

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	12	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2100	MPa	ISO 527
Yield stress	40	MPa	ISO 527
Strain at break	25	%	ISO 527
Charpy impact strength, +23°C	70	kJ/m <sup>2</sup>	ISO 179/1eU
Izod notched impact strength, +23°C	17	kJ/m <sup>2</sup>	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	91	°C	ISO 75-1/-2
Vicat softening temperature, B	92	°C	ISO 306

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 90	°C	-
Pre-drying - Time	2 - 3	h	-
Processing humidity	≤0.1	%	-
Melt temperature	210 - 240	°C	-
Mold temperature	40 - 60	°C	-
Zone 1	205 - 215	°C	-
Zone 2	220 - 230	°C	-
Zone 3	230 - 240	°C	-
Nozzle temperature	230 - 235	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 1.5	MPa	-
Holding pressure	3 - 6	MPa	-

**Characteristics**

**Processing**

Injection Molding

**Applications**

General Purpose

**Special Characteristics**

High impact or impact modified

**Regional Availability**

Europe