

DURANEX® 702MS

Polycarbonate + PBT

Polyplastics Co., Ltd.

Message:

Better Surface Appearance, Higher Gloss, HB, GF reinforced, High rigidity, Low warpage , Less sink marks

General Information			
UL YellowCard	E213445-228999		
Filler / Reinforcement	Glass \mica, 55% filler by weight		
Features	Low warpage		
	Rigidity, high		
	Gloss, Medium		
	Good appearance		
UL File Number	E213445		
Forms	Particle		
Processing Method	Injection molding		
Part Marking Code (ISO 11469)	>PBT+PC-(GF+PS)55		
Physical	Nominal Value	Unit	Test Method
Density	1.73	g/cm ³	ISO 1183
Water Absorption (23°C, 24 hr)	0.10	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	153	MPa	ISO 527-2
Tensile Strain (Break)	1.3	%	ISO 527-2
Flexural Modulus	15500	MPa	ISO 178
Flexural Stress	205	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	6.5	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	197	°C	ISO 75-2/A
Linear thermal expansion coefficient			Internal method
Flow: 23 to 55°C	2.0E-5	cm/cm/°C	Internal method
Lateral: 23 to 55°C	4.0E-5	cm/cm/°C	Internal method
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	6.0E+15	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Additional Information	Nominal Value		
Color Number	ED3002		

Injection	Nominal Value	Unit
Drying Temperature	120 - 140	°C
Drying Time	3.0 - 5.0	hr
Processing (Melt) Temp	250 - 270	°C
Mold Temperature	40.0 - 80.0	°C
Holding Pressure	60.0 - 100	MPa
Screw Speed	100 - 150	rpm

Injection instructions

Cooling Time: Plasticization time + alpha or time without sticking in mold

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

