

**WITCOM**

A member of Wittenburg Group

Your partner in speciality engineering plastics compounds

Preliminary Data Sheet Witcom PP-C/4M-RA1 EXP2

20% talc, radar absorbing, electrically conductive, ultrasonically weldable

Latest revision: Oct. 2018

Properties	Test methods	Units	Witcom PP-C/4M-RA1 EXP2
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Physical properties

Specific gravity	ISO 1183	g/cm ³	1,15
Water absorption at saturation, 23 °C	ISO 62	%	0,02
Humidity absorption, 23 °C/50 % r.h.	ISO 62	%	0,01
Mould shrinkage (flow direction, 3 mm)	ISO 2577	%	0,5 - 0,8

Mechanical properties

Tensile strength (max.)	ISO 527	MPa	26
Elongation at break	ISO 527	%	>25
Flexural strength	ISO 178	MPa	30
Flexural modulus	ISO 178	GPa	1,8
IZOD impact strength, notched	ISO 180/1eA	kJ/m ²	25
IZOD impact strength, unnotched	ISO 180/1eU	kJ/m ²	no break

Thermal properties

Heat distortion temperature (1,81 MPa)	ISO 75	°C	55
Relative temperature index, 3 mm, with impact	UL 746B	°C	-
Coefficient of linear thermal expansion	ISO 11359	K·1·10 ⁻⁵	-

Flammability

Burning behaviour	IEC 60695-11-10	-	HB @ 3,2 mm
UL recognition	UL94	-	-

Electrical properties

Surface resistivity	ASTM D257	Ω/sq	10 ² - 10 ⁴
Comparative tracking index	IEC 60112	V	-
Glow wire rating, 1,6 mm	IEC 695-2-1	°C	-

Processing conditions (injection moulding)

Drying conditions (dehumidifying drier)	: 2 - 4 Hours @ 80 °C
Maximum allowable moisture content	: 0,05 %
Melt temperature	: 200 - 260 °C
Mould temperature	: 40 - 80 °C
Screw speed	: 0,1 - 0,25 m/s
Back pressure	: 0 - 1,0 MPa
Injection pressure	: Keep to a minimum
Injection speed	: Fast ram speed
Hold pressure	: Keep to a minimum

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