ECOMPOUNDS®
COMPOUNDS BY KORRELS

KIJK VOOR MEER INFORMATIE OP WWW.KORRELS.NL OF BEL MET (038) 447 93 25

			PA 6		PA 66				PP	PPH		PBT	PC					PE	PS	ABS			ASA	BLENDS		
PROPERTY	METHOD	UNIT	PA 6 30% GF NATURAL	PA 6 30% GF BLACK	PA 66 30% GF BLACK	PA 66 BLACK	PA 66 BLACK	PA 66 NATURAL	PP BLACK	PPH 20% TALC BLACK	PPH 30% GF BLACK	PBT GF 30	PC NATURAL MFI 14	PC BLACK	PC V0 BLACK	PC V0 BLACK	PC RAL 7035	PE100 BLACK	PS WHITE MFI +/- 7	ABS INJECTION MOLDING BLACK	ABS INJECTION MOLDING UV	ABS BLACK	ASA	PC/ABS BLACK	PC/ABS FR BLACK	PC/ABS GF 10
GENERAL																										
Density		ISO 1183	1.34 - 1.36	1.34 - 1.36	1.35 - 1.38	1.13 - 1.15	1.12 - 1.15	1.12 - 1.15	0.89 - 0.94	1.04 - 1.09	1.11 - 1.14	1.53	1.2	1.21	1.21	1.25	1.21	0.95	1.05	1.06	1.07	1.07	1.07	1.18	1.19	1.23
Molding Shrinkage	Parallel / Normal	ISO 294-4	0.1	0.1	< 0.3	< 1.5	< 1.5	< 1.5	1 - 2	0.5 - 1.6		0.4		0.5 - 0.8	0.3 - 0.7	0.3 - 0.7	0.5 - 0.8			0.4	0.4	0.4	0.4	0.6	0.6	0.45
MECHANICAL																										
Tensile Stress at Break	23 °C	ISO 527-2	140 - 160		120 - 130						50 - 60		64	44	55	55	44	23						44	48	48
Tensile Strain at Break	23 °C	ISO 527-2	3 - 4%	2 - 4%	2 - 3%	> 10%	> 15%	60 - 70%		> 30%	2 - 4%		110%	110%	110%	110%	110%	9%						110%	110%	110%
Tensile Modulus	23 °C	ISO 527-2	9 - 10	8.5 - 9.5	9 - 10	2.5 - 3.5	2.5 - 5.5	2.5 - 3.5		1.1 - 2.2	5 - 6	9.2	2.2	2.1	2.3	3.6	2.1	0.9		2.4	2.5	2.5	2.5	2.2	2.3	4.2
Izod Impact Strenght, notched	23 °C	ISO 180/A	10 - 14	7 - 11	7 - 12	8 - 14	7 - 9	> 5	5.5 - 6	7 - 13	8 - 12	7	14	18	18	10	12	20	> 5	12	9	9	15	28	18	8
THERMAL																										
Melting Temperature	10 K/min	ISO 11357	210 - 230	220 - 225	250 - 270	250 - 270		250 - 270	155 - 165	165 - 170	165 - 175							190 - 220								
Heat Deflection Temperature		ISO 75/A	200			180	180	70	100			215	124	122	140	140	122						106	122	102	102
Vicat Softening Temperature		ISO 75/A		190 - 200		210						110	141	141	142	145	141	74		94	96	94	104	145	110	110
Flammability	mm																								2	
MOLDING CONDITIONS																										
Predrying temperatures		°C	90 - 100	90 - 100	90 - 110	90 - 110	90 - 100	90 - 110		80	80	100 - 120	120	120	120	120	120			80	80	80	80	90	80	100
Predrying time		hour	3 - 4	3 - 4	3 - 4	3 - 4	3 - 4	3 - 4		1 - 2	1 - 2	6 - 8	6 - 8	6 - 8	6 - 8	4 - 6	6 - 8			4 - 6	4 - 6	4 - 6	4 - 6	6 - 8	6 - 8	6 - 8
Nozzle temperature		°C	230 - 240	210 - 230	250 - 270	260 - 290	250 - 270	260 - 290		230	230	250 - 270	280 - 320	280 - 320	280 - 320	280 - 320	270 - 295			220 - 260	220 - 260	220 - 260	220 - 260	250 - 270	235 - 255	250 - 270
Barrel temperature		°C	220 - 240	220 - 240	270 - 290	270 - 290	270 - 290	270 - 290		200 - 240	200 - 240	240 - 280	270 - 320	270 - 320	270 - 320	270 - 320	270 - 295		190 - 260	220 - 250	230 - 260	220 - 250	230 - 260	240 - 280	230 - 250	240 - 280
Mold temperature		°C	60 - 100	60 - 100	80 - 100	80 - 100	80 - 100	80 - 100		40 - 70	40 - 70	60 - 100	80 - 120	80 - 120	80 - 120	80 - 120	80 - 120			30 - 80	30 - 80	30 - 80	30 - 80	60 - 100	60 - 80	60 - 100
Hold pressure					50 - 100	50 - 100	50 - 100	50 - 100		50 - 100	50 - 100	Low to medium	Low	Low	Low	Low	Low			Low to medium	Low to medium	Low to medium	Low to medium	Low to medium	Low to medium	Low to medium