

Technical Data

Product Description					
XANTAR™ CF 407	PC/ABS, Flame retardant (Phosphate), High Heat Resistant				
Generic PC+ABS	This data represents typical values that have been calculated from all products classified as: Generic PC +ABS				
	This information is provided for comparative purposes only.				
General	XANTAR™ CF 407	Generic PC+ABS			
Manufacturer / Supplier	 Mitsubishi Chemical Corporation 	Generic			
Generic Symbol	PC+ABS	 PC+ABS 			
Material Status	Commercial: Active	Commercial: Active			
UL Yellow Card ¹	• E340159-100746621				
Search for UL Yellow Card	 Mitsubishi Chemical Corporation XANTAR™ 				
Availability	• Europe	 Africa & Middle East Asia Pacific Europe Latin America North America 			
Additive	Flame Retardant				
Features	Flame RetardantHigh Heat Resistance				
RoHS Compliance	RoHS Compliant				
Also Available In		Asia PacificEuropeLatin AmericaNorth America			
Physical	XANTAR™ CF 407	Generic Unit Test Method			

Filysical	CF 407	PC+ABS	Onit	Test Method
Density / Specific Gravity				
		1.10 to 1.21	g/cm³	ASTM D792
	1.19	1.10 to 1.21	g/cm³	ISO 1183
		1.10 to 1.19	g/cm³	ASTM D1505
Apparent (Bulk) Density		0.60 to 0.65	g/cm³	ISO 60
Melt Mass-Flow Rate (MFR)				
260°C/5.0 kg		4.8 to 30	g/10 min	ASTM D1238
260°C/5.0 kg	24	12 to 29	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (260°C/5.0 kg)	23	8.0 to 49	cm ³ /10min	ISO 1133
Spiral Flow		39.6 to 68.6	cm	
Molding Shrinkage				
Flow		0.45 to 0.74	%	ASTM D955
Across Flow		0.54 to 0.62	%	ASTM D955
		0.48 to 0.65	%	ISO 294-4
Across Flow	0.40 to 0.60		%	Internal Method
Flow	0.40 to 0.60		%	Internal Method

