



## Kimalloy 3240

### Polycarbonate Alloy

#### Product Description

Kimalloy 3240 is a polymeric alloy of polycarbonate and poly (acrylonitrile – butadiene – styrene). This product offers good surface appearance, good flow, high impact resistance, low shrinkage percent and good heat resistance. The high impact resistance of this product even at low temperatures makes it suitable for automotive applications. This grade is especially suitable for metallizing applications.

#### Applications:

Automotive parts, household Parts

#### General

Material Status	• Commercial: Active		
Availability	• Middle East, Asia		
Features	• Good process ability	• Metallizable grade	
Uses	• Automotive parts	• household Parts	
Forms	• Pellets		
Color	• Black		
Packaging	• 25 kg PE bag		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12 ± 0.02	-	ISO 1183
Ash Content (600°C)	< 0.5	%	ISO 3451
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (yield)	55 ± 2	MPa	ISO 527
Tensile Modulus	2200 ± 100	MPa	ISO 527
Tensile Strain (Break)	> 50	%	ISO 527
Charpy unnotched Impact Strength at 23°C	N.B	kJ/m <sup>2</sup>	ISO 179
Charpy unnotched Impact Strength at -30°C	N.B	kJ/m <sup>2</sup>	ISO 179
Charpy notched Impact Strength at 23°C	> 50	kJ/m <sup>2</sup>	ISO 179

#### Injection

As a guide the following temperature profile and other condition is recommended

Zone 1	Zone 2	Zone 3	Zone 4	Die	Mold Temperature
230-240°C	240-250°C	240-250°C	250-260°C	250-260°C	60-70°C
Drying Temperature			Drying Time		
90-100 °C			1-2 hr.		

#### Storage & Shelf Life

Sacks should be stored in dry/closed condition and protect from sunlight.

Shelf life at proper storage is at least 18 months from production date, but in case of a long storage time, potential moisture pick-up needs to be eliminated by drying before injection.

#### Note

- Test results have been achieved in lab condition. Miss handling may give different result and sometimes outside of the standard
- The specifications given are the guidelines only.
- Above compound is suitable to run on different machines; however some adjustments may be required on individual machine.
- The customers are advised to check the quality, prior to commercial use. There is no guarantee and/or warrantee what so ever, after processing