

Polycarbonate injection molding type | Colour: Light Grey

Property	Method	Measurement condition	Unit	Values
Melt Flow Rate	ISO 1133	300 °C; 1,2 kg	g /10 min	35
Izod Impact Strength at 23 °C	ISO 180	notched	kJ/m ²	12
Tensile strength	ISO 527-1	10 mm/min	MPa	44
E-modulus	ISO 527-1	10 mm/min	GPa	2,1
Heat Deflection Temperature	ISO 75A	A	°C	122
Shore hardness	ISO 868	D		72
Density	ISO 1183-1	method A	g/cm ³	1,21
Moldschrinkage	Inhouse method		%	0,5-0,8

Application data

Description	RAL 7035 PolyCarbonate with good flow.
Application	Injection Moulding
Drying conditions	120 °C , 6 - 8 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

This information contained in this document is based on testing carried out by our laboratory. To the best of our knowledge and at the time of publication, this information is true and accurate. It shall however, in no event be held to constitute or imply warranty, undertaking express or implied commitment from the part of supplier. No liability whatsoever can be accepted by supplier with regard to the handling, processing or use of the product concerned which must in all cases be used in accordance with all applicable laws and regulations. Material is conform RoHS and Reach regulations and without heavy metals rev.date 28 03 2017