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Water Absorption	Physical	XANTAR™ CF 407	Generic PC+ABS	Unit	Test Method
24 hr - 0.088 ip 0.022 % ASTM DS70 24 hr, 23°C - 0.088 ip 0.070 % ISO 62 Saturation, 23°C 0.60 0.090 ip 0.70 % ISO 62 Equilibrium, 23°C, 50% RH - 0.057 ip 0.25 % ISO 62 Mechanical XMTR** Generic Unit Test Method Tensile Modulus - 1650 ip 0.350 MPa ASTM D638 - 1650 ip 0.350 MPa ASTM D638 - 1620 ip 3190 MPa ISO 527-11 Tensile Modulus - - MPa ISO 527-25 12700 - MPa ISO 527-25 Tensile Strength - 35.0 to 67.1 MPa ISO 527-25 Yield - 39.2 to 65.5 MPa ASTM D638 - - 39.2 to 65.5 MPa ISO 527-25 Freak - - 15 to 21 % ISO 527-25 Tensile Elongation<	Water Absorption				
24 hr, 23°C-0.08 lo 0.70%ISO 62Saturation, 23°C0.600.090 lo 0.70%ISO 62Equilbrum, 23°C, 50% RH-0.657 lo 0.25%ISO 62MechanicalCr 407"CenericUnitTest MethodTensile Modulus-1650 to 3050MPaASTM D6381650 to 3050MPaASTM D6381650 to 3050MPaASTM D6381620 to 3190MPaISO 627-111620 to 3190MPaISO 527-1148.4 to 65.2MPaASTM D638Yield35.0 to 67.1MPaISO 527-2500Break-39.2 to 62.3MPaASTM D638Yield-39.2 to 62.3MPaASTM D638Break-39.5 to 65.2MPaASTM D638Break-39.5 to 65.2MPaASTM D638Break-15.to 21%ASTM D638Yield-15.to 21%ASTM D638Yield-15.to 21%ASTM D638Yield-15.to 21%ISO 527-250Break-25.to 7.4%ISO 527-250Tensile Etongation%ISO 527-250Yield15.to 21%ASTM D638Yield15.to 21%S50 527-250Break25 to 7.4	24 hr		0.096 to 0.22	%	ASTM D570
Saturation 0.10 to 0.81 % ASTM D670 Saturation, 23°C, 50% RH 0.057 to 0.25 % ISO 62 Mechanical XANTAR™ Genetic CF 407* Centic Test Method Tensile Modulus 1650 to 3050 MPa ASTM D638 1620 to 3100 MPa ISO 527-11 Tensile Strength 1620 to 3100 MPa ISO 527-11 Tensile Strength 35.0 to 67.1 MPa ISO 527-250 Yield 39.2 to 62.3 MPa ISO 527-250 Break 39.2 to 62.4 MPa ISO 527-250 Tensile Etongation 49.8 to 05.5 MPa ISO 527-250 Tensike Longation 49.8 to 10.0 % ISO 527-250 <td>24 hr, 23°C</td> <td></td> <td>0.088 to 0.70</td> <td>%</td> <td>ISO 62</td>	24 hr, 23°C		0.088 to 0.70	%	ISO 62
Saturation, 23°C 0.60 0.090 to 0.70 % ISO 62 Equilibrium, 23°C, 50% RH - 0.057 to 0.25 % ISO 62 Mechanical Xan Construction Seaturation Seaturation Seaturation Tensile Modulus - 1850 to 3050 MPa ASTM D638 - 1620 to 3190 MPa ISO 527.11 2700 - MPa ISO 527.11 1620 to 3190 MPa ISO 527.11 2700 - MPa ISO 527.21 Tensile Strength - 48.4 to 65.2 MPa ASTM D638 Yield - 39.2 to 62.3 MPa ISO 527.250 Break - 39.2 to 63.5 MPa ISO 527.2 'Field - 47.8 to 60.5 MPa ISO 527.2 Tensile Elongation - 47.8 to 60.5 MPa ISO 527.2 Yield - - 25 to 7.4 % ISO 527.2 Yield -	Saturation		0.10 to 0.61	%	ASTM D570
Equilibrium, 23°C, 50% RH - 0.057 to 0.25 % ISO 62 Mechanical CANTAR™ 4407 Genetic Service Presile Unit Test Method Tensile Modulus - 1650 to 3050 MPa AST M 638 - 1620 to 3190 MPa ISO 527-11 - 2700 - MPa ISO 527-11 Tensile Strength - 48.4 to 65.2 MPa ASTM D638 Yield - 36.0 to 67.1 MPa ISO 527-2150 Break - 39.2 to 68.3 MPa ASTM D638 Break - 39.2 to 68.5 MPa ASTM D638 Break - 47.8 to 6.5 MPa ASTM D638 Break - 47.8 to 6.5 MPa ASTM D638 Yield -	Saturation, 23°C	0.60	0.090 to 0.70	%	ISO 62
Mechanical XANTAR™ CF 407 Generic PC+ABS Unit Test Method Tensile Modulus - 1650 to 3050 MPa ASTM D638 - - 1620 to 3190 MPa ASTM D638 - - 1620 to 3190 MPa ASTM D638 - - 1620 to 3190 MPa ISO 527-11 - - 48.4 to 65.2 MPa ASTM D638 - - 36.0 to 67.1 MPa ISO 527-2/50 Break - 39.2 to 62.3 MPa ASTM D638 Break - 39.2 to 66.2 MPa ISO 527-2 - - 39.2 to 66.2 MPa ASTM D638 Break - 39.2 to 66.2 MPa ISO 527-2 - - 47.8 to 60.5 MPa ISO 527-2 Tensile Elongation - 47.8 to 60.5 MPa ISO 527-2 Tensile Elongation - - 47.8 to 60.5 MPa ISO 527-2 Yield	Equilibrium, 23°C, 50% RH		0.057 to 0.25	%	ISO 62
Tensile Modulus 1850 to 3050 MPa ASTM D638 1620 to 3190 MPa ISO 527-1 2700 MPa ISO 527-1/1 Tensile Strength MPa ISO 527-1/1 Tensile Strength MPa ISO 527-2 Yield 38.0 to 67.1 MPa ISO 527-2 Yield 60.0 MPa ISO 527-2 Yield 60.0 MPa ISO 527-2 Break 39.2 to 65.5 MPa ASTM D638 Break 39.5 to 66.2 MPa ASTM D638 39.5 to 66.2 MPa ASTM D638 39.5 to 66.2 MPa ISO 527-2 39.5 to 66.2 MPa ISO 527-2 Tensile Elongation 47.8 to 60.5 MPa ISO 527-2 Yield 15 to 21 % ASTM D638	Mechanical	XANTAR™ CF 407	Generic PC+ABS	Unit	Test Method
- - 1850 to 3500 MPa ASTM D638 - . 1620 to 3190 MPa ISO 527.1 Tensile Strength . . . MPa ISO 527.1 Tensile Strength <	Tensile Modulus				
1620 to 3190 MPa ISO 527-1 MPa ISO 527-1/1 ISO 527-1/1 Tensile Strength - 46.4 to 65.2 MPa ASTM D638 Yield - 35.0 to 67.1 MPa ISO 527-2 Yield 60.0 - MPa ISO 527-2 Break - 39.2 to 62.3 MPa ASTM D638 Break - 39.5 to 66.2 MPa ASTM D638 - - 39.5 to 66.2 MPa ASTM D638 Break - 39.5 to 66.2 MPa ASTM D638 - - 47.8 to 60.5 MPa ISO 527-2 Tensile Elongation - 47.8 to 60.5 MPa ISO 527-2 Yield - 2.5 to 7.4 % ISO 527-2 Break - 2.9 to 110 % ASTM D638 Break - 4.9 to 100 % ISO 527-2 Break - 2.9 to 110 % ASTM D638			1850 to 3050	MPa	ASTM D638
- 2700 - MPa ISO 527-1/1 Tensile Strength - 48.4 to 65.2 MPa ASTM D638 Yield - 35.0 to 67.1 MPa ISO 527-2 Yield 60.0 - MPa ISO 527-2 Yield 60.0 - MPa ISO 527-2 Break - 39.2 to 58.5 MPa ASTM D638 Break - 39.2 to 58.5 MPa ASTM D638 Break - - 39.2 to 58.5 MPa ASTM D638 - - - 47.8 to 60.5 MPa ISO 527-2 Fisile Elongation - - 47.8 to 60.5 MPa ISO 527-2 Yield - - 1.5 to 21 % ASTM D638 Yield - - 1.5 to 21 % ISO 527-2 Yield - - 2.5 to 7.4 % ISO 527-2 Break - - 2.5 to 7.4 % ISO 527-2			1620 to 3190	MPa	ISO 527-1
Tensile Strength Yield - 48.4 to 65.2 MPa ASTM D638 Yield - 35.0 to 67.1 MPa ISO 527.2 (50) Break - 39.2 to 62.3 MPa ASTM D638 Break - 39.2 to 62.3 MPa ASTM D638 Break - 39.2 to 66.2 MPa ASTM D638 - - 47.8 to 60.5 MPa ISO 527.2 - - 39.2 to 66.2 MPa ASTM D638 - - 47.8 to 60.5 MPa ISO 527.2 - - - 47.8 to 60.5 MPa ISO 527.2 Tensile Elongation - - 1.5 to 21 % ASTM D638 Yield - - 2.5 to 7.4 % ISO 527.2 Break - 2.9 to 110 % ASTM D638 Break - 2.8 to 100 % ISO 527.2 Break - - 4.9 to 100 % ISO 527.2 <tr< td=""><td></td><td>2700</td><td></td><td>MPa</td><td>ISO 527-1/1</td></tr<>		2700		MPa	ISO 527-1/1
