PRODUCT INFORMATION

TAROLON 2500 W G2 X0

Polycarbonate medium viscosity, 10% glass fiber reinforced, flame retardant UL94 V0, good stiffness and mechanical properties.

ISO short	ISO 1043: PC-GF10 FR
Form	Pellets
UL file	E143048

Key Features

- Glass fibres reinforced
- Flame retardant
- Good flowability
- Antimony trioxide free

Availability

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

Compliance

- UL94 V0 approved all colours at 0,97 mm. UL746 B approved.

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	150		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm^3	1,27		
Filler content	ISO 3451	%	10	850°C - 1 h	
Water Absorption (24h / +23°C)	ISO 62	%	0,08		
Water Absorption at Saturation	ISO 62	%	0,25		
Mould Shrinkage (Parallel)	Internal method	%	0,3 - 0,5		
Mould Shrinkage (Normal)	Internal method	%	0,5 - 0,7		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	8	300°C - 1,2 kg	

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MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	3500	Speed 5 mm/min
Tensile Yield Strength	ISO 527-1,2	MPa	75	Speed 50 mm/min
Elongation at Break	ISO 527-1,2	%	8	Speed 50 mm/min
Tensile Break Strength	ISO 527-1,2	MPa	65	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	3700	Speed 1 mm/min
Flexural Yield Strength	ISO 178	MPa	125	Speed 1 mm/min

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	152	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	135	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	125	
Continuous service temperature	UL746 B	°C	80	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K^-1	3,3x10E(-5)	-30°C /+30°C

FLAMMABILITY

Flame Behaviour (0,97 mm)	UL94	Class	V0	UL approved
Oxigen index	ASTM D2863	%	35	

INJECTION MOULDING	Value
Drying Temperature (Desiccant Dryer)	120°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	0,02 %
Suggested Max Regrind	< 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
Nozzle Temperature	275 - 295°C
Mould Temperature	80 - 120°C
Injection Rate	Medium to Fast

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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. The processing parameters like processing temperatures are a recommendation and can be adjusted in function of injection machine or extruder size, part geometry and design.