



PRODUCT INFORMATION

TAROLON 2520

Polycarbonate medium viscosity, for general purpose applications.

ISO short Form ISO 1043: PC
UL file Pellets
E143048

Key Features

- Designed for injection moulding applications
- Good flowability

Availability

- W: lubricated
- LP: laser printable
- L: UV stabilized
- DB: dry blend coloured
- All transparent colours
- All colours

Compliance

- UL94 V2 approved all colours at 1,6 mm thickness.

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	20	2 mm	
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	225		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm ³	1,21		
Water Absorption (24h / +23°C)	ISO 62	%	0,12		
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		



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Melt Flow Rate (MFR)	ISO 1133	g/10 min	18	300°C - 1,2 kg
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MECHANICAL

Tensile Modulus	ISO 527-1,2	MPa	2300	Speed 1 mm/min
Tensile Yield Strength	ISO 527-1,2	MPa	62	Speed 50 mm/min
Elongation at Break	ISO 527-1,2	%	85	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 (+23°C)	ASTM D256	J/m	600	
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m ²	25	
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	
Coefficient of linear thermal expansion (parallel)	ISO 11359-1,-2	K ⁻¹	7x10E(-5)	-30 °C /+30 °C

FLAMMABILITY

Flame Behaviour (0,75 mm)	UL94	Class	V2	
Flame Behaviour (1,6 mm)	UL94	Class	V2	UL approved
Flame Behaviour (3,0 mm)	UL94	Class	V2	
Glow Wire Flammability Index-GWFI (0,75 mm)	IEC 60695-2-12	°C	850	
Glow Wire Flammability Index-GWFI (2 mm)	IEC 60695-2-12	°C	850	
Oxygen 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 Re grind	< 15%



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Melt Temperature	270 - 300°C
Feed Temperature	60 - 80°C
Rear Temperature	260 - 280°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
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.