

POCAN® C 3230 XF 000000

Polycarbonate + PBT

LANXESS GmbH

Message:

PBT+PC, 30 % glass fibers, injection molding, improved flowability, low tendency to warp, improved surface finish

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Good liquidity		
	Excellent appearance		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.43	g/cm ³	ISO 1183
Apparent Density	0.82	g/cm ³	ISO 60
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	25.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction: 250°C, 2.00mm ¹	0.60	%	ISO 294-4
Vertical flow direction: 120°C, 2 hours, 2.00mm ²	0.20	%	ISO 294-4
Flow direction: 250°C, 2.00mm ³	0.40	%	ISO 294-4
Flow direction: 120°C, 2 hours, 2.00mm ⁴	0.20	%	ISO 294-4
Viscosity Number (Reduced Viscosity)	80.0	ml/g	ISO 1628
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	7500	MPa	ISO 527-2/1
Tensile Stress (Break, 23°C)	95.0	MPa	ISO 527-2/5
Tensile Strain (Break, 23°C)	2.6	%	ISO 527-2/5
Flexural Modulus ⁵ (23°C)	7400	MPa	ISO 178/A
Flexural Stress ⁶ (23°C)	155	MPa	ISO 178
Flexural Strain at Flexural Strength ⁷ (23°C)	2.7	%	
ISO Shortname	PBT+PC, GHMR, 09-080, GF30		ISO 7792
Residual Moisture Content	0.0 - 0.020	%	Karl Fisher
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	< 10	kJ/m ²	ISO 179/1eA
23°C	10	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	50	kJ/m ²	ISO 179/1eU
23°C	45	kJ/m ²	ISO 179/1eU

Notched Izod Impact			ISO 180/1A
-30°C	< 10	kJ/m ²	ISO 180/1A
23°C	10	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	45	kJ/m ²	ISO 180/1U
23°C	45	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	165	°C	ISO 75-2/B
1.8 MPa, not annealed	120	°C	ISO 75-2/A
Vicat Softening Temperature	145	°C	ISO 306/B120
Melting Temperature ⁸	225	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow: 23 to 55°C	3.0E-5	cm/cm/°C	ISO 11359-2
Lateral: 23 to 55°C	8.0E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	Test Method
Drying Temperature - Circulation Dryer	120	°C	
Drying Time - Circulation Dryer	4.0 - 8.0	hr	
Processing (Melt) Temp	240 - 260	°C	
Mold Temperature	80.0 - 100	°C	
NOTE			
1.	60x60x2; WZ 80°C; 600 Bar		
2.	60x60x2		
3.	60x60x2; WZ 80°C; 600 Bar		
4.	60x60x2		
5.	2.0 mm/min		
6.	2.0 mm/min		
7.	Pull Rate: 2 mm/min; 50% RH		
8.	10°C/min		

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