

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	1.0	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	60	MPa	ISO 527
Strain at break	4.5	%	ISO 527
Flexural modulus, 23°C	4000	MPa	ISO 178
Charpy impact strength, +23°C	25	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	3.5	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	5	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	155 ^[ann.]	°C	ISO 75-1/-2
Vicat softening temperature, B	165	°C	ISO 306
ann.: annealed			

Other properties	Value	Unit	Test Standard
Humidity absorption	0.15	%	Sim. to ISO 62
Density	1280	kg/m ³	ISO 1183

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

Certifications

Recycled Resin Content

Regional Availability

Europe