

# Technical information

## TEREZ<sup>®</sup> PC 1005 GF 20

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Medium flowability polycarbonate with 20% glass fibre reinforcement.



## TECHNICAL DATA SHEET

### Product text

For injection moulding.

Properties	Value	Unit	Test method
Density	1,3400	g/cm <sup>3</sup>	ISO 1183
Impact strength Charpy (Notched 23°C), dry	8	kJ/m <sup>2</sup>	ISO 179
MFI 300°C/1,2 kg	10,00	g/10 min	ISO 1133
Impact strength Charpy 23°C, dry	38	kJ/m <sup>2</sup>	ISO 179
Elongation at tear, dry	2	%	ISO 527
Tensile-modulus, dry	6000	MPa	ISO 527
GWIT bei 2,0 mm	875	°C	IEC 60695-2-13
Tensile strength, dry	75	MPa	ISO 527
HDT 0,45 MPa	142	°C	ISO 75
HDT 1,80 MPa	135	°C	ISO 75
Vicat B/120	147	°C	ISO 306
Burning Behav. at thickness h	V-2	class	UL 94
Thickness tested	1,6	mm	UL 94
UL recognition	-		UL 94
GWFI at 1,0 mm	960	°C	IEC 60695-2-12
GWIT bei 1,0 mm	875	°C	IEC 60695-2-13
GWFI at 2 mm	960	°C	IEC 60695-2-12

## PROCESSING DATA SHEET

### Processing guidelines for injection molding of TEREZ PC 1005 GF 20

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.