

Gebalon 21-141

Polycarbonate

geba Kunststoffcompounds GmbH

Message:

Medium viscosity PC type

Applications:

technical injection molded parts for various sectors (Automotive, Electrical, Electronic, Mechanical)

General Information			
Features	Medium Viscosity		
Uses	Automotive Applications		
	Electrical/Electronic Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	21.0	cm ³ /10min	ISO 1133
Molding Shrinkage	0.40 to 1.0	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2200	MPa	ISO 527-2/1/1
Tensile Stress (Yield)	57.0	MPa	ISO 527-2/50
Tensile Strain (Yield)	6.2	%	ISO 527-2/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	12	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	136	°C	ISO 75-2/B
1.8 MPa, Unannealed	124	°C	ISO 75-2/A
Vicat Softening Temperature	141	°C	ISO 306/B50
Injection	Nominal Value	Unit	
Drying Temperature - Dry Air Dryer	100 to 120	°C	
Drying Time - Dry Air Dryer	2.0 to 4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	250 to 270	°C	
Middle Temperature	270 to 300	°C	
Front Temperature	280 to 310	°C	
Nozzle Temperature	280 to 310	°C	
Processing (Melt) Temp	280 to 310	°C	
Mold Temperature	80.0 to 120	°C	

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