

XANTAR™ CM 206

Mitsubishi Engineering-Plastics Corp - Polycarbonate + ABS

General Information			
Product Description			
PC/ABS, Vicat 110°C			
General			
RoHS Compliance		• RoHS Compliant	
ASTM & ISO Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density	1.12	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (260°C/5.0 kg)	42	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	40	cm³/10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow	0.50 to 0.70	%	
Flow	0.50 to 0.70	%	
Water Absorption (Saturation, 23°C)	0.70	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2100	MPa	ISO 527-1/1
Tensile Stress (Yield)	45.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	4.0	%	
Break	> 50	%	
Flexural Modulus ²	2200	MPa	ISO 178
Flexural Stress ²	75.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	15	kJ/m²	
23°C	35	kJ/m²	
Charpy Unnotched Impact Strength			ISO 179
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength			ISO 180/4A
-40°C	15	kJ/m²	
-20°C	30	kJ/m²	
23°C	65	kJ/m²	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	95.0	°C	
Vicat Softening Temperature	110	°C	ISO 306
CLTE			ISO 11359-2
Flow	7.0E-5	cm/cm/°C	
Transverse	7.0E-5	cm/cm/°C	



XANTAR™ CM 206

Mitsubishi Engineering-Plastics Corp - Polycarbonate + ABS

Thermal	Nominal Value	Unit	Test Method
Effective Thermal Diffusivity	1.00E-7	m²/s	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093
Dielectric Constant (1 MHz)	2.90		IEC 60250
Comparative Tracking Index (CTI)	PLC 0		UL 746A
Comparative Tracking Index	275	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.5 mm	HB		
3.0 mm	HB		
Glow Wire Flammability Index			IEC 60695-2-12
1.5 mm	675	°C	
3.0 mm	675	°C	
Glow Wire Ignition Temperature			IEC 60695-2-13
1.5 mm	700	°C	
3.0 mm	700	°C	
Oxygen Index	21	%	ISO 4589-2
Fill Analysis	Nominal Value	Unit	
Melt Density	1.02	g/cm³	
Melt Thermal Conductivity	0.22	W/m/K	
Specific Heat Capacity of Melt	2280	J/kg/°C	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature - Hot Air Dryer	100	°C
Drying Time - Hot Air Dryer	4.0	hr
Rear Temperature	240 to 270	°C
Middle Temperature	240 to 270	°C
Front Temperature	240 to 270	°C
Nozzle Temperature	240 to 270	°C
Mold Temperature	50 to 80	°C
Ejection Temperature	90	°C

