

SABIC® PC RESIN PC1003R

REGION ASIA

DESCRIPTION

PC1003R resin is a medium-low flow (MFR = 10 at 300?C/1.2kg), heat and UV stabilized, polycarbonate product with mold release designed for use in the general purpose molding market. It is available exclusively at www.sabicpc.com

TYPICAL PROPERTY VALUES

Revision 20201123

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	63	MPa	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	>70	%	ASTM D 638
Tensile Modulus, 50 mm/min	2350	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	90	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D790
Hardness, Rockwell R	120	-	ASTM D 785
Tensile Stress, yield, 50 mm/min	63	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	>70	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
Hardness, Rockwell R	120	-	ISO 2039-2
IMPACT			
Izod Impact, unnotched, 23°C	NB	J/m	ASTM D4812
Izod Impact, notched, 23°C	800	J/m	ASTM D 256
Instrumented Dart Impact Energy @ peak, 23°C	65	J	ASTM D3763
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	70	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	12	kJ/m²	ISO 180/1A
THERMAL			
Vicat Softening Temp, Rate B/50	143	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm	138	°C	ASTM D 648
HDT, 1.82 MPa, 3.2 mm	127	°C	ASTM D 648
CTE, -40°C to 95°C, flow	7.E-05	1/°C	ASTM E831
Thermal Conductivity	0.2	W/m-°C	ASTM C177
Thermal Conductivity	0.2	W/m-°C	ISO 8302
CTE, 23°C to 80°C, flow	7.E-05	1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	Passes	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50	143	°C	ISO 306
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	138	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	127	°C	ISO 75/Af



PROSECTIES TYPICAL VALUES UNITS TEST METHODS PHYSICAL SEPACEL GRAVITY ASTM 0792 Water Absorption, (2°C) Saturated) 0.35 8 ASTM 0797 Mold Shrinkage on Tensile Bart, flow 0.5 – 0.7 \$ SMC method Mold Shrinkage, flow, 3.2 mm 0.5 – 0.7 \$ SMC method Mell Flow, Rate, 300°C/1.2 kgt 10 9 (10 min STM 07238 Water Absorption, (2°C) (saturated) 0.5 2 0 (10 min) STM 07238 Water Absorption, (2°C) (saturated) 0.5 2 0 (10 min) STM 07238 Water Absorption, (2°C) (saturated) 9 0 (10 min) STM 07624 Water Absorption, (2°C) (saturated) 9 0 (10 min) STM 07624 Water Absorption, (2°C) (saturated) 9 0 (10 min) STM 07624 Water Absorption, (2°C) (saturated) 9 0 (10 min) STM 07624 Water Absorption, (2°C) (saturated) 9 0 (10 min) STM 0763 Water Absorption, (2°C) (saturated) 0 (2 min) ASIM 0703 Water Absorption, (2°C) (saturated) 0 (2 min) </th <th></th> <th></th> <th></th> <th></th>				
