

Pocan® C1206 000000
 (PET+PC)-I

Envalior

Injection Molding, Unreinforced, Improved Impact

ISO 1043 (PET+PC)-I

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	30	cm³/10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2200	MPa	ISO 527
Yield stress	50	MPa	ISO 527
Yield strain	4.5	%	ISO 527
Nominal strain at break	10	%	ISO 527
Impact Strength (Charpy), +23°C	no break	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	no break	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	55	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	20	kJ/m²	ISO 179/1eA
Puncture - maximum force, +23°C	4500	N	ISO 6603-2
Puncture energy, +23°C	55	J	ISO 6603-2

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	250	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	90	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	120	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	90	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	80	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB	class	UL 94
Thickness tested	1.5	mm	-

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Comparative tracking index	600	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Density	1220	kg/m³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	270	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	4 - 8	h	-
Processing humidity	≤0.02	%	-
Melt temperature	260 - 280	°C	-
Mold temperature	70 - 90	°C	-

Characteristics
Processing

Injection Molding

Special Characteristics

Impact modified, Heat aging stabilized

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Delivery form

Pellets

Injection Molding

PREPROCESSING

Residual moisture content: 0.00 - 0.02 %

Drying temperature circulating air dryer: 120 °C

Drying time circulating air dryer: 4 - 8 h

PROCESSING

Melt temperature (Tmin - Tmax): 260 - 280 °C

admissible residence time at Tmax: <=10 min

Mold temperature: 70 - 90 °C
