

Product Texts

Soluble or severely attacked after brief contact.

Please consider the information about the application of the materials.

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|--|--------------|-------------|----------------------|
| ISO Data | | | |
| Molding shrinkage, parallel | 1.2 | % | ISO 294-4, 2577 |
| Molding shrinkage, normal | 1.4 | % | ISO 294-4, 2577 |

| Mechanical properties | Value | Unit | Test Standard |
|---------------------------------------|--------------|-------------------|----------------------|
| ISO Data | | | |
| Tensile Modulus | 2900 | MPa | ISO 527 |
| Yield stress | 81 | MPa | ISO 527 |
| Yield strain | 4.3 | % | ISO 527 |
| Strain at break | 35 | % | ISO 527 |
| Flexural modulus, 23°C | 3000 | MPa | ISO 178 |
| Flexural strength | 97 | MPa | ISO 178 |
| Charpy impact strength, +23°C | N | kJ/m ² | ISO 179/1eU |
| Charpy impact strength, -30°C | N | kJ/m ² | ISO 179/1eU |
| Charpy notched impact strength, +23°C | 5.5 | kJ/m ² | ISO 179/1eA |
| Charpy notched impact strength, -30°C | 4.9 | kJ/m ² | ISO 179/1eA |
| Izod notched impact strength, +23°C | 4.4 | kJ/m ² | ISO 180/1A |

| Thermal properties | Value | Unit | Test Standard |
|--|--------------|-------------|----------------------|
| ISO Data | | | |
| Melting temperature, 10°C/min | 262 | °C | ISO 11357-1/-3 |
| Temp. of deflection under load, 1.80 MPa | 67 | °C | ISO 75-1/-2 |
| Temp. of deflection under load, 0.45 MPa | 197 | °C | ISO 75-1/-2 |

| Other properties | Value | Unit | Test Standard |
|-------------------------|--------------|-------------------|----------------------|
| Density | 1140 | kg/m ³ | ISO 1183 |

| Material specific properties | Value | Unit | Test Standard |
|-------------------------------------|--------------------|--------------------|----------------------|
| ISO Data | | | |
| Viscosity number | 145 ^[1] | cm ³ /g | ISO 307, 1157, 1628 |

1: VN at 0.5% in sulfuric acid, nominal

| Processing Recommendation Injection Molding | Value | Unit | Test Standard |
|--|--------------|-------------|----------------------|
| Pre-drying - Temperature | 80 | °C | - |
| Pre-drying - Time | 6 - 12 | h | - |
| Processing humidity | ≤0.2 | % | - |
| Melt temperature | 280 - 295 | °C | - |
| Mold temperature | 50 - 90 | °C | - |
| Zone 1 | 250 - 270 | °C | - |
| Zone 2 | 270 - 290 | °C | - |
| Zone 3 | 270 - 290 | °C | - |
| Nozzle temperature | 270 - 290 | °C | - |
| Screw speed | 75 - 180 | rpm | - |
| Back pressure | 0.2 - 1 | MPa | - |

Characteristics

Processing

Injection Molding

Regional Availability

North America, Europe, Asia Pacific, South and Central America

Certifications

RoHS compliant