

| Processing/Physical Characteristics | dry / cond | Unit | Test Standard   |
|-------------------------------------|------------|------|-----------------|
| <b>ISO Data</b>                     |            |      |                 |
| Molding shrinkage, parallel         | 0.3 / *    | %    | ISO 294-4, 2577 |
| Molding shrinkage, normal           | 0.5 / *    | %    | ISO 294-4, 2577 |

| Mechanical properties                 | dry / cond    | Unit              | Test Standard |
|---------------------------------------|---------------|-------------------|---------------|
| <b>ISO Data</b>                       |               |                   |               |
| Tensile Modulus                       | 15000 / 10000 | MPa               | ISO 527       |
| Stress at break                       | 165 / 125     | MPa               | ISO 527       |
| Strain at break                       | 2.5 / 3.5     | %                 | ISO 527       |
| Charpy impact strength, +23°C         | 85 / 95       | kJ/m <sup>2</sup> | ISO 179/1eU   |
| Charpy notched impact strength, +23°C | 15 / 18       | kJ/m <sup>2</sup> | ISO 179/1eA   |
| Charpy notched impact strength, -30°C | 13 / -        | kJ/m <sup>2</sup> | ISO 179/1eA   |

| Thermal properties  | dry / cond | Unit  | Test Standard   |
|---|------------|-------|-----------------|
| <b>ISO Data</b>   |            |       |                 |
| Melting temperature, 10°C/min                             | 220 / *    | °C    | ISO 11357-1/-3  |
| Burning behav. at 1.5 mm nom. thickn.<br>Thickness tested | HB / *     | class | IEC 60695-11-10 |
|   | 1.5 / *    | mm    | -               |

| Other properties    | dry / cond | Unit              | Test Standard  |
|---------------------|------------|-------------------|----------------|
| Water absorption    | 4.8 / *    | %                 | Sim. to ISO 62 |
| Humidity absorption | 1.5 / *    | %                 | Sim. to ISO 62 |
| Density             | 1540 / -   | kg/m <sup>3</sup> | ISO 1183       |

| Processing Recommendation Injection Molding | Value     | Unit | Test Standard |
|---|-----------|------|---------------|
| Pre-drying - Temperature                    | 80        | °C   | -             |
| Pre-drying - Time                           | 4         | h    | -             |
| Processing humidity                         | ≤0.1      | %    | -             |
| Melt temperature                            | 260 - 280 | °C   | -             |
| Mold temperature                            | 80 - 120  | °C   | -             |

**Characteristics**

**Processing**

Injection Molding

**Certifications**

Recycled Resin Content

**Delivery form**

Pellets, Black

**Regional Availability**

Europe