Specific Gravity 12 March Approtency 2**Cysturated) 12 ATM 1074 (2014) Water Absorption, C2**Cysturated) 0.5 3 ATM 1076 (2014) Mold Shrinkage, flow, 3.2 mm 55 7.7 3 Micro More Application (2014) 30 ATM 1012 (2014) Berlinky 1 2 10 10 ATM 1012 (2014) ATM 1012 (2014) Berlinky 2 3 3 4 10 2 10	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Water Absorption, (23°C/Saturated) 0.35 % (35M Defined) Mold Shrinkage on Tensile Bar, flow 0.5-0.7 % (35M Defined) Mold Shrinkage, flow, 3.2 mm 0.5-0.7 % (35M Defined) Mel Flow Rate, 300°C/1.2 kgf 10 g/m² 15M Design Density 12 g/m² 15M Design Mel Volume Rate, Mw Rat 300°C/1.2 kg 9 m²/l 0m² 10 133 Mater Absorption, (23°C) saturated) 8 9 % (37M Design) ASTM D1003 Mater Absorption, (23°C) saturated) 8 9 % (37M D1003) ASTM D1003 Mater Absorption, (23°C) saturated) 8 9 % ASTM D1003 Mater Absorption, (23°C) saturated) 9 8 9 ASTM D103 ASTM D1003 Mater Absorption, (23°C) saturated) 9 8 9 8 9 8 9 8 9 8 9 9 8 9 9 8 9 9 8 9 9 8 9 9 8 <td>PHYSICAL</td> <td></td> <td></td> <td></td>	PHYSICAL			
Mod Shrinkage, flow, 3.2 mm 05 - 0.7 % % Ack method Mol Shrinkage, flow, 3.2 mm 05 - 0.7 % 7 Ack method Density 1.2 gl-m² 05 1183 Water Absorption, (23° (raturated) 0.5 % 16 06-1 Melt Volume Rate, MVR at 30°C (1.2 kg) 88 - 90 % 50 06-1 Melt Volume Rate, MVR at 30°C (1.2 kg) 88 - 90 % ACT MID 1003 POTTICIA V X ACT MID 1003 Braze, 254 mm 88 - 90 % ACT MID 1003 Refractive Index 1.58 2 ACT MID 1003 Refractive Index 1.58 9 ACT MID 1003 Refractive Index 1.58 9 ACT MID 1003 Refractive Index 1.58 9 ACT MID 1003 Pollectric Strength, 1.6 mm 2 ACT MID 1003 ACT MID 1003 Relative Permittivity, 1 Mtz 3 4 ACT MID 1003 ACT MID 1003 Dissipation Factor, 1 Mtz 2 4 ACT MID 1003 ACT MID 1003	Specific Gravity	1.2	-	ASTM D792
Mode Shrinkage, flow, 3.2 mm 05-0.7 % Home Makes, 300°C/1.2 kgf 10-0 g/10 min ASTM D1288 Met Robs Agor, Cy1.2 kgf 12-2 (9 cm²) 305 183 <td< td=""><td>Water Absorption, (23°C/Saturated)</td><td>0.35</td><td>%</td><td>ASTM D570</td></td<>	Water Absorption, (23°C/Saturated)	0.35	%	ASTM D570
Met Frow Rato 300°C/1.2 kg/s 10 g/cm² MSD 183 Density 10 g/cm² 105 183 Met Volume Rate, MVR at 300°C/1.2 kg 9 m² 10 mm 50 1133 OPTICAL Ught Transmision, 2.54 mm 88 – 90 8 35 MD 1003 Refractive Index 8.9 9.0 8 ASIM D1003 Refractive Index 1.586 9.0 ASIM D103 ELECTRICA Ught Statistivity AIT D15 Million ASIM D150 D16 geneticitivity, Albuz AIT D15 Million ASIM D150 D16 geneticitivity, Albuz AIT D15 Million ASIM D150 D16 geneticitivity, Albuz AIT D15 ASIM D150 ASIM D150 D16 geneticitivity, Albuz ASIM D150	Mold Shrinkage on Tensile Bar, flow	0.5 – 0.7	%	SABIC method
Density 1.2 girm³ Sol 183 Water Absorption, Q3*C/saturated) 3.9 9 100 cc. 1 100 cc. 1 Melt Volume Rate, MNR at 30°C/12 kg 9 9 30 mill mill 100 cc. 1 OPTICIA. Franciscon, 2.54 mm 88-90 % ASTM D1003 Refractive Index 1.586 9 9 ASTM D1003 Refractive Index 1.586 9 0 ASTM D1003 Refractive Index 1.586 9 0 ASTM D1003 ELECTRICA V V V V V V V V V V V V ASTM D150 C C C C C C C C C ASTM D150 C C C ASTM D150 C C C C C C C	Mold Shrinkage, flow, 3.2 mm	0.5 – 0.7	%	SABIC method