Yield 48.4 to 65.2 MPa ASTM D638 Yield 35.0 to 67.1 MPa ISO 527-2 Yield 60.0 MPa ISO 527-250 Break 39.2 to 68.5 MPa ASTM D638 Break 39.2 to 68.5 MPa ISO 527-2 - 39.2 to 68.5 MPa ASTM D638 Break 39.5 to 66.2 MPa ASTM D638 1.5 to 21 % ASTM D638 Yield 1.5 to 21 % ASTM D638 Yield - % ISO 527-2/50 Break 28 to 100 % ISO 527-2/50 Break 49 to 100 % ISO 527-2/50 Inseak - 20 to 100 % ISO 527-2/50	Tensile Strength				
Yield 35.0 to 67.1 MPa ISO 527-2 Yield 60.0 - MPa ISO 527-2/50 Break - 39.2 to 68.5 MPa ISO 527-2/50 Break - 39.2 to 68.5 MPa ISO 527-2 - - 39.5 to 66.2 MPa ASTM D638 - - 47.8 to 60.5 MPa ISO 527-2 - - 47.8 to 60.5 MPa ISO 527-2 - - 47.8 to 60.5 MPa ISO 527-2 Tensile Elongation - - 47.8 to 60.5 MPa ISO 527-2 Yield - 1.5 to 21 % ASTM D638 Break - 2.9 to 110 % ASTM D638 Break - 2.9 to 110 % ISO 527-2 Break - 2.9 to 100 % ISO 527-2 Break - 4.9 to 100 % ISO 527-2 Break - 4.9 to 100 %	Yield		48.4 to 65.2	MPa	ASTM D638
Yield 60.0 MPa ISO 527-2/50 Break 39.2 to 62.3 MPa ASTM D638 Break 39.2 to 58.5 MPa ISO 527-2 - 39.2 to 58.5 MPa ASTM D638 Break 39.2 to 58.5 MPa ISO 527-2 - 47.8 to 60.5 MPa ASTM D638 - - 47.8 to 60.5 MPa ASTM D638 - - 47.8 to 60.5 MPa ASTM D638 - - 47.8 to 60.5 MPa ISO 527-2 Tensile Elongation % ISO 527-25 MSG Break -0 29 to 110 % ASTM D638 Break 28 to 100 % ISO 527-22 Break 49 to 100 % ISO 527-22 Break 49 to 100 % ISO 527-22 Break 49 to 100 % ISO 527-22	Yield		35.0 to 67.1	MPa	ISO 527-2
Break 39.2 to 62.3 MPa ASTM D638 Break 39.2 to 58.5 MPa ISO 527-2 39.5 to 66.2 MPa ASTM D638 49.5 to 60.5 MPa ISO 527-2 Tensile Elongation 49.5 to 60.5 MPa ISO 527-2 Yield 1.5 to 21 % ASTM D638 Yield 2.5 to 7.4 % ISO 527-2 Yield 2.5 to 7.4 % ISO 527-2 Yield 4.0 % ISO 527-2 Break 29 to 110 % ASTM D638 Break 28 to 100 % ISO 527-2 Break 49 to 100 % ISO 507-2	Yield	60.0		MPa	ISO 527-2/50
Break 39.2 to 58.5 MPa ISO 527-2 39.5 to 66.2 MPa ASTM D638 47.8 to 60.5 MPa ISO 527-2 Tensile Elongation 47.8 to 60.5 MPa ISO 527-2 Yield 1.5 to 21 % ASTM D638 Yield 2.5 to 7.4 % ISO 527-2 Yield 4.0 % ISO 527-2 Yield 4.0 % ISO 527-2 Break 29 to 110 % ASTM D638 Break 29 to 100 % ISO 527-2 Break 29 to 100 % ISO 527-2 Break 49 to 100 % ISO 527-2 Invanial Tensile Strain at Break 49 to 100 % ISO 527-2 Flexural Modulus - 49 to 100 MPa ASTM D790 1810 to 2700	Break		39.2 to 62.3	MPa	ASTM D638
39.5 to 66.2 MPa ASTM D638 47.8 to 60.5 MPa ISO 527-2 Tensile Elongation 1.5 to 21 % ASTM D638 Yield 1.5 to 21 % ASTM D638 Yield 2.5 to 7.4 % ISO 527-2 Yield 2.5 to 7.4 % ISO 527-2 Break 2.9 to 110 % ASTM D638 Break 2.9 to 110 % ASTM D638 Break 2.9 to 100 % ISO 527-2 Break 2.9 to 100 % ISO 527-2 Break 4.9 to 100 % ISO 527-2 Break 4.9 to 100 % ISO 527-2 Instant Break 4.9 to 100 % ISO 527-2 Instant Break - 4.9 to 100 % ISO 527-2 Flexural Modulus - - <td< td=""><td>Break</td><td></td><td>39.2 to 58.5</td><td>MPa</td><td>ISO 527-2</td></td<>	Break		39.2 to 58.5	MPa	ISO 527-2
47.8 to 60.5 MPa ISO 527-2 Tensile Elongation 1.5 to 21 % ASTM D638 Yield 2.5 to 7.4 % ISO 527-2 Yield 2.5 to 7.4 % ISO 527-2 Yield 4.0 % ISO 527-2 Yield 4.0 % ISO 527-2 Break 29 to 110 % ASTM D638 Break 29 to 100 % ISO 527-2 Break 29 to 100 % ISO 527-2 Break 49 to 100 % ISO 527-2 Nominal Tensile Strain at Break 49 to 100 % ISO 527-2 Flexural Modulus 49 to 100 % ISO 527-2 - 2010 to 2770 MPa ASTM D790 - 49 to 100 % ISO 178 3 2700 MPa ISO 178 -			39.5 to 66.2	MPa	ASTM D638
Tensile Elongation Yield 1.5 to 21 % ASTM D638 Yield 2.5 to 7.4 % ISO 527-2 Yield 4.0 % ISO 527-2/50 Break 29 to 110 % ASTM D638 Break 29 to 110 % ASTM D638 Break 28 to 100 % ISO 527-2 Break 28 to 100 % ISO 527-2 Break 49 to 100 % ISO 527-2 Break 49 to 100 % ISO 527-2 Nominal Tensile Strain at Break 49 to 100 % ISO 527-2 Flexural Modulus - 40 to 2770 MPa ASTM D790 1810 to 2700 MPa ISO 178 3 2700 MPa ISO 178 3 95.0 MPa ISO 178 3 95.0 MPa ISO 178 Yield 68.4 to 105 </td <td></td> <td></td> <td>47.8 to 60.5</td> <td>MPa</td> <td>ISO 527-2</td>			47.8 to 60.5	MPa	ISO 527-2
Yield1.5 to 21%ASTM D638Yield2.5 to 7.4%ISO 527-2Yield4.0%ISO 527-2/50Break29 to 110%ASTM D638Break29 to 110%ASTM D638Break28 to 100%ISO 527-2Break49 to 100%ISO 527-2Break>50%ISO 527-2Break49 to 100%ISO 527-2Nominal Tensile Strain at Break49 to 100%ISO 527-2Flexural Modulus49 to 100%ISO 527-249 to 100%ISO 527-2Flexural Strength49 to 100%2010 to 2770MPaASTM D7901810 to 2700MPaISO 17868.4 to 105MPaASTM D79069.0 to 102MPaISO 17868.4 to 105MPaASTM D79068.4 to 105MPaASTM D790Break68.4 to 105MPaASTM D79068.4 to 105MPaASTM D790Taber Abrasion Resistance54.0 to 82.0mgASTM D790Taber Abrasion Resistance54.0 to 82.0mgASTM D1044ImpactXANTAR*MGeneric C PC+ABSUnitTest Method	Tensile Elongation				
Yield 2.5 to 7.4 % ISO 527-2 Yield 4.0 % ISO 527-2/50 Break 29 to 110 % ASTM D638 Break 28 to 100 % ISO 527-2 Break 28 to 100 % ISO 527-2 Break 28 to 100 % ISO 527-2 Break 49 to 100 % ISO 527-2 Break 49 to 100 % ISO 527-2 Nominal Tensile Strain at Break 49 to 100 % ISO 527-2 Flexural Modulus 49 to 100 % ISO 527-2 2010 to 2770 MPa ASTM D790 1810 to 2700 MPa ISO 178 3 2700 MPa ISO 178 3 95.0 MPa ISO 178 3 95.0 MPa ASTM D790	Yield		1.5 to 21	%	ASTM D638
Yield 4.0 % ISO 527-2/50 Break 29 to 110 % ASTM D638 Break 28 to 100 % ISO 527-2 Break >50 % ISO 527-2/50 Nominal Tensile Strain at Break 49 to 100 % ISO 527-2/50 Nominal Tensile Strain at Break 49 to 100 % ISO 527-2/50 Flexural Modulus 49 to 100 % ISO 527-2 Flexural Modulus 49 to 100 % ISO 527-2 Flexural Strength 2010 to 2770 MPa ASTM D790 1810 to 2700 MPa ISO 178 3 2700 MPa ISO 178 3 2700 MPa ISO 178 3 95.0 MPa ISO 178 3 95.0 MPa ISO 178 Yield 68.4 to 105 MPa ASTM D790 Break 68.4 to 105 MPa <td>Yield</td> <td></td> <td>2.5 to 7.4</td> <td>%</td> <td>ISO 527-2</td>	Yield		2.5 to 7.4	%	ISO 527-2
