

## Technical Data Sheet

### Polyflam RPC 40400 GRY68290



Polycarbonate

#### Product Description

Flame retardant PC; halogen free according to DIN VDE 0472 part 815

**Processing Method** Injection Molding

**Attribute** Halogen Free

**Additive** Flame Retardant

Typical Properties	Nominal Value	Units	Test Method
<b>Physical</b>			
Melt Volume Flow Rate, (260 °C/5.0 kg)	25	cm <sup>3</sup> /10 min	ISO 1133
Density, (Method A)	1.18	g/cm <sup>3</sup>	ISO 1183
<b>Mechanical</b>			
Tensile Stress at Yield, (Type 1A, 50 mm/min)	60.0	MPa	ISO 527-2
Tensile Strain at Yield, (Type 1A, 50 mm/min)	5.0	%	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	2400	MPa	ISO 527-1
<b>Impact</b>			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	60	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	20	kJ/m <sup>2</sup>	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	No Break		ISO 179
(-30 °C, Type 1, Edgewise)	No Break		ISO 179
<b>Hardness</b>			
Ball Pressure Test, (105 °C)	Pass		IEC 60695-10-2
<b>Thermal</b>			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	110	°C	ISO 306
(A (10N), 50 °C/h)	115	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	103	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	95.0	°C	ISO 75-2/A
RTI Elec			
(1.5 mm)	80.0	°C	UL 746B
(3.0 mm)	80.0	°C	UL 746B

<b>RTI Imp</b>			
(1.5 mm)	80.0	°C	UL 746B
(3.0 mm)	80.0	°C	UL 746B
<b>RTI Str</b>			
(1.5 mm)	80.0	°C	UL 746B
(3.0 mm)	80.0	°C	UL 746B
<b>Electrical</b>			
Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1
Comparative Tracking Index (CTI)	225	V	IEC 60112
High Amp Arc Ignition			UL 746A
Surface Resistivity	>1.0E+15	ohm	IEC 60093
<b>Flammable</b>			
Hot-wire Ignition (HWI)			UL 746A
<b>Burning Rate</b>			
(2.00 mm, Self-Extinguishing)	0.0	mm/min	ISO 3795
(2.00 mm, Self-Extinguishing)	0.0	mm/min	FMVSS 302
<b>Glow Wire Flammability Index</b>			
(1.5 mm)	960	°C	IEC 60695-2-12
(3.0 mm)	960	°C	IEC 60695-2-12
<b>Glow Wire Ignition Temperature</b>			
(1.5 mm)	850	°C	IEC 60695-2-13
(3.0 mm)	775	°C	IEC 60695-2-13
Oxygen Index	33	%	ASTM D2863
<b>UL Information</b>			
<b>Flame Rating</b>			
(1.5 mm)	V-0		UL 94
(3.0 mm)	V-0		UL 94
(3.5 mm)	V-0		UL 94
(3.5 mm)	5VA		UL 94
UL File Number	E86615		

<b>Injection Parameters</b>	<b>Nominal Value</b>	<b>Units</b>
Drying Time	3.0 to 4.0	hr
Drying Temperature	100 to 120	°C
Suggested Max Moisture	0.02	%
Screw Speed	<250	mm/sec
Processing (Melt) Temp	260 to 270	°C
Injection Rate	Moderate-Fast	
Back Pressure	5.00 to 10.0	MPa
Mold Temperature	50 to 80	°C