Water Absorption, (23°C/saturated) 0.35 % 60-21 Melt Volume Rate, MVR at 300°C/1.2 kg 9 cm/l J min 50-133 UTION UTION USA PARTICLE MERCAN STANDING Refractive Index 88-90 \$ ASTM D1003 Refractive Index 1.586 9 9 8-80 Month 50-80 ASTM D1003 Refractive Index 1.586 9 9 8-90 Month 350 Month ASTM D1004 Refractive Index 2 0.05 ASTM D1004 ASTM D1004 Colspan="3">Co	Melt Flow Rate, 300°C/1.2 kgf	10	g/10 min	ASTM D1238
Melt Volume Rate, MVR at 300°C/1.2 kg9convious termsUPICALUsight Tanamission, 2.54 mm88–903ASTM D1003Ratea, 2.54 mm0.88ASTM D1003Refractive Index1.58690.8ASTM D103Refractive Index1.58690.8ASTM D154ELECTICALUsing ResistivityASTM D157Dielectric Strength, 1.6 mm27M/mmASTM D159Relative Permittivity, 6.0 kg3ASTM D150Relative Permittivity, 1.0 Mtz30ASTM D150Dissipation Factor, 1.0 Mtz0.019ASTM D150Dissipation Factor, 1.0 Mtz0.019ASTM D150Dissipation Factor, 1.0 Mtz2.1 £15M/mmEC06033Dislectric Strength, 1.6 mm27M/mmEC06033Relative Permittivity, 6.0 Hz3ASTM D150Relative Permittivity, 1.0 Mtz3CE06034Relative Permittivity, 1.0 Mtz3CE06035Dispitation Factor, 1.0 Mtz1CE06035Dispitation Factor, 2.0 Mtz1CE06035LEVEL CHARACTERISTICTUTUTUUR Recognized, 94V-2 Flame Class Rating1.6CE0703Diving Time2CE0703TUDrying Time2CE0703TUMaximum Moisture Content2CE0703Maximum Moisture Content2CE0703Time Transperture2CE0703TURoc	Density	1.2	g/cm³	ISO 1183
DePTICAL Light Transmission, 2.54 mm 88 – 90 % ASTM D1003 Haze, 2.54 mm <.0.86	Water Absorption, (23°C/saturated)	0.35	%	ISO 62-1
Light Transmision, 2.54 mm 88-90 % ASTM D1003 Haze, 2.54 mm 9.88 3.68 3.10 ATM D1003 Refractive Index 1.586 9 0.37M D542 ATM D542 Refractive Index 1.586 9 0.9 ATM D542 LECTRICAT Volume Resistivity 5 Mr. ASTM D150 Dielectric Strength, 1.6 mm 2 9 ASTM D150 Relative Pemititivity, 0 Hz 3 0.01 3 ASTM D150 Relative Pemititivity, 1 Mtz 0.01 0.01 3 ASTM D150 Displation Factor, 60 Hz 0.01 0.01 0.01 ASTM D150 Relative Pemititivity, 1 Mtz 2 0.01	Melt Volume Rate, MVR at 300°C/1.2 kg	9	cm³/10 min	ISO 1133
Haze, 2.54 mm< <a d03<="" not="" th="">Refractive Index1.586<a d05<="" not="" th="">Refractive Index1.586<a d05<="" not="" th="">ELECTRICALUnlime Resistivity>1.E+15<a d05<="" not="" th="">Dielectric Strength, 1.6 mm27<a d07<="" not="" th=""><a d05<="" not="" th="">Relative Pernittivity, 6 Mz3<a d05<="" not="" th=""><a d05<="" not="" th="">Relative Pernittivity, 1 MHz3<a d05<="" not="" th=""><a d05<="" not="" th="">Dissipation Factor, 6 OHz0.01<a d05<="" not="" th=""><a d05<="" not="" th="">Dissipation Factor, 1 MHz0.01<a d05<="" not="" th=""><a d05<="" not="" th="">Dissipation Factor, 1 MHz3<a d05<="" not="" th=""><a d05<="" not="" th="">Dissipation Factor, 1 MHz3<a d05<="" not="" th=""><a d05<="" not="" th="">Dissipation Factor, 1 MHz3<a d05<="" not="" th=""><a d05<="" not="" th="">Relative Pernittivity, 1 MHz3<a d05<="" not="" th=""><a d05<="" not="" th="">Dissipation Factor, 6 O Hz0<a d05<="" not="" th=""><a