Break 29 to 110 % ASTM D638 Break 28 to 100 % ISO 527-2 Break >50 % ISO 527-2 Break >50 % ISO 527-2 Break 49 to 100 % ISO 527-2 Nominal Tensile Strain at Break 49 to 100 % ISO 527-2 Flexural Modulus 49 to 100 % ISO 527-2 49 to 100 % ISO 527-2 Flexural Modulus 49 to 100 % ISO 527-2 2010 to 2770 MPa ASTM D790 1810 to 2700 MPa ISO 178 3 2700 MPa ISO 178 68.4 to 105 MPa ASTM D790 68.4 to 105 MPa ASTM D790 3 95.0 MPa ASTM D790 </td <td>Yield</td> <td>4.0</td> <td></td> <td>%</td> <td>ISO 527-2/50</td>	Yield	4.0		%	ISO 527-2/50
Break 28 to 100 % ISO 527-2 Break > 50 % ISO 527-2/50 Nominal Tensile Strain at Break 49 to 100 % ISO 527-2 Flexural Modulus 49 to 100 % ISO 527-2 Flexural Modulus 49 to 100 % ISO 527-2 49 to 100 % ISO 527-2 Flexural Modulus 49 to 100 % ISO 527-2 49 to 100 % ISO 527-2 Flexural Modulus 2010 to 2770 MPa ASTM D790 1810 to 2700 MPa ISO 178 3 2700 MPa ISO 178 3 95.0 MPa ISO 178 3 95.0 MPa ISO 178 Yield 68.4 to 105 MPa ASTM D790 Break 63.7 to 83.7 MPa <td>Break</td> <td></td> <td>29 to 110</td> <td>%</td> <td>ASTM D638</td>	Break		29 to 110	%	ASTM D638
Break> 50%ISO 527-2/50Nominal Tensile Strain at Break49 to 100%ISO 527-2Flexural Modulus2010 to 2770MPaASTM D7901810 to 2700MPaISO 17832700MPaISO 178Flexural Strength68.4 to 105MPaASTM D79069.0 to 102MPaISO 178395.0MPaISO 178Yield68.4 to 105MPaASTM D790Break68.4 to 105MPaASTM D790Taber Abrasion Resistance54.0 to 82.0mgASTM D790ImpactXANTAR™Generic PC+ABSUnitTest MethodCharpy Notched Impact Strength6.5 to 63kJ/m²ISO 179	Break		28 to 100	%	ISO 527-2
Nominal Tensile Strain at Break49 to 100%ISO 527-2Flexural Modulus2010 to 2770MPaASTM D7901810 to 2700MPaISO 17832700MPaISO 178Flexural Strength68.4 to 105MPaASTM D79069.0 to 102MPaISO 178395.0MPaISO 178Yield68.4 to 105MPaASTM D790Break63.7 to 83.7MPaASTM D790Taber Abrasion Resistance54.0 to 82.0mgASTM D1044ImpactXANTAR™ CF 407Generic PC+ABSUnitTest MethodCharpy Notched Impact Strength6.5 to 63kJ/m²ISO 179	Break	> 50		%	ISO 527-2/50
Flexural Modulus 2010 to 2770 MPa ASTM D790 1810 to 2700 MPa ISO 178 3 2700 MPa ISO 178 Flexural Strength 68.4 to 105 MPa ASTM D790 69.0 to 102 MPa ISO 178 3 95.0 MPa ISO 178 3 95.0 MPa ISO 178 Yield 68.4 to 105 MPa ASTM D790 Break 63.7 to 83.7 MPa ASTM D790 Taber Abrasion Resistance 54.0 to 82.0 mg ASTM D790 Impact XANTAR™ CF 407 Generic PC+ABS Unit Test Method Charpy Notched Impact Strength 6.5 to 63 kJ/m² ISO 179	Nominal Tensile Strain at Break		49 to 100	%	ISO 527-2
2010 to 2770 MPa ASTM D790 1810 to 2700 MPa ISO 178 3 2700 MPa ISO 178 Flexural Strength 68.4 to 105 MPa ASTM D790 69.0 to 102 MPa ISO 178 3 95.0 MPa ISO 178 3 95.0 MPa ISO 178 Yield 68.4 to 105 MPa ASTM D790 Break 68.4 to 105 MPa ASTM D790 Taber Abrasion Resistance 54.0 to 82.0 mg ASTM D1044 Impact XANTAR™ CF 407 Generic PC+ABS Unit Test Method	Flexural Modulus				
1810 to 2700MPaISO 17832700MPaISO 178Flexural Strength68.4 to 105MPaASTM D79069.0 to 102MPaISO 178395.0MPaISO 178Yield68.4 to 105MPaASTM D790Break68.4 to 105MPaASTM D790Taber Abrasion Resistance54.0 to 82.0mgASTM D1044ImpactXANTAR™ CF 407Generic PC+ABSUnitTest MethodCharpy Notched Impact Strength6.5 to 63kJ/m²ISO 179			2010 to 2770	MPa	ASTM D790
32700MPaISO 178Flexural Strength68.4 to 105MPaASTM D79069.0 to 102MPaISO 178395.0MPaISO 178Yield68.4 to 105MPaASTM D790Break63.7 to 83.7MPaASTM D790Taber Abrasion Resistance54.0 to 82.0mgASTM D1044ImpactXANTAR™ CF 407Generic PC+ABSUnitTest MethodCharpy Notched Impact Strength6.5 to 63kJ/m²ISO 179			1810 to 2700	MPa	ISO 178
Flexural Strength68.4 to 105MPaASTM D79069.0 to 102MPaISO 178395.0MPaISO 178Yield68.4 to 105MPaASTM D790Break63.7 to 83.7MPaASTM D790Taber Abrasion Resistance54.0 to 82.0mgASTM D1044ImpactXANTAR™ CF 407Generic PC+ABSUnitTest MethodCharpy Notched Impact Strength6.5 to 63kJ/m²ISO 179	3	2700		MPa	ISO 178
68.4 to 105MPaASTM D79069.0 to 102MPaISO 178395.0MPaISO 178Yield68.4 to 105MPaASTM D790Break68.4 to 105MPaASTM D790Taber Abrasion Resistance54.0 to 82.0mgASTM D1044ImpactXANTAR™ CF 407Generic PC+ABSUnitTest MethodCharpy Notched Impact Strength6.5 to 63kJ/m²ISO 179	Flexural Strength				
69.0 to 102MPaISO 178395.0MPaISO 178Yield68.4 to 105MPaASTM D790Break63.7 to 83.7MPaASTM D790Taber Abrasion Resistance54.0 to 82.0mgASTM D1044ImpactXANTAR™ CF 407Generic PC+ABSUnitTest MethodCharpy Notched Impact Strength6.5 to 63kJ/m²ISO 179			68.4 to 105	MPa	ASTM D790
395.0MPaISO 178Yield68.4 to 105MPaASTM D790Break63.7 to 83.7MPaASTM D790Taber Abrasion Resistance54.0 to 82.0mgASTM D1044ImpactXANTAR™ CF 407Generic PC+ABSUnitTest MethodCharpy Notched Impact Strength6.5 to 63kJ/m²ISO 179			69.0 to 102	MPa	ISO 178
Yield68.4 to 105MPaASTM D790Break63.7 to 83.7MPaASTM D790Taber Abrasion Resistance54.0 to 82.0mgASTM D1044ImpactXANTAR™ CF 407Generic PC+ABSUnitTest MethodCharpy Notched Impact Strength6.5 to 63kJ/m²ISO 179	3	95.0		MPa	ISO 178
Break 63.7 to 83.7 MPa ASTM D790 Taber Abrasion Resistance 54.0 to 82.0 mg ASTM D1044 Impact XANTAR™ CF 407 Generic PC+ABS Unit Test Method Charpy Notched Impact Strength 6.5 to 63 kJ/m² ISO 179	Yield		68.4 to 105	MPa	ASTM D790
Taber Abrasion Resistance54.0 to 82.0mgASTM D1044ImpactXANTAR™ CF 407Generic PC+ABSUnitTest MethodCharpy Notched Impact Strength6.5 to 63kJ/m²ISO 179	Break		63.7 to 83.7	MPa	ASTM D790
Impact XANTAR™ CF 407 Generic PC+ABS Unit Test Method Charpy Notched Impact Strength 6.5 to 63 kJ/m² ISO 179	Taber Abrasion Resistance		54.0 to 82.0	ma	ASTM D1044
Charpy Notched Impact Strength 6.5 to 63 kJ/m ² ISO 179	Impact	XANTAR™ CF 407	Generic PC+ABS	Unit	Test Method
	Charpy Notched Impact Strength		6.5 to 63	kJ/m²	ISO 179

