

KIMIALEX PC(605UN)

MATERIAL NAME: PC COLOR: NATURAL CODE: PC605UN

MATERIAL DESCRIPTION: [Kimialex 605UN](#) is UV stabilized PC masterbatch for top layer of PC sheets.

No.	PROPERTIES		METHOD	UNIT	VALUE
PHYSICAL PROPERTIES					
1	ASH CONTENT		ISO 3451	%	20.0
2	RELATIVE DENSITY		ISO 1183	g/cm ³	1.17
3	VISCOSITY NUMBER		ISO 307	Cm ³ /gr	---
4	MOISTURE CONTENT		ISO 62	%	0.18
MECHANICAL PROPERTIES					
5	TENSIL STRENGTH AT BREAK (5mm/min)		ASTM/D638	MPa	65.6
6	ELONGATION AT BREAK (5mm/min)		ASTM/D638	%	161
7	TENSIL MODULUS (5mm/min)		ASTM/D638	MPa	2900
8	NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	10
9	UN NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	N.B
THERMAL PROPERTIES					
10	HARDNESS		ISO 868	Shore D	74
11	MFI		ASTM/D1238	g/10min	-
12	VICAT(50° C/h)	10N	ASTM/D1238	° C	-
		50N			-
FLAMMABILITY					
13	HDT (120° C/h)	264psi	ASTM/D648	° C	-
		66psi			-
14	Flammability	Class	UL94	-	-
INJECTION PROCESS PARAMETERS					
<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>
70	90	90	140	80 °C	0.5h
<i>Mold Releasing</i>			<i>Zone</i>		
<i>Good</i>			5	4	3
			- °C	235 °C	240 °C
				2	1
				245 °C	250 °C