

# Technical information

## TEREZ<sup>®</sup> PC 9005 L

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Crystal clear with mould release, food contact.



## TECHNICAL DATA SHEET

### Product text

For all injection moulding parts.

Properties	Value	Unit	Test method
Density	1,2000	g/cm <sup>3</sup>	ISO 1183
Melt flow index (MFI)	10,00	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	35	kJ/m <sup>2</sup>	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 9005 L

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.