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Impact	XANTAR™ CF 407	Generic PC+ABS	Unit	Test Method
Charpy Unnotched Impact Strength				ISO 179
		22 to 100	kJ/m²	
-30°C	No Break			
23°C	No Break			
Notched Izod Impact				
		48 to 710	J/m	ASTM D256
		9.0 to 57	kJ/m²	ISO 180
23°C	50		kJ/m²	ISO 180/4A
Notched Izod Impact (Area)		39.2 to 65.1	kJ/m²	ASTM D256
Unnotched Izod Impact				
		380 to 2200	J/m	ASTM D4812
		94 to 100	kJ/m²	ISO 180
Instrumented Dart Impact				
		42.8 to 65.3	J	ASTM D3763
		35.0 to 105	J	ISO 6603-2
Multi-Axial Instrumented Impact Peak Force		4260 to 5400	Ν	ISO 6603-2
Gardner Impact		35.6 to 36.3	J	ASTM D3029
Hardness	XANTAR™ CF 407	Generic PC+ABS	Unit	Test Method
Rockwell Hardness				
		100 to 120		ASTM D785
		106 to 124		ISO 2039-2
Shore Hardness		79 to 80		ISO 868
Ball Indentation Hardness		89.3 to 133	MPa	ISO 2039-1
Thermal	XANTAR™	Generic PC+ABS	Unit	Test Method
	CF 407	1.0.1120		
Deflection Temperature Under Load	CF 407	100020		
Deflection Temperature Under Load 0.45 MPa, Unannealed		86.9 to 131	°C	ASTM D648
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed	 	86.9 to 131 87.6 to 131	℃ ℃	ASTM D648 ISO 75-2/B
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed 0.45 MPa, Annealed	 	86.9 to 131 87.6 to 131 92.0 to 129	ວ° ວ° ວ°	ASTM D648 ISO 75-2/B ISO 75-2/B
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed 0.45 MPa, Annealed 1.8 MPa, Unannealed	 	86.9 to 131 87.6 to 131 92.0 to 129 79.9 to 116	ວ° ວ° ວ°	ASTM D648 ISO 75-2/B ISO 75-2/B ASTM D648
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed 0.45 MPa, Annealed 1.8 MPa, Unannealed 1.8 MPa, Unannealed	 100	86.9 to 131 87.6 to 131 92.0 to 129 79.9 to 116 78.9 to 113	ວ° ວ° ວ° ວ°	ASTM D648 ISO 75-2/B ISO 75-2/B ASTM D648 ISO 75-2/A
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed 0.45 MPa, Annealed 1.8 MPa, Unannealed 1.8 MPa, Unannealed 1.8 MPa, Annealed	 100 	86.9 to 131 87.6 to 131 92.0 to 129 79.9 to 116 78.9 to 113 94.6 to 110	ວ° ວີ ວີ	ASTM D648 ISO 75-2/B ISO 75-2/B ASTM D648 ISO 75-2/A ISO 75-2/A
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed 0.45 MPa, Annealed 1.8 MPa, Unannealed 1.8 MPa, Unannealed 1.8 MPa, Annealed Continuous Use Temperature	 100 	86.9 to 131 87.6 to 131 92.0 to 129 79.9 to 116 78.9 to 113 94.6 to 110 60.0 to 100	ວ° ວ° ວິ ວິ ວິ	ASTM D648 ISO 75-2/B ISO 75-2/B ASTM D648 ISO 75-2/A ISO 75-2/A ASTM D794
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed 0.45 MPa, Annealed 1.8 MPa, Unannealed 1.8 MPa, Unannealed 1.8 MPa, Annealed Continuous Use Temperature Vicat Softening Temperature	 100 	86.9 to 131 87.6 to 131 92.0 to 129 79.9 to 116 78.9 to 113 94.6 to 110 60.0 to 100	ວ° ວີ ວີ ວີ ວີ	ASTM D648 ISO 75-2/B ISO 75-2/B ASTM D648 ISO 75-2/A ISO 75-2/A ASTM D794
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed 0.45 MPa, Annealed 1.8 MPa, Unannealed 1.8 MPa, Unannealed 1.8 MPa, Annealed Continuous Use Temperature Vicat Softening Temperature	 100 	86.9 to 131 87.6 to 131 92.0 to 129 79.9 to 116 78.9 to 113 94.6 to 110 60.0 to 100 89.9 to 139	ວ° ວ° ວ° ວ° ວ° ວ°	ASTM D648 ISO 75-2/B ISO 75-2/B ASTM D648 ISO 75-2/A ISO 75-2/A ASTM D794
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed 0.45 MPa, Annealed 1.8 MPa, Unannealed 1.8 MPa, Unannealed 1.8 MPa, Annealed Continuous Use Temperature Vicat Softening Temperature	 100 120	86.9 to 131 87.6 to 131 92.0 to 129 79.9 to 116 78.9 to 113 94.6 to 110 60.0 to 100 89.9 to 139 92.5 to 141	ວ° ວ° ວີ ວິ ວິ ວິ ວິ	ASTM D648 ISO 75-2/B ISO 75-2/B ASTM D648 ISO 75-2/A ISO 75-2/A ASTM D794 ASTM D1525 ISO 306
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed 0.45 MPa, Annealed 1.8 MPa, Unannealed 1.8 MPa, Unannealed 1.8 MPa, Annealed Continuous Use Temperature Vicat Softening Temperature CLTE	 100 120	86.9 to 131 87.6 to 131 92.0 to 129 79.9 to 116 78.9 to 113 94.6 to 110 60.0 to 100 89.9 to 139 92.5 to 141	ວີ ເວົ່ ເວົ້ ເວົ້ ເວົ້ ເວົ້ ເວົ້ ເວົ້ ເວົ້ ເວົ້	ASTM D648 ISO 75-2/B ISO 75-2/B ASTM D648 ISO 75-2/A ISO 75-2/A ASTM D794 ASTM D1525 ISO 306
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed 0.45 MPa, Annealed 1.8 MPa, Unannealed 1.8 MPa, Unannealed 1.8 MPa, Annealed Continuous Use Temperature Vicat Softening Temperature CLTE Flow	 100 120	86.9 to 131 87.6 to 131 92.0 to 129 79.9 to 116 78.9 to 113 94.6 to 110 60.0 to 100 89.9 to 139 92.5 to 141 7.1E-5 to 8.3E-5	°C °C °C °C °C °C °C °C °C °C °C	ASTM D648 ISO 75-2/B ISO 75-2/B ASTM D648 ISO 75-2/A ISO 75-2/A ASTM D794 ASTM D1525 ISO 306 ASTM D696
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed 0.45 MPa, Annealed 1.8 MPa, Unannealed 1.8 MPa, Unannealed 1.8 MPa, Annealed Continuous Use Temperature Vicat Softening Temperature CLTE Flow Flow	 100 120	86.9 to 131 87.6 to 131 92.0 to 129 79.9 to 116 78.9 to 113 94.6 to 110 60.0 to 100 89.9 to 139 92.5 to 141 7.1E-5 to 8.3E-5 5.3E-5 to 7.6E-5	°C °C °C °C °C °C °C °C °C °C °C	ASTM D648 ISO 75-2/B ISO 75-2/B ASTM D648 ISO 75-2/A ISO 75-2/A ASTM D794 ASTM D1525 ISO 306 ASTM D696 ASTM E831
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed 0.45 MPa, Annealed 1.8 MPa, Unannealed 1.8 MPa, Unannealed 1.8 MPa, Annealed Continuous Use Temperature Vicat Softening Temperature CLTE Flow Flow Flow	 100 120 	86.9 to 131 87.6 to 131 92.0 to 129 79.9 to 116 78.9 to 113 94.6 to 110 60.0 to 100 89.9 to 139 92.5 to 141 7.1E-5 to 8.3E-5 5.3E-5 to 7.6E-5 5.5E-5 to 1.0E-4	°C °C °C °C °C °C °C °C °C °C °C	ASTM D648 ISO 75-2/B ISO 75-2/B ASTM D648 ISO 75-2/A ISO 75-2/A ASTM D794 ASTM D1525 ISO 306 ASTM D696 ASTM E831 ISO 11359-2
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed 0.45 MPa, Annealed 1.8 MPa, Unannealed 1.8 MPa, Unannealed 1.8 MPa, Annealed Continuous Use Temperature Vicat Softening Temperature CLTE Flow Flow Flow Flow	 100 120 	86.9 to 131 87.6 to 131 92.0 to 129 79.9 to 116 78.9 to 113 94.6 to 110 60.0 to 100 89.9 to 139 92.5 to 141 7.1E-5 to 8.3E-5 5.3E-5 to 7.6E-5 5.5E-5 to 1.0E-4 6.9E-5 to 9.1E-5	°C °C °C °C °C °C °C °C °C °C °C	ASTM D648 ISO 75-2/B ISO 75-2/B ASTM D648 ISO 75-2/A ISO 75-2/A ASTM D794 ASTM D1525 ISO 306 ASTM D696 ASTM E831 ISO 11359-2 ASTM E831
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed 0.45 MPa, Annealed 1.8 MPa, Unannealed 1.8 MPa, Unannealed 1.8 MPa, Annealed Continuous Use Temperature Vicat Softening Temperature CLTE Flow Flow Flow Flow Transverse Transverse	 100 120 	86.9 to 131 87.6 to 131 92.0 to 129 79.9 to 116 78.9 to 113 94.6 to 110 60.0 to 100 89.9 to 139 92.5 to 141 7.1E-5 to 8.3E-5 5.3E-5 to 7.6E-5 5.5E-5 to 1.0E-4 6.9E-5 to 9.1E-5 5.6E-5 to 8.6E-5	°C °C °C °C °C °C °C °C °C °C °C °C °C °	ASTM D648 ISO 75-2/B ISO 75-2/B ASTM D648 ISO 75-2/A ISO 75-2/A ASTM D794 ASTM D1525 ISO 306 ASTM D696 ASTM E831 ISO 11359-2 ASTM E831 ISO 11359-2
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed 0.45 MPa, Annealed 1.8 MPa, Unannealed 1.8 MPa, Unannealed 1.8 MPa, Annealed Continuous Use Temperature Vicat Softening Temperature CLTE Flow Flow Flow Flow Transverse Transverse Thermal Conductivity	 100 120 	86.9 to 131 87.6 to 131 92.0 to 129 79.9 to 116 78.9 to 113 94.6 to 110 60.0 to 100 89.9 to 139 92.5 to 141 7.1E-5 to 8.3E-5 5.3E-5 to 7.6E-5 5.5E-5 to 1.0E-4 6.9E-5 to 9.1E-5 5.6E-5 to 8.6E-5	°C °C °C °C °C °C °C °C °C °C °C °C °C °	ASTM D648 ISO 75-2/B ISO 75-2/B ASTM D648 ISO 75-2/A ISO 75-2/A ASTM D794 ASTM D1525 ISO 306 ASTM E831 ISO 11359-2 ASTM E831 ISO 11359-2
Deflection Temperature Under Load 0.45 MPa, Unannealed 0.45 MPa, Unannealed 0.45 MPa, Annealed 1.8 MPa, Unannealed 1.8 MPa, Unannealed 1.8 MPa, Annealed Continuous Use Temperature Vicat Softening Temperature CLTE Flow Flow Flow Flow Flow Transverse Transverse Thermal Conductivity 	 100 120 	86.9 to 131 87.6 to 131 92.0 to 129 79.9 to 116 78.9 to 113 94.6 to 110 60.0 to 100 89.9 to 139 92.5 to 141 7.1E-5 to 8.3E-5 5.3E-5 to 7.6E-5 5.5E-5 to 1.0E-4 6.9E-5 to 9.1E-5 5.6E-5 to 8.6E-5 0.20 to 0.37	°C °C °C °C °C °C °C °C °C °C °C °C °C °	ASTM D648 ISO 75-2/B ISO 75-2/B ASTM D648 ISO 75-2/A ISO 75-2/A ASTM D1525 ISO 306 ASTM D696 ASTM E831 ISO 11359-2 ASTM E831 ISO 11359-2 ASTM C177