d05<="" not="" th="">Dissipation Factor, 6 O Hz0<a d05<="" not="" th=""><a d05<="" not="" th="">Dissipation Factor, 1 MHz0<a d05<="" not="" th=""><a d05<="" not="" th="">Dissipation Factor, 1 MHz0<a d05<="" not="" th=""><a d05<="" not="" th="">Dispitation Factor, 1 MHz0<a d05<="" not="" th=""><a d05<="" not="" th="">Dispitation Factor, 1 MHz0<a d05<="" not="" th=""><a d05<="" not="" th="">Dispitation Factor, 1 MHz0<a d05<="" not="" th=""><a d05<="" not="" th="">Dispitation Factor, 1 MHz0<a d05<="" not="" th=""><a d05<="" not="" th="">Dispitation Factor, 1 MHz<a d05<="" not="" th=""><a d05<="" not="" th=""><th< td=""><td>OPTICAL</td><td></td><td></td><td></td></th<>	OPTICAL			
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Refractive Index1.586ELECTRICALVolume Resistivity>1.64.15Dielectric Strength, 1.6 mm27 <td>Haze, 2.54 mm</td> <td><0.8</td> <td>%</td> <td>ASTM D1003</td>	Haze, 2.54 mm	<0.8	%	ASTM D1003
ELECTRICAL Volume Resistivity >1.6.15 Ohne-Cm ASTM 0257 Dielectric Strength, 1.6 mm 27 W/m ASTM 0149 Relative Permittivity, 6.0 Hz 3 ASTM 0150 Belative Permittivity, 1.MtAz 3 ASTM 0150 Dispiation Factor, 6.0 Hz 0.001 - ASTM 0150 Dispiation Factor, 1.MtAz 0.01 - ASTM 0150 Volume Resistivity 1.6.15 M/m IEC 60033 Dielectric Strength, 1.6 mm 27 W/m IEC 60024-1 Relative Permittivity, 6.0 Hz 3 - IEC 60025 Relative Permittivity, 1.Mtaz 3 - IEC 60025 Relative Permittivity, 1.Mtaz 3 - IEC 60025 Dispiation Factor, 6.0 Hz 0.01 - IEC 60025 Dispiation Factor, 6.0 Hz - IEC 60025 IEC 60025 Dispiation Factor, 6.0 Hz - IEC 60025 IEC 60025 Dispiation Factor, 6.0 Hz - IEC 60025 IEC 60025 Dispiation Factor, 6.0 Hz<	Refractive Index	1.586	-	ASTM D542
Volume Resistivity51.4±15OhmemoryASTM D159Dielectric Strength, 1.6 mm27W/l/mASTM D149Relative Permittivity, 60 Hz3-ASTM D150Relative Permittivity, 1 MHz3-ASTM D150Dissipation Factor, 60 Hz0.01-ASTM D150Dissipation Factor, 1 MHz0.01-ASTM D150Volume Resitivity0.1£±15OhmemoryIEC 60293Relative Permittivity, 1 60 Hz3-IEC 60250Relative Permittivity, 60 Hz3-IEC 60250Relative Permittivity, 1 MHz0.00-IEC 60250Dissipation Factor, 60 Hz0.00-IEC 60250Dissipation Factor, 60 Hz0.00-IEC 60250Dissipation Factor, 60 Hz0.00-IEC 60250Dissipation Factor, 60 Hz1.0-IEC 60250Dissipation Factor, 60 Hz1.0-IEC 60250UR Recognized, 94V-2 Flame class Rating1.6-IEC 60250Dissipation Factor, 60 Hz1.0-IEC 60250Drying Temperature2.4IEC 60250Drying Temperature2.0Mozzle Temperature2.0Mozzle Temperature2.0Mozzle Temperature2.0Mozzle Temperature2.0Mozzle Temperature2.0Mozzle Temperature<	Refractive Index	1.586	-	ISO 489
Dielectric Strength, 1.6 mm 27 Wr/mm ASTM D149 Relative Permittivity, 60 Hz 3 - ASTM D150 Relative Permittivity, 1 MHz 3 - ASTM D150 Dissipation Factor, 60 Hz 0.001 - ASTM D150 Volume Resistivity ASTM D150 - ASTM D150 Volume Resistivity My/mm ASTM D150 - Dielectric Strength, 1.6 mm 27 W/mm IEC 60093 - Relative Permittivity, 10 Mtz 3 - W/mm IEC 60243-1 - Relative Permittivity, 10 Mtz 3 -	ELECTRICAL			
