

Clariant Renol PCSP0004 Polycarbonate Alloy

Category : Polymer , Thermoplastic , Polycarbonate (PC)

Material Notes:

Data provided by Clariant Masterbatches

Order this product through the following link:

http://www.lookpolymers.com/polymer_Clariant-Renol-PCSP0004-Polycarbonate-Alloy.php

Processing Properties	Metric	English	Comments
Melt Temperature	321 - 343 °C	610 - 650 °F	
Mold Temperature	82.2 - 104 °C	180 - 220 °F	
Dry Time	2 - 4 hour @Temperature 104 °C	2 - 4 hour @Temperature 220 °F	to eliminate surface defects
Injection Pressure	4.96 - 8.27 MPa	720 - 1200 psi	Secondary
	8.27 - 13.8 MPa	1200 - 2000 psi	Initial
Back Pressure	0.345 - 1.72 MPa	50.0 - 250 psi	
Shot Size	30 - 80 %	30 - 80 %	
Screw Speed	20 - 100 rpm	20 - 100 rpm	

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