

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|--|-----------------------|-------------------|-----------------|
| ISO Data | | | |
| Molding shrinkage, parallel | 1.0 | % | ISO 294-4, 2577 |
| Mechanical properties | | | |
| ISO Data | | | |
| Yield stress | 70 | MPa | ISO 527 |
| Strain at break | 3.5 | % | ISO 527 |
| Flexural modulus, 23°C | 5000 | MPa | ISO 178 |
| Charpy impact strength, +23°C | 35 | kJ/m ² | ISO 179/1eU |
| Charpy notched impact strength, +23°C | 4.5 | kJ/m ² | ISO 179/1eA |
| Izod notched impact strength, +23°C | 6 | kJ/m ² | ISO 180/1A |
| Thermal properties | | | |
| ISO Data | | | |
| Temp. of deflection under load, 1.80 MPa | 175 ^[ann.] | °C | ISO 75-1/-2 |
| Vicat softening temperature, B | 185 | °C | ISO 306 |
| ann.: annealed | | | |
| Other properties | | | |
| Humidity absorption | 0.15 | % | Sim. to ISO 62 |
| Density | 1350 | kg/m ³ | ISO 1183 |
| Processing Recommendation Injection Molding | | | |
| 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