Relative Permittivity, 1 MHz3-ASTM D150Dissipation Factor, 60 Hz.001-ASTM D150Dissipation Factor, 1 MHz.001-ASTM D150Volume Resistivity.1E+15Ohm.cmEC 60093Dielectric Strength, 1.6 mm27W/mmEC 60243·1Relative Permittivity, 0 Hbz3-EC 60250Belative Permittivity, 1 MHz3-EC 60250Dissipation Factor, 60 Hz.001-EC 60250Dissipation Factor, 60 Hz.001-EC 60250Dissipation Factor, 1 MHz.01EC 60250DISSIPATION FACTOR, 60 HzU. Recognized, 94V-2 Flame Class Rating16mmU. 94DISSIPATION MOLDINGDistriction Molbiure2-4hrs-Diving Time2-4hrs-Maximum Molsture Content.02Mekt Temperature20-20C-Nozale Temperature270-290C-Montale Temperature270-290C-Middle - Zone 2 Temperature260-280C-Rear-Zone 1 Temperature260-280C-Hopper Temperature260-280C-	Volume Resistivity	>1.E+15	Ohm-cm	ASTM D257
Relative Permittivity, 1 MHz 3 c. ASTM D150 Dissipation Factor, 60 Hz 0.001 - ASTM D150 Volume Resistivity >1.E+15 Ohm-cm IC 60093 Pollectric Strength, 1.6 mm 27 kV/mm IC 60024-1 Relative Permittivity, 60 Hz 3 - IC 60250 Relative Permittivity, 1 MHz 3 - IC 60250 Dissipation Factor, 60 Hz 0.001 - IC 60250 Dissipation Factor, 1 MHz - - IC 60250 UL RECORDIZED STATE (MECHANGE STATE STA	Dielectric Strength, 1.6 mm	27	kV/mm	ASTM D149
Dissipation Factor, 60 Hz 0.001 - 0.00 ASTM D150 Dissipation Factor, 1 MHz 0.01 - 0.00 ASTM D150 Volume Resistivity > 1.E+15 Olm-cm IC 60093 Diselectric Strength, 1.6 mm 27 W//mm IC 60243-1 Relative Permittivity, 60 Hz 3 - 0.00 EC 60250 Relative Permittivity, 1 MHz 3 - 0.00 EC 60250 Dissipation Factor, 60 Hz 0.001 - 0.00 EC 60250 Dissipation Factor, 1 MHz 0.01 - 0.00 EC 60250 LAME CHARACTERITICS TU TU V U 9.00 Diving Temperature 2-4 ns 1.00 9.00 1.00 <td>Relative Permittivity, 60 Hz</td> <td>3</td> <td>-</td> <td>ASTM D150</td>	Relative Permittivity, 60 Hz	3	-	ASTM D150
Dissipation Factor, 1 MHz0.01- Ohm-cmATM D150Volume Resistivity>1.£+15Ohm-cmIEC 60093Dielectric Strength, 1.6 mm27W/mmIEC 60243-1Relative Permittivity, 60 Hz3- Ohm-cmIEC 60250Relative Permittivity, 1 MHz3- Ohm-cmIEC 60250Dissipation Factor, 60 Hz0.001- Ohm-cmIEC 60250Dissipation Factor, 1 MHz0.01- Ohm-cmIEC 60250UR Recognized, 94V-2 Flame Class Rating1.6mmU.94Diying Temperature20mmU.94Drying Time2-4InsIEC 10250Maximum Moisture Content20.2**Maximum Moisture Content200-290**Nozzle Temperature207-290*C*Tont - Zone 3 Temperature207-290**Middle - Zone 2 Temperature207-290**Middle - Zone 2 Temperature207-290**Rear-Zone 1 Temperature200-280**Hopper Temperature60-80**	Relative Permittivity, 1 MHz	3	-	ASTM D150
