

TECHNICAL DATA SHEET

XANTAR™ F 25 R

Mitsubishi EP

PC FR

Processing

Injection molding, Other extrusion, Blow molding

Delivery Form

Pellets

Additives

Release agent

Special CharacteristicsFlame retardant, Heat stabilized or stable to heat,
Transparent**Product Text****Product Information**

High Viscosity, Flame Retardant, Molding Release

ISO 1043 PC FR

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Processing/Physical Characteristics	Value	Unit	Standard
Melt volume-flow rate, MVR	5	cm ³ /10min	ISO 1133
Temperature	300	°C	
Load	1.2	kg	
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Density of melt	1010	kg/m ³	
Thermal conductivity of melt	0.24	W/(m K)	
Spec. heat capacity of melt	1710	J/(kg K)	
Eff. thermal diffusivity	1.4E-7	m ² /s	
Ejection temperature	131	°C	

Mechanical Properties	Value	Unit	Standard
Tensile modulus	2300	MPa	ISO 527
Yield stress	60	MPa	ISO 527
Yield strain	6	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Poisson's ratio	0.35		ISO 527

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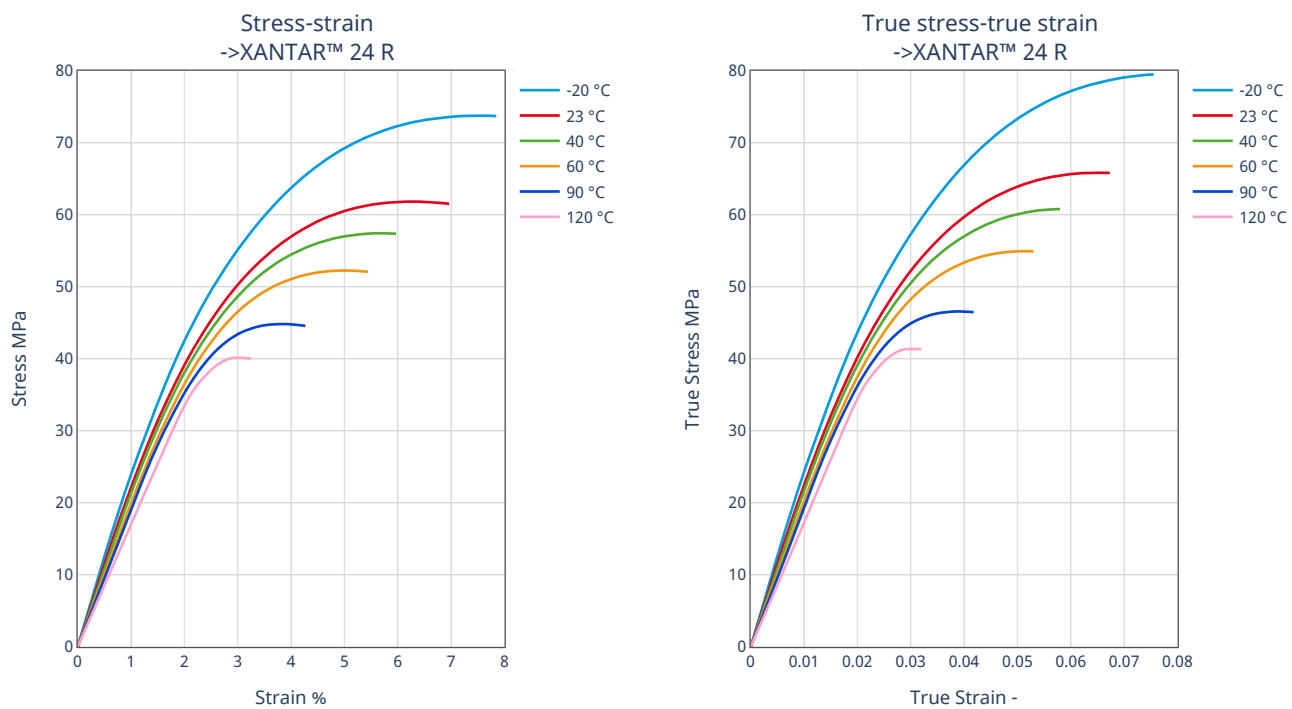
Thermal Properties	Value	Unit	Standard
Temp. of deflection under load, 1.80 MPa	130	°C	ISO 75-1/-2
Vicat softening temperature, B	150	°C	ISO 306
Coeff. of linear therm. expansion, parallel	65	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	V-2	class	IEC 60695-11-10
Thickness tested	1.5	mm	
Yellow card available	yes		
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	3	mm	
Yellow card available	yes		
Oxygen index	35	%	ISO 4589-1/-2
Electrical Properties	Value	Unit	Standard
Relative permittivity, 100Hz	3		IEC 62631-2-1
Relative permittivity, 1MHz	2.9		IEC 62631-2-1
Dissipation factor, 100Hz	6.6	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	92	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	225		IEC 60112
Other Properties	Value	Unit	Standard
Water absorption	0.35	%	Sim. to ISO 62
Density	1200	kg/m ³	ISO 1183
Material Specific Properties	Value	Unit	Standard
Viscosity number	63	cm ³ /g	ISO 307, 1157, 1628
Test Specimen Production	Value	Unit	Standard
Injection molding, melt temperature	300	°C	ISO 294
Injection molding, mold temperature	90	°C	ISO 294
Processing Recommendation Injection Molding	Value	Unit	Standard
Pre-drying - temperature	120	°C	
Pre-drying - time	4	h	
Processing humidity	≤0.03	%	

