# MAJORIS FC185C - 1298

### Polypropylene

#### AD majoris

#### Message:

FC185C - 1298 is a mineral filled high performance compound intended for injection moulding. FC185C - 1298 is intended for component, which require very good surface quality, rigidity, low shrinkage and high dimensional stability. APPLICATIONS Electrical appliances Household articles Technical components

General Information			
Filler / Reinforcement	Mineral filler		
Features	Good dimensional stability		
	Rigidity, high		
	Recyclable materials		
	Low shrinkage		
	Good appearance		
	Excellent appearance		
Uses	Electrical/Electronic Applications		
	Electrical appliances		
	Household goods		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.03	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/2.16	20		100 1100
kg)	20	g/10 min	ISO 1133
Molding Shrinkage (2.00 mm)	1.5	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2250	MPa	ISO 527-2/1
Tensile Stress (Break)	30.0	MPa	ISO 527-2/50
Flexural Modulus <sup>1</sup>	2000	MPa	ISO 178
Flexural Stress	55.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.2	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	54	kJ/m²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	111	°C	ISO 75-2/B

1.8 MPa, not annealed         71.0         °C         ISO 75-2/A           Ball Pressure Test (120°C)         Pass         IEC 60695-10-2           Flammability         Nominal Value         Unit         Test Method           Flame Rating         HB         UL 94         Glow Wire Flammability Index (2.00 mm)         650         °C         IEC 60695-2-12           Injection         Nominal Value         Unit         Test Method         Unit           Drying Temperature         80.0         °C         IEC 60695-2-12           Injection         Nominal Value         Unit         Test Method           Drying Temperature         80.0         °C         IEC 60695-2-12           Injection Rate         3.0         hr         IEC 60695-2-12           Mold Temperature         3.0         °C         IEC 60695-2-12           Injection Rate         Moderate         IEC 60695-2-12         IEC 60695-2-12           Injection instructions         IEC 600         °C         IEC 60695-2-12           Injection instructions         IEC 600         °C         IEC 600           Injection instructions         IEC 600         °C         IEC 600           Injection instructions         IEC 600         IEC 600         IEC 600						
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Mold Temperature     30.0 - 50.0     °C       Injection Rate     Moderate       Injection instructions       Holding pressure: 50 to 70% of the injection pressure       NOTE	Drying Time	3.0	hr			
Injection Rate     Moderate       Injection instructions     Holding pressure: 50 to 70% of the injection pressure       NOTE     NOTE	Processing (Melt) Temp	210 - 260	°C			
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	Holding pressure: 50 to 70% of the injection pressure					
1. 2.0 mm/min	NOTE					
	1.	2.0 mm/min				

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