

Technical information

TEREZ[®] PC 2009 GF 15

Polycarbonate, 15 % glassfiber reinforced.



TECHNICAL DATA SHEET

Product text

For all kind of moulding parts with increased demand of stiffness.

Properties	Value	Unit	Test method
Density	1,3000	g/cm ³	ISO 1183
Melt flow index (MFI)	8,00	g/10 min	ISO 1133
MFI Temperature	300	°C	ISO 1133
MFI Load	1,20	kg	ISO 1133
Impact strength Charpy (Notched 23°C), dry	8	kJ/m ²	ISO 179
Elongation at tear, dry	2.5	%	ISO 527
Elongation at yield, dry	1,80	%	ISO 527
Tensile-modulus, dry	4800	MPa	ISO 527
Tensile strength, dry	80	MPa	ISO 527
HDT 1,80 MPa	140	°C	ISO 75
Vicat B/50	145	°C	ISO 306
CTI	175	V	IEC 60112
Thickness tested	1,5	mm	UL 94
Brennbarkeit bei nominal 1,5mm	V-2	class	UL 94
UL recognition	Ja / Yes		UL 94
GWFI at 1,0 mm	960	°C	IEC 60695-2-12
GWFI at 3 mm	960	°C	IEC 60695-2-12
Water absorption	0,30	%	ISO 62

PROCESSING DATA SHEET

Processing guidelines for injection molding of TEREZ PC 2009 GF 15

The processing data sheet provides guidelines about processing as well as pre-drying.

MATERIAL PREPARATION

Storage

Store in a dry place protected from direct sunlight. Avoid all sources of ignition like extreme heat, sparks, or open flame.

Drying

For the manufacturing of mechanically and optically optimal injection molding parts, we recommend following pre-drying conditions according to the table below. If the container is open (wet granules), the drying time can be extended accordingly.

Dry air dryer

Temperature	120°C
Time	4 hours
Due point	-40°C

Residual moisture

<= 0.03% (recommended)

MACHINE REQUIREMENTS

PROCESSING

Basic settings

The following basic settings are generally to be selected:

Temperatures

Processing temperatures

Hopper	60 - 80°C
Center	270 - 290°C
Nozzle	270 - 290°C

Mold temperature

Temp.	80 - 120°C
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Residence time

You should try to keep the residence time short, especially at high temperatures to avoid material degradation.

Instructions for cleaning

The aggregate can be cleaned by using low MFI polypropylene. You can also use standard cleaning granulate.