

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.8 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Stress at break	116 / 64	MPa	ISO 527
Strain at break	2.5 / 10	%	ISO 527
Flexural modulus, 23°C	5100 / 3050	MPa	ISO 178
Flexural strength	166 / 97.2	MPa	ISO 178
Charpy notched impact strength, +23°C	5.05 / 16	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	5.05 / 16	kJ/m ²	ISO 180/1A

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	200 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	207 / *	°C	ISO 75-1/-2

Other properties	dry / cond	Unit	Test Standard
Density	1230 / -	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	71.1	°C	-
Pre-drying - Time	4	h	-
Melt temperature	271 - 293	°C	-
Mold temperature	26.7 - 93.3	°C	-
Zone 1	254	°C	-
Zone 2	268	°C	-
Zone 3	285	°C	-
Nozzle temperature	266 - 282	°C	-
Screw speed	30 - 60	rpm	-
Injection pressure	68.9	MPa	-
Back pressure	0.0689 - 0.689	MPa	-

Characteristics

Processing

Injection Molding

Delivery form

Pellets, Black

Additives

Lubricants

Special Characteristics

U.V. stabilized or stable to weather, Heat stabilized or stable to heat

Certifications

Recycled Resin Content

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa