

## TECHNICAL DATA SHEET

# XANTAR™ G4F 22 R

Mitsubishi EP  
PC-GF20 FR

### Processing

Injection molding

### Delivery Form

Pellets

### Additives

Release agent

### Special Characteristics

Flame retardant, Heat stabilized or stable to heat

## Product Text

### Product Information

20% Glass Reinforced, Flame Retardant

ISO 1043 PC-GF20 FR

XANTAR Polycarbonate & Blends, your global partner for innovative added value

Processing/Physical Characteristics	Value	Unit	Standard
Melt volume-flow rate, MVR	8	cm <sup>3</sup> /10min	ISO 1133
Temperature	300	°C	
Load	1.2	kg	
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577
Density of melt	1170	kg/m <sup>3</sup>	
Thermal conductivity of melt	0.29	W/(m K)	
Spec. heat capacity of melt	1530	J/(kg K)	
Eff. thermal diffusivity	1.62E-7	m <sup>2</sup> /s	
Ejection temperature	134	°C	
Mechanical Properties	Value	Unit	Standard
Tensile modulus	6000	MPa	ISO 527
Stress at break	90	MPa	ISO 527
Strain at break	4	%	ISO 527
Poisson's ratio	0.35		ISO 527

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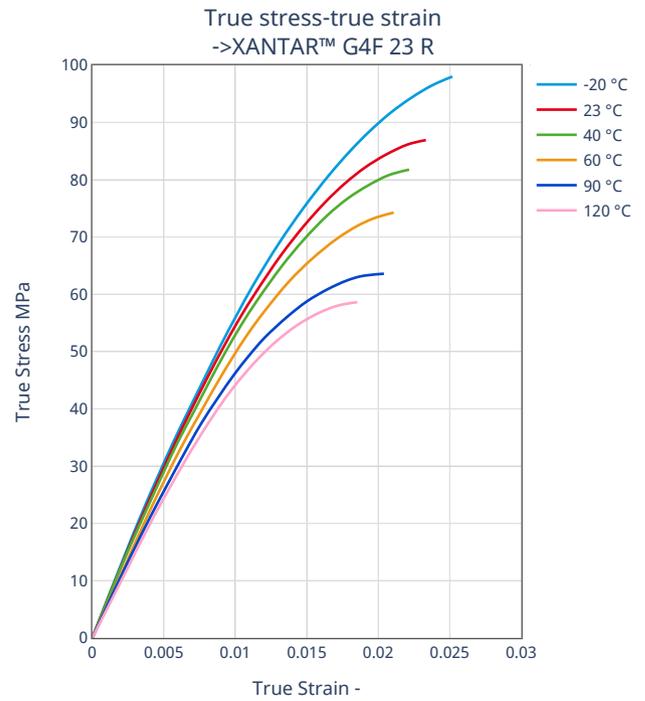
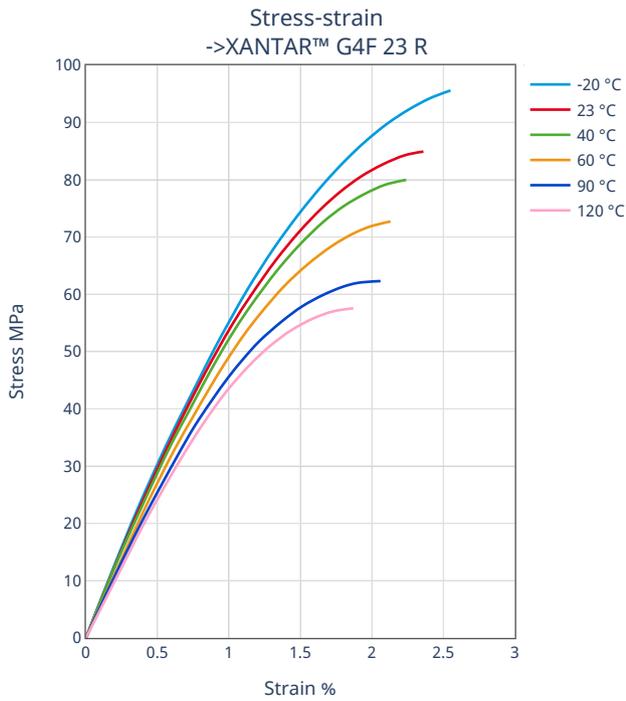
Thermal Properties	Value	Unit	Standard
Temp. of deflection under load, 1.80 MPa	145	°C	ISO 75-1/-2
Vicat softening temperature, B	150	°C	ISO 306
Coeff. of linear therm. expansion, parallel	25	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	
Yellow card available	yes		
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	1.2	mm	
Yellow card available	yes		
Oxygen index	35	%	ISO 4589-1/-2
Electrical Properties	Value	Unit	Standard
Relative permittivity, 100Hz	3.25		IEC 62631-2-1
Relative permittivity, 1MHz	3.2		IEC 62631-2-1
Dissipation factor, 100Hz	9	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	90	E-4	IEC 62631-2-1
Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Electric strength	29	kV/mm	IEC 60243-1
Comparative tracking index	200		IEC 60112
Other Properties	Value	Unit	Standard
Water absorption	0.29	%	Sim. to ISO 62
Density	1350	kg/m <sup>3</sup>	ISO 1183
Test Specimen Production	Value	Unit	Standard
Injection molding, melt temperature	300	°C	ISO 294
Injection molding, mold temperature	100	°C	ISO 294
Processing Recommendation Injection Molding	Value	Unit	Standard
Pre-drying - temperature	120	°C	
Pre-drying - time	4	h	
Processing humidity	≤0.03	%	
Melt temperature	290 - 320	°C	
Mold temperature	80 - 120	°C	
Zone 1	260 - 280	°C	

