

**Apec® 2095**

 Covestro - Polycarbonates - *Polycarbonate*
**General Information**
**Product Description**

MVR (330°C/2.16kg) 8 cm<sup>3</sup>/10 min; high viscosity; easy release; 'softening temperature (VST/B 120)=203°C; injection molding - melt temperature 330 - 340°C; Covers for brake lights and indicator lights; Recessed light fixtures/reflectors; Blade-type fuses; Headlamp reflectors/bezels

**General**

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Features	• Good Flow	• Good Mold Release	• High Viscosity
Uses	• Automotive Applications	• Lighting Applications	
	• Automotive Backlights	• Reflectors	
RoHS Compliance	• RoHS Compliant		
Processing Method	• Injection Molding		

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density (73°F)	1.13	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (330°C/2.16 kg)	8.0	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (330°C/2.16 kg)	8.0	cm <sup>3</sup> /10min	ISO 1133
Molding Shrinkage <sup>2</sup>			ISO 294-4
Across Flow : 0.0787 in	0.90	%	
Flow : 0.0787 in	0.90	%	
Water Absorption (Saturation, 73°F)	0.30	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.12	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	348000	psi	ISO 527-1/1
Tensile Stress (Yield, 73°F)	10900	psi	ISO 527-2/50
Tensile Strain (Yield, 73°F)	6.8	%	ISO 527-2/50
Nominal Tensile Strain at Break (73°F)	> 50	%	ISO 527-2/50
Flexural Modulus <sup>3</sup> (73°F)	355000	psi	ISO 178
Flexural Stress <sup>3</sup> (73°F)	16000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	No Break		
73°F	No Break		
Hardness	Nominal Value	Unit	Test Method
Ball Indentation Hardness	18900	psi	ISO 2039-1
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	378	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	343	°F	ISO 75-2/A
Vicat Softening Temperature	397	°F	ISO 306/B120
CLTE - Flow (73 to 131°F)	3.6E-5	in/in/°F	ISO 11359-2
CLTE - Transverse (73 to 131°F)	3.6E-5	in/in/°F	ISO 11359-2
RTI Elec	302	°F	UL 746B
RTI Imp	266	°F	UL 746B
RTI Str	302	°F	UL 746B
Electrical	Nominal Value	Unit	Test Method



Surface Resistivity	1.0E+16 ohms	IEC 60093
Volume Resistivity (73°F)	1.0E+17 ohms·cm	IEC 60093
Electric Strength (73°F, 0.0394 in)	890 V/mil	IEC 60243-1
Relative Permittivity		IEC 60250
73°F, 100 Hz	2.90	
73°F, 1 MHz	2.80	
Dissipation Factor		IEC 60250
73°F, 100 Hz	1.0E-3	
73°F, 1 MHz	9.0E-3	
Comparative Tracking Index		IEC 60112
Solution A	600 V	
Solution B	100 V	
Electrolytic Corrosion (73°F)	A1	IEC 60426
<b>Flammability</b>	<b>Nominal Value Unit</b>	<b>Test Method</b>
Flame Rating (0.06 in)	HB	UL 94
Glow Wire Flammability Index (0.08 in)	1470 °F	IEC 60695-2-12
Oxygen Index <sup>4</sup>	25 %	ISO 4589-2
<b>Optical</b>	<b>Nominal Value Unit</b>	<b>Test Method</b>
Refractive Index <sup>5</sup>	1.566	ISO 489

### Processing Information

Injection	Nominal Value Unit
Drying Temperature - Dry Air Dryer	266 °F
Drying Time - Dry Air Dryer	2.0 to 3.0 hr
Suggested Max Moisture	< 0.020 %
Suggested Shot Size	30 to 70 %
Rear Temperature	563 to 581 °F
Middle Temperature	581 to 599 °F
Front Temperature	599 to 617 °F
Nozzle Temperature	617 to 635 °F
Processing (Melt) Temp	626 to 644 °F
Mold Temperature	266 to 302 °F
Back Pressure	725 to 2180 psi
Vent Depth	9.8E-4 to 3.0E-3 in

### Injection Notes

Hold Pressure (% of Injection Pressure): 50 - 75%  
Peripheral Screw Speed: 0.05 - 0.2 m/s  
Standard Melt Temperature: 335°C

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 60x60x2mm

<sup>3</sup> 0.079 in/min

<sup>4</sup> Procedure A

<sup>5</sup> Method A

