

KIMIALEX PC(640GN)

MATERIAL NAME: PC **COLOR:** NATURAL **CODE:** 640GN

MATERIAL DESCRIPTION: Kimialex® 630GN is a 40% glass fiber reinforced, prime, natural Polycarbonate for injection molding.

No.	PROPERTIES		METHOD	UNIT	VALUE
PHYSICAL PROPERTIES					
1	ASH CONTENT		ISO 3451	%	52.2
2	RELATIVE DENSITY		ISO 1183	g/cm ³	1.51
3	VISCOSITY NUMBER		ISO 307	Cm ³ /gr	-
4	MOISTURE CONTENT		ISO 62	%	0.25
MECHANICAL PROPERTIES					
5	TENSIL STRENGTH AT BREAK (5mm/min)		ASTM/D638	MPa	145
6	ELONGATION AT BREAK (5mm/min)		ASTM/D638	%	9
7	TENSIL MODULUS (5mm/min)		ASTM/D638	MPa	12200
8	NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	15.5
9	UN NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	58
THERMAL PROPERTIES					
10	HARDNESS		ISO 868	Shore D	79
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>
80	100	90	140	80 °C	1h
<i>Mold Releasing</i>		<i>Zone</i>			
Good		5	4	3	2
		- °C	235°C	240 °C	245 °C