



**KKALPALON PC 3G**  
**GLASS FIBRE REINFORCED POLYCARBONATE COMPOUND**

**Technical Data Sheet**

KKALPALON PC 3G is a glass reinforced polycarbonate (PC) compound. It consists of around 30 weight% chopped strand glass fibres, compatibilized with the PC matrix by special coupling agent package. This is a thermally and dimensionally stable grade with balanced toughness and rigidity. This is offered in Natural and other colours.

**CATEGORY**

- Glass fibre reinforced polycarbonate composite
- KKALPALON PC 3G is usable directly for injection moulding

**COMPOUNDING**

- Carefully chosen imported PC grades melt blended homogeneously in twin screw compounding system
- Specially sized chopped strand glass fibres are introduced at appropriate compounding stage controlled by state-of-the-art loss-in-weight feeders,
- The complete compound protected by special additives for maintaining properties and to resist colour changes during further process

**APPLICATION**

- KKALPALON PC 3G is used directly for injection moulding of various useful components
- Many electrical, appliances, automotive, industrial and other segments use this grade for variety of components
- This grade is of immense use as metal replacement in many areas

**ADVANTAGES**

- Balanced rigidity & toughness
- Excellent thermal, chemical & dimensional stability
- Stored under proper conditions, very low moisture absorption Rev 12/23

## TECHNICAL SPECIFICATION

Properties	Test method	Unit	Typical value
<b>Physical Properties</b>			
Melt Flow Index @ 300° C/ 1.2 kgf	ASTM D-1238	gm / 10min	20 ± 2
Specific Gravity	ASTM D-792	-	1.42 ± 0.02
<b>Thermal Properties</b>			
Heat Deflection Temperature (1.8 Mpa / 3.2mm)	ASTM D-648	°C	150 ± 5
<b>Flammability</b>			
Flammability @ 3.2mm thickness	DPIL Std based on UL-94	-	NA
Glow Wire Index	IEC-60695-2-12	°C	NA
<b>Mechanical Properties</b>			
Notched Izod impact strength	ASTM D-256	Kg.cm/cm	11 ± 2
Tensile Strength at yield	ASTM D-638	Kg/cm <sup>2</sup>	1000 ± 100
Flexural strength	ASTM D-790	Kg/cm <sup>2</sup>	1800 ± 100
Flexural Modulus	ASTM D-790	Kg/cm <sup>2</sup>	67000 ± 1000

## IM PROCESS PARAMETERS

<b>Pre-Drying</b>		
Temperature	°C	100 - 110
Time	Hours	2 - 3
<b>Process Temperatures</b> (Guide lines only; Customer to optimize as per component requirements)		
Feed	°C	105 - 115
Zone-1	°C	255 – 265
Zone-2	°C	260– 270
Zone-3	°C	265 – 275
Nozzle	°C	260 - 270
Mould	°C	90 - 100

**Storage** : The material shall be kept in a cool and dry place.

**Form** : Pellets

**Package** : 25 kg bags

### **DISCLAIMER:**

The above Technical Data Sheet presents information and data, true and accurate to the best of our knowledge. No warranty expressed or implied can be made regarding performance or otherwise.

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