



PRODUCT INFORMATION

TAROLON 2500 G6

Polycarbonate medium viscosity 30% glass fibres reinforced, very good mechanical properties also at high temperature, good dimensional stability, low shrinkage.

ISO short Form ISO 1043: PC-GF30 Pellets

Key Features

- Good impact - stiffness balance
- High stiffness
- Designed for injection moulding applications
- Glass fibres reinforced
- Good dimensional stability

Availability

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

Process

- INJECTION MOULDING

Application

- Electronic
- Electrical
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Volume Resistivity	IEC 60093	Ohm cm	>10E(15)		
Dielectric Strength	IEC 60243-1	kV/mm	24	2 mm	
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	175		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm ³	1,44		
Glass Fiber content	Internal method	%	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 - 0,35		
Mould Shrinkage (Normal)	Internal method	%	0,35 - 0,55		

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Melt Flow Rate (MFR)	ISO 1133	g/10 min	4,5	300°C - 1,2 kg
Melt Volume Flow Rate (MVR)	ISO 1133	cm ³ /10min	4	300°C - 1,2 kg

MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	8200	Speed 1 mm/min
Elongation at Break	ISO 527-1,2	%	2,8	Speed 50 mm/min
Tensile Break Strength	ISO 527-1,2	MPa	105	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	7500	Speed 2 mm/min
Flexural Break Strength	ISO 178	MPa	195	Speed 10 mm/min
IZOD Notched Impact (+23°C)	ASTM D256	J/m	130	
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m ²	9	
CHARPY Unnotched Impact (+23°C)	ISO 179/1eU	kJ/m ²	44	

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	155	50°C / h
Softening Temperature - 5 kg (VST/B/50)	ISO 306	°C	144	
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	142	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	135	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K ⁻¹	2,5x10E(-5)	-30°C /+30°C

FLAMMABILITY

Flame Behaviour (1,6 mm)	UL94	Class	V1	
Flame Behaviour (3,2 mm)	UL94	Class	V1	
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	850	
Oxygen index	ASTM D2863	%	32	

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 %



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Melt Temperature	260 - 300°C
Feed Temperature	80 - 100°C
Rear Temperature	260 - 270°C
Middle Temperature	270 - 290°C
Front Temperature	280 - 295°C
Nozzle Temperature	285 - 300°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.