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Appendix A – Mould Assembly Drawing

Appendix B – Modified Mould Assembly Drawing

Appendix C – Product Drawing

Appendix D – Properties of Polycarbonate

Rheological properties	**Value**	**Unit**
Melt volume-flow rate, MVR	19	cm^3/10min
Temperature	300	°C
Moulding shrinkage, parallel	0.7	%
Moulding shrinkage, normal	0.7	%
Ejection temperature	130	°C
Mechanical properties		
Tensile Modulus	2400	MPa
Yield stress	66	MPa
Yield strain	6	%
Nominal strain at break	>50	%
Tensile creep modulus, 1h	2200	MPa
Tensile creep modulus, 1000h	1900	MPa
Test specimen production		
Injection Moulding, melt temperature	280	°C
Injection Moulding, mould temperature	80	°C
Injection Moulding, injection velocity	200	mm/s
Injection moulding		
Drying Temperature	120	°C
Drying Time	3-4	Hrs
Maximum moisture content	0.02	%
Vent Depth	0.025-0.075	mm