*PRODUCT INFORMATION*

# TAROLON 2500

Polycarbonate medium viscosity, standard grade for general purpose.

**ISO short** ISO 1043: PC
**Form** Pellets

## Key Features

- Designed for injection moulding applications
- Good flowability
- Good surface aspect

## Availability

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

## Process

- INJECTION MOULDING

## Application

- General purpose applications
- Electrical
- Automotive

| Property | Method | Unit | Value | Condition | State |
|---|---|---|---|---|---|
| **ELECTRICAL** | | | | | |
| Volume Resistivity | IEC 60093 | Ohm cm | >10exp(15) | | |
| Dielectric Strength | IEC 60243-1 | kV/mm | 20 | 2 mm | |
| Dissipation Factor Frequency | IEC 60250 | - | 0,001 | | |
| Dielectric Constant | IEC 60250 | - | 2,9 | | |
| Tracking Resistance (CTI - Method A) | IEC 60112 | Volt | 225 | | |
| **PHYSICAL** | | | | | |
| Density (+23°C) | ISO 1183 | g/cm^3 | 1,20 | | |
| Water Absorption at Saturation | ISO 62 | % | 0,35 | | |
| Mould Shrinkage (Parallel) | Internal method | % | 0,5 - 0,7 | | |
| Mould Shrinkage (Normal) | Internal method | % | 0,5 - 0,7 | | |
| Melt Flow Rate (MFR) | ISO 1133 | g/10 min | 18 | 300°C - 1,2 kg | |
| **MECHANICAL** | | | | | |

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|---|---|---|---|---|
| Tensile Modulus | ISO 527-1,2 | MPa | 2400 | Speed 1 mm/min |
| Tensile Yield Strength | ISO 527-1,2 | MPa | 71 | Speed 50 mm/min |
| Elongation at Break | ISO 527-1,2 | % | 98 | Speed 50 mm/min |
| Flexural Modulus | ISO 178 | MPa | 2500 | Speed 1 mm/min |
| Flexural Max Strength | ISO 178 | MPa | 85 | Speed 1 mm/min |
| IZOD Notched Impact | ASTM D256 | J/m | 600 | +23°C |
| IZOD Unnotched Impact | ASTM D256 | J/m | N.B. | +23°C |
| CHARPY Notched Impact (+23°C) | ISO 179/1eA | kJ/m^2 | 30 | |
| CHARPY Unnotched Impact (+23°C) | ISO 179/1eU | kJ/m^2 | N.B. | |
| **THERMAL** | | | | |
| Softening Temperature - 1 kg (VST/A/50) | ISO 306 | °C | 150 | 50°C / h |
| Deflection Temperature 1,80 MPa (HDT A) | ISO 75A | °C | 140 | 120°C / h |
| Ball Pressure Test | IEC 60695-10-2 | °C | 125 | |
| Continuous service temperature (20.000 h) | UL746 B | °C | 120 | |
| Coefficient of linear thermal expansion (parallel) | ISO 11359-1,-2 | K^-1 | 7x10exp(-5) | -30°C /+30°C |
| **FLAMMABILITY** | | | | |
| Flame Behaviour (1,6 mm) | UL94 | Class | V2 | |
| Glow Wire Flammability Index-GWFI (2 mm) | IEC 60695-2-12 | °C | 850 | |
| Glow Wire Flammability Index-GWFI (3,2 mm) | IEC 60695-2-12 | °C | 960 | |
| Oxigen index | ASTM D2863 | % | 26 | |

| **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 | 270 - 300°C |
| Feed Temperature | 60 - 80°C |
| Rear Temperature | 260 - 280°C |

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| | |
|---|---|
| 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 |
| Screw Revolving Speed | 50 - 150 rpm |
| 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.