

Polycarbonate injection molding type | Colour: Black/Compound glassfilled 10%

Property	Method	Measurement condition	Unit	Values
Melt Flow Rate	ISO 1133	300 °C; 1,2 kg	g /10 min	12
Izod Impact Strength at 23°C	ISO 180	notched	kJ/m ²	10
Tensile Modulus	ISO 527-1	1 mm/min	MPa	3600
Tensile strength	ISO 527-1	5 mm/min	MPa	55
Flexural-modulus	ISO 527-1	2 mm/min	MPa	3300
Heat Deflection Temperature	ISO 75A	A	°C	140
Vicat Temperature	ISO 306	50N; 50 °C/h	°C	145
Shore hardness	ISO 868	D		78
Density	ISO 1183-1	method A	g/cm ³	1,25
Burning Behavior	UL - 94	1,6	mm	HB
Burning rate (US-FMVSS)	ISO 3795	>=1.0 mm	mm/min	passed
Moldschrinkage	Inhouse method		%	0,3-0,7

Application data

Description	Black opaque 10% glassfilled PolyCarbonate with good flow.
Application	Injection Moulding
Drying conditions	120 °C , 4-6 hours moisture content < 0,02%
Moulding temperature - Nozzle	280 - 320 °C
Moulding temperature - Barrel	270 - 320 °C
Mould Temperature	80 - 120 °C
Compression ratio	2:1 - 2,5:1
Injection Pressure	Low
Injection Speed	Fast ram speed
Hold Pressure	Low
Screw speed	0,1 - 0,2 m/s
Cushion	4 - 6 mm
Back Pressure	0 - 1,0 MPa

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