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Thermal	XANTAR™ CF 407	Generic PC+ABS	Unit	Test Method
RTI Elec				UL 746B
		60.0 to 90.4	°C	
1.5 mm	95.0		°C	
3.0 mm	95.0		°C	
RTI Imp				UL 746B
		60.0 to 90.0	°C	
1.5 mm	90.0		°C	
3.0 mm	95.0		°C	
RTI Str				UL 746B
		60.0 to 90.4	°C	
1.5 mm	90.0		°C	
3.0 mm	95.0		°C	
Effective Thermal Diffusivity	1.00E-7		m²/s	
Electrical	XANTAR™ CF 407	Generic PC+ABS	Unit	Test Method
Surface Resistivity				
		1.0E+4 to 2.5E+15	ohms	ASTM D257
	> 1.0E+15	5.1E+3 to 1.3E+16	ohms	IEC 60093
Volume Resistivity				
		1.0 to 1.0E+17	ohms∙cm	ASTM D257
	> 1.0E+15	1.0E+11 to 5.0E+16	ohms∙cm	IEC 60093
Dielectric Strength				
		8.5 to 40	kV/mm	ASTM D149
		15 to 37	kV/mm	IEC 60243-1
Dielectric Constant				
		3.00 to 3.01		ASTM D150
		2.89 to 3.10		IEC 60250
1 MHz	3.00			IEC 60250
		2.95		IEC 60250
Dissipation Factor				
		4.9E-3 to 9.1E-3		ASTM D150
		1.0E-3 to 9.6E-3		IEC 60250
Arc Resistance		119 to 123	sec	ASTM D495
Comparative Tracking Index	600	218 to 600	V	IEC 60112
Flammability	XANTAR™ CF 407	Generic PC+ABS	Unit	Test Method
Burning Rate		33 to 100	mm/min	ISO 3795
Flame Rating				UL 94
1.5 mm	V-0			
3.0 mm	• V-0 • 5VB			
Glow Wire Flammability Index				IEC 60695-2-12
		642 to 960	°C	
1.5 mm	960		°C	
3.0 mm	960		°C	

