

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|-------------------------------------|---------------|-------|---------------|
| ASTM Data | | | |
| Mold Shrinkage, MD | 0.0038 | mm/mm | ASTM D 955 |

| Mechanical properties | Value | Unit | Test Standard |
|---------------------------------------|-------------|-------------------|---------------|
| ISO Data | | | |
| Tensile Modulus | 3500 | MPa | ISO 527 |
| Stress at break | 90 | MPa | ISO 527 |
| Strain at break | 5.5 | % | ISO 527 |
| Flexural modulus, 23°C | 4100 | MPa | ISO 178 |
| Charpy impact strength, +23°C | 40 | kJ/m ² | ISO 179/1eU |
| Charpy notched impact strength, +23°C | 6 | kJ/m ² | ISO 179/1eA |
| Izod notched impact strength, +23°C | 6.5 | kJ/m ² | ISO 180/1A |

| Thermal properties | Value | Unit | Test Standard |
|--|-----------------------------|--------|----------------------|
| ISO Data | | | |
| Temp. of deflection under load, 1.80 MPa | 180^[ann.] | °C | ISO 75-1/-2 |
| Vicat softening temperature, B | 190 | °C | ISO 306 |
| Burning behav. at 1.5 mm nom. thickn. | HB | class | IEC 60695-11-10 |
| Thickness tested | 1.6 | mm | - |
| Burning behav. at thickness h | HB | class | IEC 60695-11-10 |
| Thickness tested | 3.2 | mm | - |
| Burning rate, FMVSS, Thickness 1 mm | 100 | mm/min | ISO 3795 (FMVSS 302) |
| Glow Wire Flammability Index (GWFI) | 650 | °C | IEC 60695-2-12 |
| GWFI - thickness tested (1) | 2 | mm | - |

ann.: annealed

| Other properties | Value | Unit | Test Standard |
|------------------------|-------------|-------------------|---------------|
| Density | 1250 | kg/m ³ | ISO 1183 |
| Water Absorption, 24hr | 0.15 | % | ASTM D 570 |

| Processing Recommendation Injection Molding | Value | Unit | Test Standard |
|---|------------------|------|---------------|
| Pre-drying - Temperature | 75 | °C | - |
| Pre-drying - Time | 3 - 4 | h | - |
| Processing humidity | ≤0.12 | % | - |
| Melt temperature | 240 - 270 | °C | - |
| Mold temperature | 70 - 90 | °C | - |
| Zone 1 | 220 - 230 | °C | - |
| Zone 2 | 230 - 245 | °C | - |
| Zone 3 | 250 - 260 | °C | - |
| Nozzle temperature | 250 - 260 | °C | - |
| Screw speed | 50 - 80 | rpm | - |
| Back pressure | 0.4 - 0.8 | MPa | - |
| Holding pressure | 6 - 8 | MPa | - |

Characteristics

Processing

Injection Molding

Special Characteristics

High impact or impact modified

Delivery form

Black

Regional Availability

Europe