

# ASTALON™ S2000UR

Polycarbonate  
Marplex Australia Pty. Ltd.

Message:

ASTALON™ S2000UR / S2001UR / S2003UR are the standard medium viscosity (medium melt flow) grades in the ASTALON™ range and are well suited to general purpose injection moulding applications which require a mould release agent (R) and UV stabilisation (U). Offering an exceptional combination of transparency, toughness, heat resistance, flame retardancy and processability, typical applications include automotive taillight housings and safety helmet visors.

Note: [ Standard grade = S2000UR ] / [ FDA approved = S2001UR ] / [ Steam resistant = S2003UR ].

General Information			
Additive	Mold Release		
	UV Stabilizer		
Features	Flame Retardant		
	General Purpose		
	Good Processability		
	Good Toughness		
	Medium Clarity		
	Medium Flow		
	Medium Heat Resistance		
	Medium Viscosity		
Uses	Automotive Applications		
	General Purpose		
	Safety Equipment		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.24	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	123		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>1</sup> (3.20 mm)	64.0	MPa	ASTM D638
Tensile Elongation <sup>2</sup> (Break, 3.20 mm)	120	%	ASTM D638
Flexural Modulus <sup>3</sup> (6.40 mm)	2350	MPa	ASTM D790
Flexural Strength <sup>4</sup> (6.40 mm)	89.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method

Notched Izod Impact (3.20 mm)	880	J/m	ASTM D256
Gardner Impact (3.20 mm)	> 85.0	J	ASTM D3029
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	153	°C	
1.8 MPa, Unannealed, 6.40 mm	138	°C	
CLTE - Flow	6.5E-5	cm/cm/°C	ASTM D696
<b>Electrical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Volume Resistivity	2.1E+16	ohms·cm	ASTM D257
Dielectric Constant	2.85		ASTM D150
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating (1.60 mm)	V-2		UL 94
<b>Optical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Transmittance (Total, 3000 μm)	85.0	%	ASTM D1003
<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>	
Drying Temperature	120 to 125	°C	
Drying Time	4.0 to 6.0	hr	
Rear Temperature	245 to 265	°C	
Middle Temperature	260 to 280	°C	
Front Temperature	275 to 295	°C	
Processing (Melt) Temp	270 to 300	°C	
Mold Temperature	60.0 to 110	°C	
Injection Pressure	60.0 to 140	MPa	
Injection Rate	Moderate		
Back Pressure	0.100 to 0.500	MPa	
Screw Speed	40 to 60	rpm	
Clamp Tonnage	4.0 to 8.0	kN/cm <sup>2</sup>	
<b>NOTE</b>			
1.	20 mm/min		
2.	20 mm/min		
3.	2.8 mm/min		
4.	2.8 mm/min		

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