REZYcom PP

R141 UVVT

Features:
Heat stabilized, UV stabilized

Property	Value	Unit	Test method
*** PHYSICAL PROPERTIES ***			
Density	0,92	g/cm³	ISO 1183
MFI at 230°C/2,16kg	6	g/10min	ISO 1133
*** MECHANICAL PROPERTIES ***			
Flexural modulus at +23°C	1100	MPa	ISO 178
Maximum flexural strength	29	MPa	ISO 178
Maximum tensile strength	36	MPa	ISO 527-2
Elongation at break		%	ISO 527-2
Elongation at yield		%	ISO 527-2
*** IMPACT PROPERTIES ***			
Impact strength			
Notched Charpy at +23°C	23	kJ/m²	ISO 179
Notched Charpy at -20°C	5	kJ/m²	ISO 179
Unnotched Charpy at +23°C		kJ/m²	ISO 179
Unnotched Charpy at -20°C		kJ/m²	ISO 179
*** THERMAL PROPERTIES ***			
Heat Distortion Temperature			
HDT 120°C/h at 1820kPa (A)	42	°C	ISO 75/1
Softening temperature			
Vicat 50°C/h at 9,81N (A)		°C	ISO 306
Vicat 50°C/h at 49,05N (B)	59	°C	ISO 306
*** FLAMMABILITY PROPERTIES ***			
Flammability			
GWT at 2 mm		°C	IEC 695-2-1
UL94 at 1.6 mm	HB		UL94
*** HARDNESS ***			
Hardness Shore D (15 s)	60	Shore D	D2240
*** ADDITIONAL INFORMATION ***			
Filler content	2	±2%	ISO 3451
Mould shrinkage (with flow)	1,5-1,7	%	ISO 294-4
Mould shrinkage (across flow)	1,7-1,9	%	ISO 294-4
*** PROCESS INSTRUCTIONS ***			
Drying time	2-4	h	
Drying temperature	70-80	°C	
Melt temperature	180-230	°C	
Mould temperature	40-80	°C	
Peripherical screw speed	650-800	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

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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).

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