

# Latilon 28D

Polycarbonate

LATI S.p.A.

## Message:

Polycarbonate (PC).

Low smoke toxicity index and optical density. Very high dimensional stability. Very good surface appearance.

| General Information |                            |  |  |
|---------------------|----------------------------|--|--|
| Features            | Good Dimensional Stability |  |  |
|                     | Good Surface Finish        |  |  |
|                     | Low Optical Density        |  |  |
|                     | Low Smoke Emission         |  |  |

| Physical                       | Nominal Value | Unit              | Test Method |
|--------------------------------|---------------|-------------------|-------------|
| Density                        | 1.20          | g/cm <sup>3</sup> | ISO 1183    |
| Molding Shrinkage <sup>1</sup> |               |                   | ISO 294-4   |
| Across Flow : 2.00 mm          | 0.55 to 0.75  | %                 |             |
| Flow : 2.00 mm                 | 0.60 to 0.75  | %                 |             |

| Mechanical      | Nominal Value | Unit | Test Method |
|-----------------|---------------|------|-------------|
| Tensile Modulus |               |      | ISO 527-2/1 |
| 23°C            | 2400          | MPa  |             |
| 60°C            | 2100          | MPa  |             |
| 90°C            | 1800          | MPa  |             |
| 120°C           | 1600          | MPa  |             |
| Tensile Stress  |               |      | ISO 527-2/5 |
| Yield, 23°C     | 60.0          | MPa  |             |
| Yield, 60°C     | 50.0          | MPa  |             |
| Yield, 90°C     | 40.0          | MPa  |             |
| Yield, 120°C    | 30.0          | MPa  |             |
| Tensile Strain  |               |      | ISO 527-2/5 |
| Yield, 23°C     | 6.0           | %    |             |
| Yield, 60°C     | 4.5           | %    |             |
| Yield, 90°C     | 3.5           | %    |             |
| Yield, 120°C    | 2.5           | %    |             |

| Impact                           | Nominal Value | Unit              | Test Method |
|----------------------------------|---------------|-------------------|-------------|
| Charpy Notched Impact Strength   |               |                   | ISO 179/1eA |
| -20°C                            | 8.0           | kJ/m <sup>2</sup> |             |
| 23°C                             | 10            | kJ/m <sup>2</sup> |             |
| Charpy Unnotched Impact Strength |               |                   | ISO 179/1eU |
| -20°C                            | No Break      |                   |             |

| 23°C                                    | No Break                     |          |             |
|-----------------------------------------|------------------------------|----------|-------------|
| Notched Izod Impact (23°C, 3.20 mm)     | 800                          | J/m      | ASTM D256A  |
| Thermal                                 | Nominal Value                | Unit     | Test Method |
| Heat Deflection Temperature             |                              |          |             |
| 0.45 MPa, Unannealed                    | 125                          | °C       | ISO 75-2/B  |
| 1.8 MPa, Unannealed                     | 120                          | °C       | ISO 75-2/A  |
| Continuous Use Temperature <sup>2</sup> | 120                          | °C       |             |
| Vicat Softening Temperature             | 135                          | °C       | ISO 306/B50 |
| CLTE - Flow (30 to 100°C)               | 3.0E-5                       | cm/cm/°C | ASTM D696   |
| Flammability                            | Nominal Value                | Unit     | Test Method |
| Oxygen Index                            | 26                           | %        | ASTM D2863  |
| Injection                               | Nominal Value                | Unit     |             |
| Drying Temperature                      | 120 to 130                   | °C       |             |
| Drying Time                             | 3.0                          | hr       |             |
| Processing (Melt) Temp                  | 270 to 290                   | °C       |             |
| Mold Temperature                        | 100 to 120                   | °C       |             |
| Injection Rate                          | Fast                         |          |             |
| NOTE                                    |                              |          |             |
| 1.                                      | at 60 Mpa of cavity pressure |          |             |
| 2.                                      | 20,000 hr                    |          |             |

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