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Flammability	XANTAR™ CF 407	Generic PC+ABS	Unit	Test Method
Glow Wire Ignition Temperature				IEC 60695-2-13
		694 to 960	°C	
1.5 mm	750		°C	
3.0 mm	725		°C	
Oxygen Index				
		28 to 32	%	ASTM D2863
	32	23 to 34	%	ISO 4589-2
Fill Analysis	XANTAR™ CF 407	Generic PC+ABS	Unit	Test Method
Melt Density	1.01		g/cm³	
Melt Viscosity		170 to 255	Pa·s	ASTM D3835
Melt Thermal Conductivity	0.23		W/m/K	
Specific Heat Capacity of Melt	2220		J/kg/°C	
Injection	XANTAR™ CF 407	Generic PC+ABS	Unit	
Drying Temperature				
		79 to 110	°C	
Hot Air Dryer	100		°C	
Drying Time				
		2.7 to 5.0	hr	
Hot Air Dryer	4.0		hr	
Drying Time, Maximum		6.0	hr	
Suggested Max Moisture		0.020 to 0.024	%	
Suggested Shot Size		50 to 55	%	
Hopper Temperature		70 to 74	°C	
Rear Temperature	260 to 280	218 to 266	°C	
Middle Temperature	260 to 280	229 to 274	°C	
Front Temperature	260 to 280	234 to 270	°C	
Nozzle Temperature	260 to 280	249 to 273	°C	
Processing (Melt) Temp		243 to 275	°C	
Mold Temperature	50 to 80	59 to 86	°C	
Injection Pressure		85.3 to 99.0	MPa	
Holding Pressure		74.7 to 75.0	MPa	
Back Pressure		0.138 to 10.0	MPa	
Screw Speed		52 to 56	rpm	
Vent Depth		0.050 to 0.057	mm	
Ejection Temperature	105		°C	
Injection Notes				