Volume Resistivity1.E.15Ohm-cmEC 6093Dielectric Strength, 1.6 mm27W/mmEC 60243-1Relative Permittivity, 60 Hz3-EC 60250Relative Permittivity, 1 MHz3-EC 60250Dissipation Factor, 60 Hz0.001EC 60250Dissipation Factor, 1 MHz0.01UR Recognized, 94V-2 Flame Class Rating16mmU94Diying Temperature2-4msDying Time2-4msMaximum Moisture Content2002*-Meit Temperature200-30*-Toxzel Temperature200-290*-Tomt-Zone 3 Temperature200-290*-Middle - Zone 2 Temperature200-280*-Rear-Zone 1 Temperature200-280*-Bopper Temperature60-80*-	Dissipation Factor, 60 Hz	0.001	-	ASTM D150
Dielectric Strength, 1.6 mm27W//mmEC 60243-1Relative Permittivity, 60 Hz3-EC 60250Relative Permittivity, 1 MHz3-EC 60250Dissipation Factor, 60 Hz.0001-EC 60250Dissipation Factor, 1 MHz.001EC 60250FLAME CHARACTERISTICSUI. Recognized, 94V-2 Flame Class Rating16mmUI 94Diying Temperature120**C**LDrying Time2 − 4hrs**LMaximum Moisture Content.0.02**L**LMelt Temperature280 − 310**C**LNozzle Temperature270 − 290**C**LFront - Zone 3 Temperature270 − 290**C**LMiddle - Zone 2 Temperature270 − 290**C**LMiddle - Zone 2 Temperature270 − 290**C**LMiddle - Zone 2 Temperature270 − 290**C**LRear - Zone 1 Temperature260 − 280**C**L**LHopper Temperature50 − 80**C**L**L**L	Dissipation Factor, 1 MHz	0.01	-	ASTM D150
Relative Permittivity, 60 Hz 3 3 4 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	Volume Resistivity	>1.E+15	Ohm-cm	IEC 60093
Relative Permittivity, 1 MHz3-EC 60250Dissipation Factor, 60 Hz0.001EC 60250Dissipation Factor, 1 MHz0.01TAME CHARACTERISTICSUR Recognized, 94V-2 Flame Class Rating16.6mmUB 94Drying TemperatureDrying Temperature2-4hrsMaximum Moisture Content0.02%Melt Temperature280-310CPront - Zone 3 Temperature270-290°CMiddle - Zone 2 Temperature270-290°CRear- Zone 1 Temperature260-280°CBoper Temperature60-80°C	Dielectric Strength, 1.6 mm	27	kV/mm	IEC 60243-1
Dissipation Factor, 60 Hz 0.001 - IEC 60250 Dissipation Factor, 1 MHz 0.01 - IEC 60250 FLAME CHARACTERISTICS U. Recognized, 94V-2 Flame Class Rating 1.6 mm U. 94 INJECTION MOLDING Drying Temperature 2-4 hrs -	Relative Permittivity, 60 Hz	3	-	IEC 60250
Dissipation Factor, 1 MHz 0.01 0.01 c. 1 EC 60250 FLAME CHARACTERISTICS UL Recognized, 94V-2 Flame Class Rating 1.6 mm 0.01 0.94 INJECTION MOLDING Drying Temperature 1.00 0.02 °C Maximum Moisture Content 2.00.02 % Melt Temperature 2.00-310 °C Nozzle Temperature 2.07 - 290 °C Front - Zone 3 Temperature 2.07 - 290 °C Middle - Zone 2 Temperature 2.07 - 290 °C Rear - Zone 1 Temperature 2.00-280 °C Rear - Zone 1 Temperature 6.0-80 °C Hopper Temperature 6.0-80 °C Hopper Temperature 6.0-80 °C Hopper Temperature 6.0-80 °C	Relative Permittivity, 1 MHz	3	-	IEC 60250
FLAME CHARACTERISTICS UL Recognized, 94V-2 Flame Class Rating Indection MolDING Prying Temperature 120 2-4 Maximum Moisture Content 0.02 Mozel Temperature 280-310 Columbarian Front - Zone 3 Temperature 280-310 Columbarian 270-290 Columbarian 280-310 Columbarian 270-290 Columbarian 270-290 Columbarian Columbarian 270-290 Columbarian 270-290 Columbarian C	Dissipation Factor, 60 Hz	0.001	-	IEC 60250
