

## KIMIALEX PC(630GN)

MATERIAL NAME: PC      COLOR: NATURAL      CODE: 630GN

MATERIAL DESCRIPTION: Kimialex® 630GN is a 30% glass fiber reinforced, prime, natural Polycarbonate for injection molding.

No.	PROPERTIES		METHOD	UNIT	VALUE
<b>PHYSICAL PROPERTIES</b>					
1	ASH CONTENT		ISO 3451	%	41.5
2	RELATIVE DENSITY		ISO 1183	g/cm <sup>3</sup>	1.42
3	VISCOSITY NUMBER		ISO 307	Cm <sup>3</sup> /gr	-
4	MOISTURE CONTENT		ISO 62	%	0.213
<b>MECHANICAL PROPERTIES</b>					
5	TENSIL STRENGTH AT BREAK (5mm/min)		ASTM/D638	MPa	137
6	ELONGATION AT BREAK (5mm/min)		ASTM/D638	%	9.3
7	TENSIL MODULUS (5mm/min)		ASTM/D638	MPa	10700
8	NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m <sup>2</sup>	16.5
9	UN NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m <sup>2</sup>	62
<b>THERMAL PROPERTIES</b>					
10	HARDNESS		ISO 868	Shore D	78
11	MFI		ASTM/D1238	g/10min	-
12	VICAT(50° C/h)	10N	ASTM/D1238	° C	-
		50N			-
<b>FLAMMABILITY</b>					
13	HDT (120° C/h)	264psi	ASTM/D648	° C	-
		66psi			-
14	Flammability	Class	UL94	-	-
<b>INJECTION PROCESS PARAMETERS</b>					
<i>Loading</i>		<i>Injection</i>		<i>Degassing</i>	
<i>Speed</i>	<i>Pressure (Bar)</i>	<i>Speed</i>	<i>Pressure (Bar)</i>	<i>Temperature</i>	<i>Time</i>
80	100	90	140	80 °C	1h
<i>Mold Releasing</i>		<i>Zone</i>			
<i>Good</i>		5	4	3	2
		- °C	235°C	240 °C	245 °C
					1
					250°C