

MedEco ICB

Technical Data Sheet

Material properties

All values given are indicative. The data was measured on test objects and may vary due to product-specific geometry and process characteristics.

Property	Method	Condition	Value	Unit
Density			1,24	g/cm ³
MFI	ISO 1133-A	190°C/ 2,16 kg	30	g/10min
Melting point	ISO 3146		175	°C
Tensile Strength	ISO 527-1/1A		65	N/mm ²
Elongation at Break	ISO 527-1/1A		5.5	%
Tensile Modulus	ISO 527-1/1A		3450	N/mm ²
IZOD Notched Impact Strength	ISO 180	23°C	2,5	kJ/m ²
HDT-B	ISO 75-1	0,45 N/mm ²	60	°C
Mold Shrinkage			0,45-0,8	%

Processing instructions

Pre-drying: min. 6h at 60°C

Parameter	Value	Unit
Funnel temperature	40	°C
Feed Zone	170	°C
Compression Zone	180	°C
Metering Zone	190	°C
Nozzle Temperature	185	°C
Mold Temperature	30 – 40	°C
Screw Speed	Low	
Injection Pressure	Medium	
Holding Pressure	80% of Injection Pressure Switch at 95% - 98% filling	
Injection Speed	Medium	
Cooling time	Medium - Long	