

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 <sup>2</sup>	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 <sup>3</sup>	1,21
Moldschrinkage	Inhouse method		%	0,5-0,8

**Application data**

Description	RAL 7040 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

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