

PRODUCT DESCRIPTION - DATA SHEET

PO853DT is a halogen-free flame retardant polycarbonate based resin range available in standard and customized colors. In addition to good flammability performance, making it easy processing at low temperature for a wide variety of applications in aircraft interiors.

Features

- Flame Retardant: Compliance with CCAR25.853 (a)&(d) which thicknesses range from 1.5mm to 4mm
- Texture: Low gloss brings texture aesthetics
- Color: Custom Colors
- Formability: Extruding for 3-D designed vacuum forming and injection molding

Application

- Seating and arm rests
- Window surrounds
- Door shrouds and structural supports
- Interior components application
- Galley equipment

Properties	Standard	Condition	Unit	Value
Mechanical Properties				
Tensile Strength	ISO 527	50 mm/min	MPa	75
Tensile Strength at Break	ISO 527	50 mm/min	%	95
Flexural Stress	ISO 178	2 mm/min	MPa	105
Flexural Modulus	ISO 178	2 mm/min	MPa	2600
Izod Impact (Notched)	ISO 180	5.5 J	kJ/m ²	NB
Flame Retardant Properties				
Vertical Burning	CCAR25.853(a) Appendix F Part 1	12 s	-	Pass
Vertical Burning	CCAR25.853(a) Appendix F Part 1	60 s	-	Pass
Heat Release (Max)	CCAR25.853(d) Appendix F Part 4	35 kW/m ²	kW/m ²	≤65
Heat Release (Total)	CCAR25.853(d) Appendix F Part 4	35 kW/m ²	kW*min/m ²	≤65
Smoke Density 4Dm	CCAR25.853(d) Appendix F Part 5	25 kW/m ²	/	≤200
Smoke Toxicity	HB7066	25 kW/m ²	/	Pass
Heat Properties				
Heat Deflection Temp.	ISO 75-1, -2	1.80 MPa	°C	94
Vicat Softing Temp	ISO 306	B /120	°C	113
Physical Properties				
Density	ISO 1183	23 °C	g/m ³	1.33
Gloss	ISO 2813	60°	-	20~30

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POLYLINE™ PO853DT
Flame Retardant Polycarbonate



Injection Molding	Unit	Condition
Drying Temperature	°C	95~100
Drying Time	h	3-6
Melt Temperature	°C	250~280
Nozzle Temperature	°C	245~275
Front-Zone 3 Temperature	°C	250~280
Middle-Zone 2 Temperature	°C	240~270
Rear-Zone 1 Temperature	°C	230~250
Mold Temperature	°C	50~80
Back Pressure	MPa	0.3~0.7
Screw Speed	rpm	40~70
Shot to Cylinder Size	%	40~60
Vent Depth	mm	0.025

1) Above values are measured at 23°C and RH 50%. These values are typical values only, not specifications.

2) In case of colored products, these figures might vary slightly.

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