

Technical data

KEBALLOY ECO R-PC FE 211004 transparent

KEBALLOY ECO R-PC FE 211004 transparent is an unreinforced polycarbonate made of 100% PCR recyclate.

Polymer: PC

ISO designation: PC(REC)

Productgroup: Recycling Compounds

Brief description of the product family:

The name KEBALLOY ECO stands for a product range of engineering plastics and high-performance compounds based on post-consumer or post-industrial recyclate. KEBALLOY ECO compounds enable significant CO2 savings compared to virgin materials and meet the highest requirements in terms of product properties and their uniformity from batch to batch. KEBALLOY ECO compounds also enable customer- or application-specific microcycles of engineering plastic parts and are thus a valuable contribution on the way to a circular plastics economy.

Properties:

amorphous, impact resistant

Typical areas of application:

Covers, Cover, Housing

Industries:

Automotive, Electrical and electronics industry, Household appliances, Industry, Optics

Physical properties

Density in kg/m ³ ISO 1183-1	1190.00
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Mechanical properties

E-modulus in MPa ISO 527-1	2400
Yield stress in MPa ISO 527-1	65
Elongation at yield in % ISO 527-1	6.0
Elongation at break in % ISO 527-1	75.0
Impact strength (Charpy) at 23°C in kJ/m ² ISO 179-1eU	100.0
Notched impact strength (Charpy) at 23°C in kJ/m ² ISO 179-1eA	25

Rheological properties

Melt flow rate MFR in g/10min ISO 1133	17
Melt flow rate MFR (test condition)	300°C / 1,2 kg
Shrinkage transverse to the flow direction in % ISO 294-4	0.5
Shrinkage in flow direction in % ISO 294-4	0.4

Thermal properties

Fire behavior (0.4 mm wall thickness) IEC 60695-11-10	HB
Fire behavior (0.8 mm wall thickness) IEC 60695-11-10	HB
Fire behavior (1.6 mm wall thickness) IEC 60695-11-10	HB
Fire behavior (3.2 mm wall thickness) IEC 60695-11-10	HB
Glass transition temperature in °C DIN EN ISO 11357-1	145

Processing instructions:**Pre-drying:**

Dryer type: dry air dryer

Temperature: 120°C

Drying time: 3 – 4 h

Residual moisture: < 0.02%.

Temperatures:

Melt temperature: 280 – 320°C

Mold temperature: 80 – 120°C

Back pressure: max. 80 bar (spec.)

Injection speed: medium

Legal notices:

The information in this data sheet is based on our current knowledge and experience. Due to the wide range of possible influences during processing and application of our products, they do not exempt the processor from carrying out his own tests and trials. A legally binding assurance of certain properties or suitability for a specific application cannot be derived from our information.

* FE products are development products which are still in the trial phase. Technical data may still change in the course of product and process development. No final decision has yet been made on the commercialization of FE products. We reserve the right to discontinue the manufacture of FE products without giving further reasons.

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