

TAROLON 2500 G4 X1

Polycarbonate

Taro Plast S.p.A.

Message:

Polycarbonate medium viscosity, 20% glass fiber reinforced, self extinguishing UL94 V1, good mechanical properties also at high temperature, good dimensional stability.
UL 94 V1 approved all colors at 1,6 mm and V0 at 3,5 mm.
Available: in natural and opaque colors.

General Information			
UL YellowCard	E143048-312233		
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	Good Dimensional Stability		
	High Stiffness		
	Medium Heat Resistance		
	Medium Viscosity		
	Self Extinguishing		
Appearance	Natural Color		
	Opaque		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.33 to 1.35	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	12	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage - Flow	0.30 to 0.50	%	ASTM D955
Water Absorption			
23°C, 24 hr	0.080	%	ASTM D570, ISO 62
Saturation	0.25	%	ASTM D570
Saturation, 23°C	0.25	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6000	MPa	ASTM D638, ISO 527-2
Tensile Strength (Break)	90.0	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break)	4.0	%	ASTM D638, ISO 527-2
Flexural Modulus	5500	MPa	ASTM D790, ISO 178
Flexural Stress			
-- 1	155	MPa	ISO 178
-- 2	145	MPa	ISO 178
Yield	155	MPa	ASTM D790
Break	145	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³ (23°C)	9.0	kJ/m ²	ASTM D256, ISO 179
Charpy Unnotched Impact Strength ⁴ (23°C)	42	kJ/m ²	ASTM D256, ISO 179
Notched Izod Impact (23°C, 3.20 mm)	130	J/m	ISO 180, ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	142	°C	ASTM D648, ISO 75-2/A
Continuous Use Temperature			
--	80.0	°C	UL 746B
-- ⁵	135	°C	IEC 60216
Vicat Softening Temperature	153	°C	ISO 306/A50, ASTM D1525 ⁶
Ball Pressure Test (135°C)	Pass		VDE 0470
CLTE - Flow (-30 to 30°C)	3.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	> 1.0E+16	ohms·cm	ASTM D257
Dielectric Strength (2.00 mm)	22	kV/mm	ASTM D149
Comparative Tracking Index (Solution A)	175	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-1		UL 94
Glow Wire Ignition Temperature (2.00 mm)	960	°C	IEC 60695-2-13
Oxygen Index	31	%	ASTM D2863
Injection	Nominal Value	Unit	
Drying Temperature			
--	100 to 110	°C	
Pre-heater	120 to 130	°C	
Drying Time			
--	1.0 to 2.0	hr	
Pre-heater	3.0	hr	
Processing (Melt) Temp	260 to 300	°C	
Mold Temperature	100 to 120	°C	
Injection Rate	Fast		
NOTE			
1.	Yield		
2.	Break		
3.	6x4x50 mm		
4.	6x4x50 mm		
5.	20000 hrs		
6.	Rate A (50°C/h), Loading 1 (10 N)		

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