

TAROLON 2011

Polycarbonate

Taro Plast S.p.A.

Message:

Polycarbonate low viscosity, transparent grade, good flow for low thickness walls.
Available: UV stabilized (L), release agent (W).

General Information			
Additive	Mold Release		
	UV Stabilizer		
Features	Good Flow		
	Good Mold Release		
	Good UV Resistance		
	Low Viscosity		
Uses	Thin-walled Parts		
Appearance	Clear/Transparent		
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)	22	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	0.14	%	ASTM D570, ISO 62
Saturation	0.30	%	ASTM D570
Saturation, 23°C	0.30	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2300	MPa	ASTM D638, ISO 527-2
Tensile Strength (Yield)	60.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	80	%	ASTM D638, ISO 527-2
Flexural Modulus	2500	MPa	ASTM D790, ISO 178
Flexural Stress			
-- ¹	80.0	MPa	ISO 178
Yield	80.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ² (23°C)	20	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)	500	J/m	ISO 180, ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	135	°C	ASTM D648, ISO 75-2/A
Vicat Softening Temperature	148	°C	ISO 306/A50, ASTM D1525 ⁴
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.	Rate A (50°C/h), Loading 1 (10 N)		

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