

Technical information

TEREZ[®] PC 9011

Crystal clear Polycarbonate, very low viscosity, mould release.



TECHNICAL DATA SHEET

Product text

For thinwalled injection moulding parts.

Properties	Value	Unit	Test method
Density	1,2000	g/cm ³	ISO 1183
Melt flow index (MFI)	25,00	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	15	kJ/m ²	ISO 179
Elongation at tear, dry	50	%	ISO 527
Elongation at yield, dry	6,00	%	ISO 527
Tensile stress at yield, dry	60	MPa	ISO 527
Tensile-modulus, dry	2300	MPa	ISO 527
HDT 1,80 MPa	130	°C	ISO 75
Vicat B/50	145	°C	ISO 306
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	1,6	mm	UL 94
UL recognition	-		UL 94
Water absorption	0,35	%	ISO 62

PROCESSING DATA SHEET

Processing guidelines for injection molding of TEREZ PC 9011

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.