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BRINGS OUT THE BEST IN PLASTICS

Partner Onte Onte Desting pursical PROPERTIES 1,41 g/cm³ ISO 1183 MEI at 100°C/2.16kg 9 g/d0min ISO 1133 MECHANICAL PROPERTIES 2600 MPa ISO 178 Flexural modulus at +23°C 2600 MPa ISO 178 Maximum flexural strength 2500 MPa ISO 178 Maximum tensile strength 650 MPa ISO 178 Elongation at break - % ISO 527-2 Elongation at break - % ISO 179 Natched Charpy at +23°C 8 KJm² ISO 179 Notched Charpy at +23°C 8 KJm² ISO 179 Notched Charpy at +23°C - KJm² ISO 179 Nontched Charpy at -23°C - KJm² ISO 179 Notted Charpy at -23	Feature	Value	Unit	Testmethod
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Heat Distortion Temperature	Unnotched Charpy at -20°C		kJ/m²	ISO 179
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PROCESS INSTRUCTIONSDrying time2-4hDrying temperature70-90°CMelt temperature190-210°CMould temperature70-110°CPeripherical screw speed150-450mm/s	Mould shrinkage (with flow)	1,8-2,0	%	ISO 294-4
Drying time2-4hDrying temperature70-90°CMelt temperature190-210°CMould temperature70-110°CPeripherical screw speed150-450mm/s	Mould shrinkage (across flow)	1,8-2,0	%	ISO 294-4
Drying temperature70-90°CMelt temperature190-210°CMould temperature70-110°CPeripherical screw speed150-450mm/s	PROCESS INSTRUCTIONS			
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Mould temperature70-110°CPeripherical screw speed150-450mm/s	Drying temperature	70-90	°C	
Peripherical screw speed 150-450 mm/s	Melt temperature	190-210	°C	
Peripherical screw speed 150-450 mm/s	Mould temperature	70-110	°C	
Back pressure 60-100 bar	Peripherical screw speed	150-450	mm/s	
	Back pressure	60-100	bar	

During production stops, emptying the cylinder is recommended. Leave the screw in its front most position. For polycarbonate it is also recommended to leave the cylinder temperature at 160- 180°C and that the heating on the feeding zone is on. When producing details in flame retardant material, corrosion protected steel is to recommend for the mould. For further information, see the material safety datasheet (MSDS).

Stated values in this datasheet are approximate. The values originate, if nothing else is stated, from standardised test specimens in natural colour. All information, recommendations and advice given by Polykemi AB or any of its subsidiaries and affiliates, written or verbal, are according to Polykemi AB's knowledge to the date of this edition, correct and given in good faith. It is the responsibility of the customer to test and evaluate if the material suits the application and the environment in which it is intended to be used. Polykemi AB, its subsidiaries can not be held responsible or liable for any loss incurred through incorrect or faulty use of the products. When producing details in flame retardant material, corrosion protected steel is to recommend for the mould. Polykemi AB takes no responsibility or any printing errors.

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