

Durethan® C 1206 00000

Polycarbonate + PET

LANXESS GmbH

Message:

PET+PC, non-reinforced, injection molding, improved impact strength

General Information			
Features	Good Impact Resistance		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.22	g/cm ³	ISO 1183
Apparent Density	0.80	g/cm ³	ISO 60
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	30.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 2577
Across Flow : 270°C, 2.00 mm ¹	0.70	%	
Across Flow : 120°C, 4 hr, 2.00 mm ²	0.30	%	
Flow : 270°C, 2.00 mm ³	0.70	%	
Flow : 120°C, 4 hr, 2.00 mm ⁴	0.30	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2200	MPa	ISO 527-2/1
Tensile Stress (Yield, 23°C)	50.0	MPa	ISO 527-2/50
Tensile Strain (Yield, 23°C)	4.5	%	ISO 527-2/50
Nominal Tensile Strain at Break (23°C)	10	%	ISO 527-2/50
Flexural Modulus ⁵ (23°C)	2200	MPa	ISO 178/A
Flexural Stress			ISO 178/A
3.5% Strain, 23°C	65.0	MPa	
23°C ⁶	75.0	MPa	
Flexural Strain at Flexural Strength ⁷ (23°C)	5.0	%	ISO 178/A
ISO Shortname	PET+PC, GHMPR, 09-020		ISO 7792
Admissible Residence Time at Tmax	< 10.0	min	
Residual Moisture Content	0.0 to 0.020	%	Karl Fisher
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	20	kJ/m ²	
23°C	55	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength			ISO 180/1A

-30°C	15	kJ/m ²	
23°C	50	kJ/m ²	
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	No Break		
23°C	No Break		
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	120	°C	ISO 75-2/B
1.8 MPa, Unannealed	90.0	°C	ISO 75-2/A
Vicat Softening Temperature	130	°C	ISO 306/B120
Melting Temperature ⁸	250	°C	ISO 11357-3
CLTE			ISO 11359-2
Flow : 23 to 55°C	9.0E-5	cm/cm/°C	
Transverse : 23 to 55°C	8.0E-5	cm/cm/°C	
Injection	Nominal Value	Unit	Test Method
Drying Temperature - Circulation Dryer	120	°C	
Drying Time - Circulation Dryer	4.0 to 8.0	hr	
Processing (Melt) Temp	260 to 280	°C	
Mold Temperature	70.0 to 90.0	°C	
NOTE			
1.	60x60x2mm, 80°C MT, 600 bar		
2.	60x60x2mm		
3.	60x60x2mm, 80°C MT, 600 bar		
4.	60x60x2mm		
5.	2.0 mm/min		
6.	2.0 mm/min		
7.	2 mm/min		
8.	10°C/min		

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