



PRODUCT INFORMATION

TAROLON 2500 G6 X1

Polycarbonate medium viscosity 30% glass fibres reinforced, flame retardant UL94 V1, good mechanical properties also at high temperature, good dimensional stability.

ISO short ISO 1043: PC-GF30 FR
Form Pellets
UL file E143048

Key Features

- Good impact - stiffness balance
- Designed for injection moulding applications
- Halogen free
- Glass fibres reinforced

Availability

- W: lubricated
- Opaque colours
- LP: laser printable
- L: UV stabilized

Compliance

- UL94 V1 approved all colours at 1,6 mm and V0 at 3,5 mm.
- Halogens free according to DIN VDE 0472 part 815
- Halogens free according to IEC 61249-2-21

Process

- INJECTION MOULDING

Application

- Electronic
- Electrical
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	150		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm ³	1,43		
Filler content	ISO 3451	%	30	850°C - 1 h	
Water Absorption (24h / +23°C)	ISO 62	%	0,05		
Water Absorption at Saturation	ISO 62	%	0,20		
Mould Shrinkage (Parallel)	Internal method	%	0,15-0,2		
Mould Shrinkage (Normal)	Internal method	%	0,3-0,4		
Melt Volume Flow Rate (MVR)	ISO 1133	cm ³ /10min	8,5	300°C - 2,16 kg	

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MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	8000	Speed 1 mm/min
Elongation at Break	ISO 527-1,2	%	2,6	Speed 50 mm/min
Tensile Break Strength	ISO 527-1,2	MPa	126	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	7800	Speed 1 mm/min
IZOD Notched Impact	ASTM D256	J/m	140	+23°C
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m ²	15	

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	158	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	148	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	135	
Continuous service temperature (20.000 h)	UL746 B	°C	130	
Continuous service temperature	UL746 B	°C	80	UL approved

FLAMMABILITY

Flame Behaviour (1,6 mm)	UL94	Class	V1	UL approved
Flame Behaviour (3,5 mm)	UL94	Class	V0	UL approved
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	960	
Oxygen index	ASTM D2863	%	36	

INJECTION MOULDING

	Value
Drying Temperature (Desiccant Dryer)	120°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	0,02 %
Suggested Max Re grind	< 15 %
Melt Temperature	260 - 290°C
Feed Temperature	80 - 100°C
Rear Temperature	250 - 270°C
Middle Temperature	260 - 280°C
Front Temperature	270 - 285°C



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Nozzle Temperature	275 - 295°C
Mould Temperature	80 - 120°C
Injection Rate	Medium to Fast
Back Pressure	As low as possible (< 0,3 Mpa)
Screw Revolving Speed	25 - 50 rpm
Screw Revolving Speed	50 rpm @ Diameter 40 mm
Screw Revolving Speed	35 rpm @ Diameter 55 mm
Screw Revolving Speed	25 rpm @ Diameter 75 mm
Cushion	3 - 5 mm
Vent Depth	0,05 mm

Notes During processing, a dehumidifying hopper dryer is recommended at a temperature of 60 to 80°C.