

TAROLON 2500

Polycarbonate

Taro Plast S.p.A.

Message:

Polycarbonate medium viscosity, standard grade for general purpose.
Available: all colors, UV stabilized (L), release agent (W).

General Information			
Additive	Mold Release		
	UV Stabilizer		
Features	General Purpose		
	Good Mold Release		
	Good UV Resistance		
	Medium Viscosity		
Uses	General Purpose		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	18	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955
Flow	0.50 to 0.70	%	
Across Flow	0.50 to 0.70	%	
Water Absorption			
23°C, 24 hr	0.12	%	ASTM D570, ISO 62
Saturation	0.35	%	ASTM D570
Saturation, 23°C	0.35	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2300	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	62.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	85	%	ASTM D638, ISO 527-2
Flexural Modulus	2500	MPa	ASTM D790, ISO 178
Flexural Stress			
-- ¹	85.0	MPa	ISO 178
Yield	85.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ² (23°C)	25	kJ/m ²	ASTM D256, ISO 179

Charpy Unnotched Impact Strength ³ (23°C)	> 300	kJ/m ²	ASTM D256, ISO 179
Notched Izod Impact (23°C, 3.20 mm)	600	J/m	ISO 180, ASTM D256
Unnotched Izod Impact (23°C, 3.20 mm)	No Break		ISO 180, ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	140	°C	ASTM D648, ISO 75-2/A
Continuous Use Temperature ⁴	120	°C	IEC 60216
Vicat Softening Temperature	150	°C	ISO 306/A50, ASTM D1525 ⁵
Ball Pressure Test (125°C)	Pass		VDE 0470
CLTE - Flow (-30 to 30°C)	7.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	> 1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (2.00 mm)	20	kV/mm	ASTM D149
Comparative Tracking Index (Solution A)	225	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-2		UL 94
Glow Wire Ignition Temperature (2.00 mm)	850	°C	IEC 60695-2-13
Oxygen Index	26	%	ASTM D2863
Injection	Nominal Value	Unit	
Drying Temperature			
--	100 to 110	°C	
Pre-heater	120 to 130	°C	
Drying Time			
--	1.0 to 2.0	hr	
Pre-heater	3.0	hr	
Processing (Melt) Temp	260 to 290	°C	
Mold Temperature	80.0 to 100	°C	
Injection Rate	Moderate-Fast		
NOTE			
1.	Yield		
2.	6x4x50 mm		
3.	6x4x50 mm		
4.	20000 hrs		
5.	Rate A (50°C/h), Loading 1 (10 N)		

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