



Document	ISO Datasheet
Description	PC
Grade	DAFNELOY MXF/EA
Code	
Application	Injection moulding

Unfilled.Toughened. Very high impact. Opaque colours.Flame Retardant grade Chlorine and Bromine free.

Properties	Method	Unit	Value
Physical			
Melt Flow Rate (300°C - 1,20 Kg)	ISO 1133	g/10'	8
Density at 23°C	ISO 1183	g/cm ³	1,18
Mould Shrinkage (%)	INTERNAL	%	0,6-0,8
Thermal			
Vicat B50	ISO 306	°C	135
Ball Pressure Test	IEC 60695-10-2	°C	125
HDT, A (1.80 MPa)	ISO 75/Af	°C	116
HDT, B (0.45 MPa)	ISO 75/Af	°C	130
Mechanical at 23 °C			
Flexural Modulus (23°C - 2 mm/min)	ISO 178	MPa	2000
Flexural strength (23°C - 2 mm/min)	ISO 178	MPa	80
Tensile stress at yield (23°C-50 mm/min)	ISO 527-2	MPa	55
Tensile elong. at break (23°C-50 mm/min)	ISO 527-2	%	>100
Rockwell hardness (M scale)	ISO 2039-2		30
Izod notched impact strength (23°C) ISO	ISO 180/1A	KJ/m ²	70
Charpy notched impact strength (23°C)	ISO 179/1eA	KJ/m ²	70
Charpy unnotched impact strength (23°C)	ISO 179/1eU	KJ/m ²	NB
Flammability			
Glow Wire Flammability Index GWFI (1,0 mm)	IEC 60695-2-12	°C	960
Glow Wire Flammability Index GWFI (2,0 mm)	IEC 60695-2-12	°C	725
Flammability class (0,8 mm)	UL94		V0
Flammability class (1,7 mm)	UL94		V0
Flammability class (3,2 mm)	UL94		V0

Processing Conditions			
Melt Temperature Range	ISO 294	°C	280-300
Mold Temperature Range	ISO 294	°C	90-120
Injection Velocity	ISO 294		HIGH
Drying Temperature		°C	120-130
Drying Time		Hour	3
Regulations compliance			
RoHS compliance status:	COMPLIANT		
EN71:			
UL listed file n°:	QMFZ2.E220931		
Water contact approvals.			
Food contact status:			

§ Moulding shrinkage is not an intrinsic property of plastics. It also depends on moulding parameters. The values reported have been calculated in the direction parallel to the flow in a 4.0 x 10.0 x 170 mm sample.

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