

ASTALOY™ PC/PET C70H20

Polycarbonate + PET
Marplex Australia Pty. Ltd.

Message:

ASTALOY™ PC/PET C70H20 is an alloy of Polycarbonate and Polyethylene Terephthalate (PET) polymer which features high impact strength, high heat resistance, chemical resistance and excellent processability. It is suitable for injection moulding in thin wall sections
C70H20 is a development grade. The physical properties reported below are based on limited experimental data and are subject to frequent review.
Note: The letters "U" or "W" indicate UV stabilisation has been added [ie: ASTALOY™ PC/PET C70H20U].

General Information			
Features	Impact resistance, high		
	Workability, good		
	Good chemical resistance		
	Heat resistance, high		
Uses	Thin wall parts		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (285°C/2.16 kg)	22	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.50	%	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	56.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	150	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2300	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	81.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	800	J/m	ASTM D256
Dart Drop Impact (3.20 mm)	70.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, unannealed, 3.20mm	114	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	120	°C	ASTM D648
1.8 MPa, unannealed, 12.7mm	125	°C	ASTM D648
Vicat Softening Temperature	155	°C	ASTM D1525 ⁵
CLTE - Flow	6.5E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value	Unit	Test Method

Flame Rating (1.60 mm)	HB	UL 94
Glow Wire Flammability Index (1.60 mm)	750	°C AS/NZS 60695.2.12
Injection	Nominal Value	Unit
Drying Temperature	120 - 130	°C
Drying Time	4.0 - 6.0	hr
Rear Temperature	250 - 260	°C
Middle Temperature	260 - 270	°C
Front Temperature	270 - 280	°C
Processing (Melt) Temp	270 - 290	°C
Mold Temperature	60.0 - 80.0	°C
Injection Pressure	60.0 - 140	MPa
Injection Rate	Slow-Moderate	
Back Pressure	0.300 - 1.00	MPa
Clamp Tonnage	4.0 - 8.0	kN/cm ²
Injection instructions		
Screw Speed: Minimum		
NOTE		
1.	5.0 mm/min	
2.	5.0 mm/min	
3.	1.3 mm/min	
4.	1.3 mm/min	
5.	压力1 (10N)	

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