

| Processing/Physical Characteristics | Value | Unit | Test Standard   |
|-------------------------------------|-------|------|-----------------|
| <b>ISO Data</b>                     |       |      |                 |
| Molding shrinkage, parallel         | 0.3   | %    | ISO 294-4, 2577 |
| Molding shrinkage, normal           | 0.8   | %    | ISO 294-4, 2577 |

| Mechanical properties                 | Value | Unit              | Test Standard |
|---------------------------------------|-------|-------------------|---------------|
| <b>ISO Data</b>                       |       |                   |               |
| Tensile Modulus                       | 7500  | MPa               | ISO 527       |
| Stress at break                       | 130   | MPa               | ISO 527       |
| Strain at break                       | 5     | %                 | ISO 527       |
| Flexural modulus, 23°C                | 7200  | MPa               | ISO 178       |
| Charpy impact strength, +23°C         | 45    | kJ/m <sup>2</sup> | ISO 179/1eU   |
| Charpy notched impact strength, +23°C | 6.5   | 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           | 230   | °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     | -                    |
| Burning rate, FMVSS, Thickness 1 mm      | 100   | mm/min | ISO 3795 (FMVSS 302) |
| 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             | 1410  | 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

Black

### Special Characteristics

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

### Certifications

Recycled Resin Content

### Regional Availability

Europe