

DPONATE 2770R

(Flame Retardant with Moderate Flow)

DESCRIPTION

This PC material is flame retardant grade that offers a balance of properties including moderate flow characteristic for ease of processing, UV stabilization for enhanced weather ability, easy release for simplified molding availability in a range of opaque colors to suit various electrical parts requirement.

PROVISIONAL TECHNICAL DATA SHEET

PROPERTIES	TEST METHOD	TYPICAL VALUES	UNITS
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RHEOLOGICAL PROPERTIES

MVR at 300°C, 1.2kg Load	ISO 1133	10	CC/10min
MFR at 300°C, 1.2kg Load	ISO 1133	11	g/10min

MECHANICAL PROPERTIES

Tensile Stress, yield, 50 mm/min	ISO 527	65	MPa
Tensile Stress, break, 50 mm/min	ISO 527	70	MPa
Tensile Modulus, 1 mm/min	ISO 527	2350	MPa
Flexural Stress, yield, 2 mm/min	ISO 178	95	MPa
Flexural Modulus, 2 mm/min	ISO 178	2400	MPa
Izod Impact, notched 80*10*3 +23°C	ISO 180/1A	65	kJ/m ²

THERMAL PROPERTIES

Vicat Softening Temperature	ISO 306/B50	140	°C
Vicat Softening Temperature	ISO 306/B120	142	°C
HDT/Ae, 1.8 MPa	ISO 75-2/A	122	°C
HDT/Ae, 0.45 MPa	ISO 75-2/A	136	°C

PHYSICAL PROPERTIES

Density	ISO 1183	1.2	g/cm ³
Moisture Absorption (23°C / 50% RH)	ISO 62	0.15	%

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FLAMMABILITY

UL 94V-0 Flame Class Rating (1.6mm)	UL 94	V0	Class
GWFI 3mm @ 960°C	IEC 60695-2-12	PASS	°C

INJECTION MOLDING

Drying Temperature	120	°C
Drying Time	4	Hrs.
Maximum Moisture Content	≤ 0.02	%
Melt Temperature	280 – 300	°C
Nozzle Temperature	265 – 275	°C
Front - Zone 3 Temperature	255 – 265	°C
Middle - Zone 2 Temperature	250 – 260	°C
Rear - Zone 1 Temperature	245 – 250	°C
Mold Temperature	80 – 100	°C

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