

Properties**CE1810**

PC/Polyester resin

Standard

Properties	Test methods	Test conditions	Units	
Mold shrinkage	ASTM D955	-	%	0.5-0.7
Tensile strength	ISO 527	-	MPa	63
Flexural strength	ISO 178	-	MPa	90
Flexural modulus	ISO 178	-	MPa	2300
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m2	20
Deflection temperature under load	ISO 75	1.80MPa	deg C	115
Deflection temperature under load	ISO 75	0.45MPa	deg C	135
Density	ISO 1183	-	g/cm3	1.22

Note

•Values are typical, not quality assured.

Typical settings for processing

Preliminary drying	Barrel temperature(deg C)				Screw rotation (rpm)	Back pressure (MPa)	Mold temperature (deg C)
	Nozzle	Front	Middle	Back			
3-5hrs 110-120deg C	240-260	250-270	250-270	230-250	50-100	10-20	70-100