UL Recognized, 94V-2 Flame Class Rating1.6mmUL 94INJECTION MOLDINGDrying Temperature120°C***Drying Time2-4hrs***Maximum Moisture Content0.02%****Melt Temperature280 – 310°C***Nozzle Temperature270 – 290°C***Middle - Zone 3 Temperature270 – 290°C***Middle - Zone 2 Temperature270 – 290°C***Rear - Zone 1 Temperature260 – 280°C***Hopper Temperature60 – 80°C***	Dissipation Factor, 1 MHz	0.01	-	IEC 60250
INJECTION MOLDING Drying Temperature 120 C-4 Maximum Moisture Content 0.02 Melt Temperature 280 - 310 C-2 Nozzle Temperature 270 - 290 C-2 Middle - Zone 3 Temperature 270 - 290 Middle - Zone 2 Temperature 270 - 290 C-2 Middle - Zone 1 Temperature 270 - 290 C-2 Middle - Zone 1 Temperature 270 - 290 C-2 Rear - Zone 1 Temperature 60 - 80 C-2 C-2 C-2 C-2 C-2 C-2 C-2 C-	FLAME CHARACTERISTICS			
Drying Temperature 120 °C Drying Time 2 – 4 hrs Maximum Moisture Content 0.02 % Melt Temperature 280 – 310 °C Nozzle Temperature 270 – 290 °C Front - Zone 3 Temperature 280 – 310 °C Middle - Zone 2 Temperature 270 – 290 °C Rear - Zone 1 Temperature 260 – 280 °C Hopper Temperature 60 – 80 °C	UL Recognized, 94V-2 Flame Class Rating	1.6	mm	UL 94
Drying Time 2-4 hrs Maximum Moisture Content 0.02 % Melt Temperature 280 – 310 °C Nozzle Temperature 270 – 290 °C Front - Zone 3 Temperature 280 – 310 °C Middle - Zone 2 Temperature 270 – 290 °C Rear - Zone 1 Temperature 260 – 280 °C Hopper Temperature 60 – 80 °C	INJECTION MOLDING			
Maximum Moisture Content 0.02 % Melt Temperature 280 – 310 °C Nozzle Temperature 270 – 290 °C Front - Zone 3 Temperature 280 – 310 °C Middle - Zone 2 Temperature 270 – 290 °C Rear - Zone 1 Temperature 260 – 280 °C Hopper Temperature 60 – 80 °C	Drying Temperature	120	°C	
Melt Temperature 280 – 310 °C Nozzle Temperature 270 – 290 °C Front - Zone 3 Temperature 280 – 310 °C Middle - Zone 2 Temperature 270 – 290 °C Rear - Zone 1 Temperature 260 – 280 °C Hopper Temperature 60 – 80 °C	Drying Time	2 – 4	hrs	
Nozzle Temperature 270 – 290 °C Front - Zone 3 Temperature 280 – 310 °C Middle - Zone 2 Temperature 270 – 290 °C Rear - Zone 1 Temperature 260 – 280 °C Hopper Temperature 60 – 80 °C	Maximum Moisture Content	0.02	%	
Front - Zone 3 Temperature 280 – 310 °C Middle - Zone 2 Temperature 270 – 290 °C Rear - Zone 1 Temperature 260 – 280 °C Hopper Temperature 60 – 80 °C	Melt Temperature	280 – 310	°C	
Middle - Zone 2 Temperature 270 – 290 °C Rear - Zone 1 Temperature 260 – 280 °C Hopper Temperature 60 – 80 °C	Nozzle Temperature	270 – 290	°C	
Rear - Zone 1 Temperature 260 - 280 °C Hopper Temperature 60 - 80 °C	Front - Zone 3 Temperature	280 – 310	°C	
Hopper Temperature 60 − 80 °C	Middle - Zone 2 Temperature	270 – 290	°C	
······································	Rear - Zone 1 Temperature	260 – 280	°C	
Mold Temperature 80 – 110 °C	Hopper Temperature	60 – 80	°C	
	Mold Temperature	80 – 110	°C	



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