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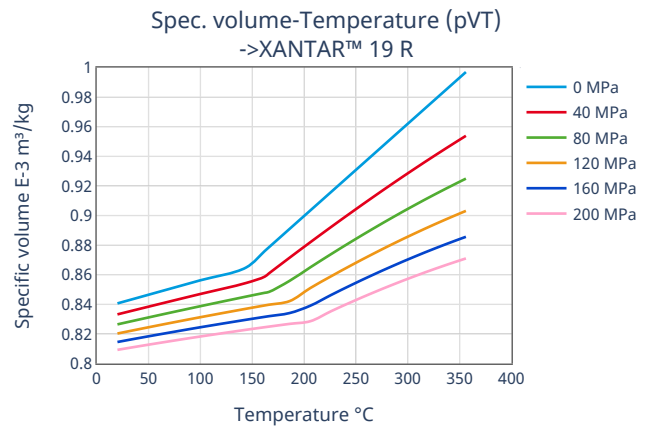
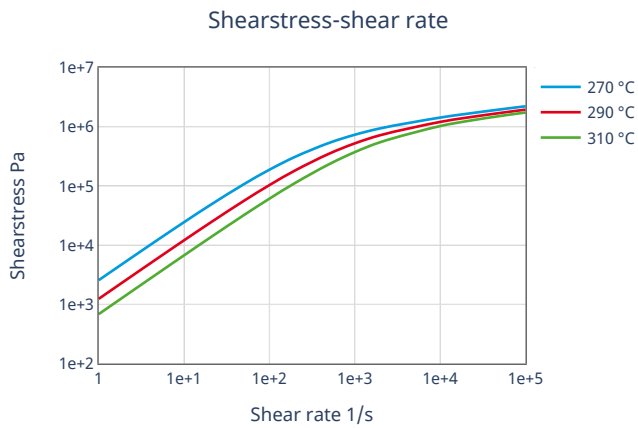
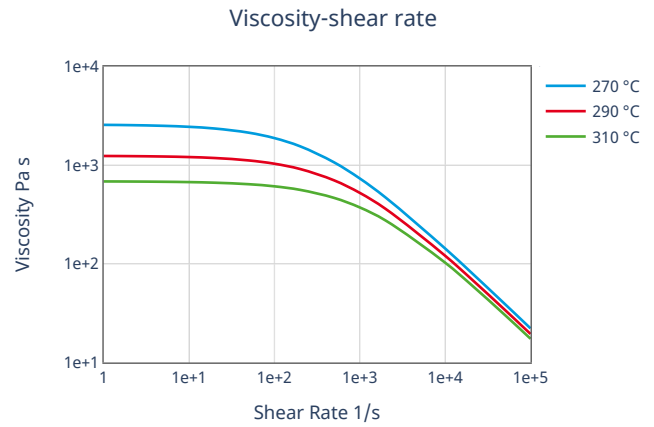
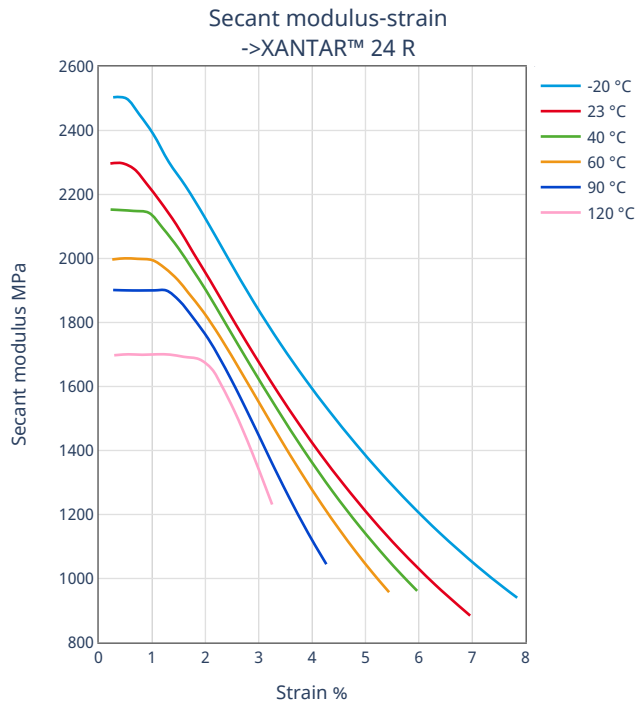
Processing Recommendation Injection Molding	Value	Unit	Standard
Melt temperature	290 - 320	°C	
Mold temperature	80 - 120	°C	
Zone 1	260 - 280	°C	
Zone 2	270 - 290	°C	
Zone 3	280 - 300	°C	
Nozzle temperature	270 - 290	°C	

Diagrams



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Processing Information

Injection molding

Injection Molding Recommendations