

# Visiloy™ 2615R11U2

Polycarbonate + PBT

Technical Polymers, LLC

Message:

Visiloy™ 2615R11U2 is a Polycarbonate + PBT (PC+PBT) material filled with 11% glass fiber. It is available in North America for extrusion or injection molding.

Important attributes of Visiloy™ 2615R11U2 are:

Flame Rated

UV Stabilized

General Information			
Filler / Reinforcement	Glass Fiber,11% Filler by Weight		
Additive	UV Stabilizer		
Forms	Pellets		
Processing Method	Extrusion		
	Injection Molding		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm³	ASTM D792

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (23°C)	86.2	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	4.0	%	ASTM D638
Flexural Modulus (23°C)	3790	MPa	ASTM D790
Flexural Strength (23°C)	131	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	64	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	116	°C	ASTM D648

Flammability	Nominal Value	Test Method	
Flame Rating	HB	UL 94	

Injection	Nominal Value	Unit	
Drying Temperature	110	°C	
Drying Time	4.0 to 6.0	hr	
Processing (Melt) Temp	260 to 282	°C	
Mold Temperature	65.6 to 98.9	°C	
Injection Rate	Moderate-Fast		
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	30 to 80	rpm	
Clamp Tonnage	4.1 to 8.3	kN/cm²	
Cushion	3.18 to 6.35	mm	
Screw L/D Ratio	20.0:1.0		

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#### Recommended distributors for this material

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