

## EPC DPONATE 2770R

### (PC FR)

#### DESCRIPTION

This PC compound is flame retardant that offers a balance of properties including moderate flow characteristic for ease of processing, UV stabilization for enhanced weather ability, 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 |
|------------|-------------|----------------|-------|
|------------|-------------|----------------|-------|

#### 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                      | 65   | MPa               |
| Tensile Strain at break, 50 mm/min | ISO 527                      | 70   | MPa               |
| Tensile Modulus, 1 mm/min          | ISO 527                      | 2350 | MPa               |
| Flexural Stress, yield, 2 mm/min   | ISO 178                      | 90   | 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 <sup>2</sup> |

#### 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 <sup>3</sup> |
| Moisture Absorption (23°C / 50% RH) | ISO 62   | ≤0.3 | %                 |

| PROPERTIES | TEST METHOD | TYPICAL VALUES | UNITS |
|------------|-------------|----------------|-------|
|------------|-------------|----------------|-------|

### FLAMMABILITY

| UL 94V-0 Flame Class Rating<br>(3mm) | UL 94          | V0   | Class |
|--------------------------------------|----------------|------|-------|
| GWFI 3mm @ 960°C                     | IEC 60695-2-12 | PASS | °C    |

### INJECTION MOLDING

|                             |           |      |
|-----------------------------|-----------|------|
| Drying Temperature          | 120       | °C   |
| Drying Time                 | 4         | Hrs. |
| Maximum Moisture Content    | ≤ 0.02    | %    |
| Melt Temperature            | 280 – 300 | °C   |
| Nozzle Temperature          | 265 – 275 | °C   |
| Front - Zone 3 Temperature  | 255 – 265 | °C   |
| Middle - Zone 2 Temperature | 250 – 260 | °C   |
| Rear - Zone 1 Temperature   | 245 – 250 | °C   |
| Mold Temperature            | 80 – 100  | °C   |

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