm/min	ISO 527	70	MPa
Tensile Strain, break, 50 mm/min	ISO 527	70	%
Tensile Modulus, 1 mm/min	ISO 527	2500	MPa
Flexural Stress, yield, 2 mm/min	ISO 178	95	MPa
Flexural Modulus, 2 mm/min	ISO 178	2700	MPa
Izod Impact, notched 80*10*3 @23°C	ISO 21305/based on ISO 180/A	65	kJ/m ²

THERMAL PROPERTIES

Vicat Softening Temperature	ISO 306/B50	140	°C
Vicat Softening Temperature	ISO 306/B120	142	°C
HDT/Ae, 1.8 MPa	ISO 75-2/A	122	°C
HDT/Ae, 0.45 MPa	ISO 75-2/A	136	°C

PHYSICAL PROPERTIES

Density	ISO 1183	1.2	g/cm ³
Moisture Absorption	ISO 62	≤0.3	%

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FLAMMABILITY

GWFI @ 875°C @3mm	IEC 60695-2-12	PASS	°C
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INJECTION MOLDING

Drying Temperature	120	°C
Drying Time	4	Hrs.
Maximum Moisture Content	≤ 0.02	%
Melt Temperature	280 – 320	°C
Nozzle Temperature	290 – 300	°C
Front - Zone 3 Temperature	280 – 290	°C
Middle - Zone 2 Temperature	270 – 280	°C
Rear - Zone 1 Temperature	250 – 260	°C
Mold Temperature	80 – 100	°C

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