

SCANTEC

PC S85R FA

Features:

Food approved

Property	Value	Unit	Test method
*** PHYSICAL PROPERTIES ***			
Density	1,20	g/cm ³	ISO 1183
Viscosity		Pas	
*** MECHANICAL PROPERTIES ***			
Flexural modulus at +23°C	2200	MPa	ISO 178
Maximum flexural strength	100	MPa	ISO 178
Maximum tensile strength	60	MPa	ISO 527-2
Elongation at break		%	ISO 527-2
Elongation at yield	6	%	ISO 527-2
*** IMPACT PROPERTIES ***			
Impact strength			
Notched Charpy at +23°C	25	kJ/m ²	ISO 179
Notched Charpy at -20°C	15	kJ/m ²	ISO 179
Unnotched Charpy at +23°C		kJ/m ²	ISO 179
Unnotched Charpy at -20°C		kJ/m ²	ISO 179
*** THERMAL PROPERTIES ***			
Heat Distortion Temperature			
HDT 120°C/h at 455kPa (B)	137	°C	ISO 75/1
HDT 120°C/h at 1820kPa (A)	127	°C	ISO 75/1
Softening temperature			
Vicat 50°C/h at 9,81N (A)	144	°C	ISO 306
Vicat 50°C/h at 49,05N (B)	139	°C	ISO 306
*** FLAMMABILITY PROPERTIES ***			
Flammability			
GWFI at 2 mm	850	°C	IEC 60695-2-12
UL94 at 1.6 mm	V2		UL94
*** ADDITIONAL INFORMATION ***			
Filler content		±2%	ISO 3451
Mould shrinkage (with flow)	0,5-0,7	%	Polykemi
Mould shrinkage (across flow)	0,5-0,7	%	Polykemi
*** PROCESS INSTRUCTIONS ***			
Drying time	2-8	h	
Drying temperature	120	°C	
Maximal moisture content	<0,02	%	
Melt temperature	270-300	°C	
Mould temperature	80-120	°C	

Version 3

2020-05-28

Stated values in this datasheet are approximate. The values originate, if nothing else is stated, from standardised test specimens in natural colour. All information, recommendations and advice given by Polykemi AB or any of its subsidiaries and affiliates, written or verbal, are according to Polykemi AB's knowledge to the date of this edition, correct and given in good faith. It is the responsibility of the customer to test and evaluate if the material suits the application and the environment in which it is intended to be used. Polykemi AB, its subsidiaries and affiliates can not be held responsible or liable for any loss incurred through incorrect or faulty use of the products. When producing details in flame retardant material, corrosion protected steel is to recommend for the mould. Polykemi AB takes no responsibility for any printing errors.

Property	Value	Unit	Test method
Peripheral screw speed	300-450	mm/s	
Back pressure	60-100	bar	

During production stops, emptying the cylinder is recommended. Leave the screw in its front most position. For polycarbonate it is also recommended to leave the cylinder temperature at 160-180°C and that the heating on the feeding zone is on. When producing details in flame retardant material, corrosion protected steel is to recommend for the mould. For further information, see the material safety datasheet (MSDS).

Version 3

2020-05-28

Stated values in this datasheet are approximate. The values originate, if nothing else is stated, from standardised test specimens in natural colour. All information, recommendations and advice given by Polykemi AB or any of its subsidiaries and affiliates, written or verbal, are according to Polykemi AB's knowledge to the date of this edition, correct and given in good faith. It is the responsibility of the customer to test and evaluate if the material suits the application and the environment in which it is intended to be used. Polykemi AB, its subsidiaries and affiliates can not be held responsible or liable for any loss incurred through incorrect or faulty use of the products. When producing details in flame retardant material, corrosion protected steel is to recommend for the mould. Polykemi AB takes no responsibility for any printing errors.

Polykemi AB, Bronsgatan 8, Box 14, 271 21 Ystad, Sweden

Tel: +46 411-170 30, Fax: +46 411-167 30, E-mail: info@polykemi.se, www.polykemi.se