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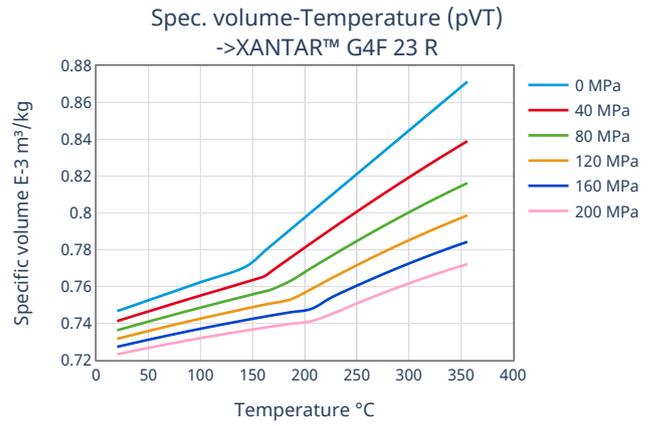
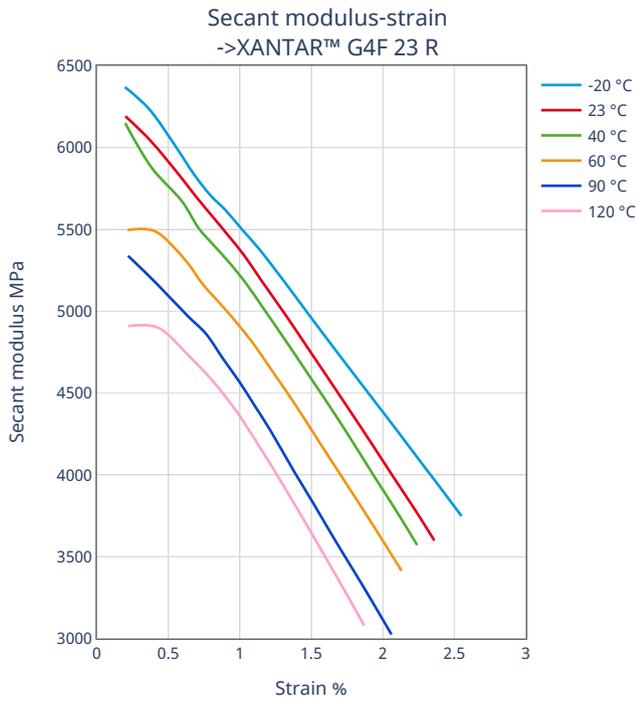
Processing Recommendation Injection Molding	Value	Unit	Standard
Zone 2	270 - 290	°C	
Zone 3	280 - 300	°C	
Nozzle temperature	270 - 290	°C	

## Diagrams



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Injection Molding Recommendations