

# MedEco XCB C1

## 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 <sup>3</sup>
MFI	ISO 1133-A	190°C/ 2,16 kg	2.6	g/10min
Melting point	ISO 3146		175	°C
Tensile Strength	ISO 527-1/1A		75	N/mm <sup>2</sup>
Elongation at Break	ISO 527-1/1A		2.5	%
Tensile Modulus	ISO 527-1/1A		3540	N/mm <sup>2</sup>
IZOD Notched Impact Strength	ISO 180	23°C	4	kJ/m <sup>2</sup>
HDT-B	ISO 75-1	0,45 N/mm <sup>2</sup>	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	