

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Mold Shrinkage, MD	<b>0.015</b>	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Yield stress	<b>70</b>	MPa	ISO 527
Stress at break	<b>60</b>	MPa	ISO 527
Strain at break	<b>30</b>	%	ISO 527
Flexural modulus, 23°C	<b>2300</b>	MPa	ISO 178
Charpy notched impact strength, +23°C	<b>7.5</b>	kJ/m <sup>2</sup>	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	<b>70</b>	°C	ISO 75-1/-2
Vicat softening temperature, B	<b>220</b>	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	<b>HB</b>	class	IEC 60695-11-10
Thickness tested	<b>1.6</b>	mm	-
Burning behav. at thickness h	<b>HB</b>	class	IEC 60695-11-10
Thickness tested	<b>3.2</b>	mm	-
Glow Wire Flammability Index (GWFI)	<b>650</b>	°C	IEC 60695-2-12
GWFI - thickness tested (1)	<b>2</b>	mm	-

Other properties	Value	Unit	Test Standard
Humidity absorption	<b>0.25</b>	%	Sim. to ISO 62
Density	<b>1110</b>	kg/m <sup>3</sup>	ISO 1183

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

## Characteristics

### Processing

Injection Molding

### Delivery form

Black

### Special Characteristics

High impact or impact modified, U.V. stabilized or stable to weather, Heat stabilized or stable to heat

### Certifications

Recycled Resin Content

### Regional Availability

Europe