

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	0.9	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	6000	MPa	ISO 527
Stress at break	110	MPa	ISO 527
Strain at break	4	%	ISO 527
Flexural modulus, 23°C	5000	MPa	ISO 178
Charpy impact strength, +23°C	40	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	7	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	7.5	kJ/m <sup>2</sup>	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	210	°C	ISO 75-1/-2
Vicat softening temperature, B	225	°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	-
Glow Wire Flammability Index (GWFI)	650	°C	IEC 60695-2-12
GWFI - thickness tested (1)	2	mm	-

Other properties	Value	Unit	Test Standard
Humidity absorption	0.15	%	Sim. to ISO 62
Density	1270	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	85	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.12	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	70 - 90	°C	-
Zone 1	250 - 260	°C	-
Zone 2	260 - 270	°C	-
Zone 3	280 - 290	°C	-
Nozzle temperature	280 - 285	°C	-
Screw speed	50 - 80	rpm	-
Back pressure	0.4 - 0.8	MPa	-
Holding pressure	6 - 8	MPa	-

## Characteristics

### Processing

Injection Molding

### Delivery form

Natural Color

### Special Characteristics

U.V. stabilized or stable to weather, Heat stabilized or stable to heat

### Certifications

Recycled Resin Content

### Regional Availability

Europe