Properties

X7303L

Flame retardant PC/HIPS resin (UL94 V-1)

*The product(s) do not contain halogenated compounds as flame retardants and do not contain antimony compounds.

High flow

Properties	Test methods	Test conditions	Units	
Melt mass-flow rate	ISO 1133	220 deg C/10kg	g/10min	50
Mold shrinkage	ASTM D955	-	%	0.4-0.6
Tensile strength	ISO 527	-	MPa	48
Flexural strength	ISO 178	-	MPa	79
Flexural modulus	ISO 178	-	MPa	2600
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m2	41
Notched Izod impact strength	ASTM D256	23 deg C/6.4mm	J/m	290
Deflection temperature under load	ISO 75	1.80MPa	deg C	79
Deflection temperature under load	ASTM D648	1.82MPa/12.7mm	deg C	87
Vicat softening temperature	ISO 306/B50	50N X 50deg C/h	deg C	93
Coefficient of linear thermal expansion	ISO 11359	MD	X1E-5/deg C	7
Coefficient of linear thermal expansion	ISO 11359	TD	X1E-5/deg C	-
Flammability	UL94	-	-	V-1/1.8mm V-0/2.5mm 5VA/2.5mm
Water absorption	ISO 62	-	%	0.3
Density	ISO 1183	-	g/cm3	1.16

Note
・Values are typical, not quality assured.
・UL recognition File No. of Daicel Polymer is E47773.

Typical settings for processing

Preliminary drying	Barrel temperature(deg C)				Screw rotation (rpm)	Back pressure (MPa)	Mold temperature (deg C)
	Nozzle	Front	Middle	Back			
3-4hrs 75-80deg C	220-250	230-250	210-230	190-210	40-60	5-15	40-60

*The barrel temperature at the front zone should be over 230 deg C to avoid defective mechanical properties of moldings.