

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
Molding shrinkage, normal	1.0	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Tensile Modulus	9900	MPa	ISO 527
Stress at break	145	MPa	ISO 527
Strain at break	4	%	ISO 527
Charpy impact strength, +23°C	70	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	8	kJ/m ²	ISO 179/1eA
Thermal properties			
ISO Data			
Melting temperature, 10°C/min	220	°C	ISO 11357-1/-3
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	0.8	mm	-
Other properties			
Water absorption	6.5	%	Sim. to ISO 62
Humidity absorption	1.85	%	Sim. to ISO 62
Density	1400	kg/m ³	ISO 1183
Material specific properties			
ISO Data			
Viscosity number	135	cm ³ /g	ISO 307, 1157, 1628
Processing Recommendation Injection Molding			
Pre-drying - Temperature	176	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	250 - 280	°C	-
Mold temperature	60 - 100	°C	-

Characteristics

Processing

Injection Molding

Special Characteristics

Heat stabilized or stable to heat

Certifications

Recycled Resin Content

Regional Availability

Europe