

ASTALON™ K2000UR

Polycarbonate
Marplex Australia Pty. Ltd.

Message:

ASTALON™ K2000UR is a medium flow, flame retardant Polycarbonate that is designed to meet the stringent Underwriter's Laboratory UL94 V-0 test whilst offering improved indoor colour stability, heat resistance and exceptional balance of impact toughness, product rigidity and mouldability. Typical applications include computer casing mouldings, electrical switchgear assemblies and whitegoods clothes dryer doors.

General Information	
Additive	Flame Retardant
Features	Flame Retardant
	Good Color Stability
	Good Impact Resistance
	Good Moldability
	Medium Flow
	Medium Heat Resistance
	Medium Rigidity
Uses	Electrical/Electronic Applications
	White Goods & Small Appliances

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	17	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.00 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.24	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	58.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	200	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2200	MPa	ASTM D790
Flexural Strength ⁴ (6.40 mm)	90.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	700	J/m	ASTM D256
Gardner Impact (3.20 mm)	65.0	J	ASTM D3029
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 6.40 mm	131	°C	
1.8 MPa, Unannealed, 12.7 mm	139	°C	
CLTE - Flow	6.5E-5	cm/cm/°C	ASTM D696

Flammability	Nominal Value	Test Method
Flame Rating (1.60 mm)	V-0	UL 94

Injection	Nominal Value	Unit
Drying Temperature	120 to 125	°C
Drying Time	4.0 to 6.0	hr
Rear Temperature	230 to 250	°C
Middle Temperature	245 to 265	°C
Front Temperature	260 to 280	°C
Processing (Melt) Temp	255 to 270	°C
Mold Temperature	60.0 to 110	°C
Injection Pressure	60.0 to 140	MPa
Injection Rate	Moderate	
Back Pressure	0.100 to 0.500	MPa
Screw Speed	30 to 50	rpm
Clamp Tonnage	4.0 to 8.0	kN/cm ²

NOTE		
1.	20 mm/min	
2.	20 mm/min	
3.	2.8 mm/min	
4.	2.8 mm/min	

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