Generic PC+ABS This data represents typical values that have been calculated from all products classified as: Generic PC +ABS

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Extrusion	XANTAR™ CF 407	Generic PC+ABS	Unit
Drying Temperature		89 to 95	°C
Drying Time		3.0 to 7.0	hr
Melt Temperature		250 to 257	°C
Extrusion Notes			

Extrusion notes

Generic PC+ABS This data represents typical values that have been calculated from all products classified as: Generic PC +ABS

This information is provided for comparative purposes only.

Notes

¹ A UL Yellow Card contains UL-verified flammability and electrical characteristics. UL Prospector continually works to link Yellow Cards to individual plastic materials in Prospector, however this list may not include all of the appropriate links. It is important that you verify the association between these Yellow Cards and the plastic material found in Prospector. For a complete listing of Yellow Cards, visit the UL Yellow Card Search.

² Typical properties: these are not to be construed as specifications.

³ 2.0 mm/min



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Where to Buy

Supplier	
XANTAR™ CF 407	Mitsubishi Chemical Corporation Tokyo, Tokyo Japan Telephone: +81-3-6748-7300 Web: https://www.m-chemical.co.jp/en/index.html
Generic PC+ABS	Generic
Distributor	
XANTAR™ CF 407	 Nexeo Plastics - Europe Nexeo Plastics is a Pan European distribution company. Contact Nexeo for availability of individual products by country. Telephone: +34-93-480-9125 Web: https://www.nexeoplastics.com/ Availability: Austria, Belgium, Bulgaria, Czech Republic, Denmark, Finland, France, Germany, Ireland, Italy, Latvia, Lithuania, Luxembourg, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Spain, Sweden, Switzerland, United Kingdom RESINEX Group RESINEX is a Pan European distribution company. Contact RESINEX for availability of individual products by country. Telephone: +32-14-672511 Web: http://www.resinex.com/ Availability: Europe
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