

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	1.8	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Stress at break	65	MPa	ISO 527
Strain at break	35	%	ISO 527
Flexural modulus, 23°C	2400	MPa	ISO 178
Flexural strength	86.2	MPa	ISO 178
Charpy notched impact strength, +23°C	14.9	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	14.9	kJ/m ²	ISO 180/1A
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	54	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	155	°C	ISO 75-1/-2
Other properties			
Density	1110	kg/m ³	ISO 1183
Processing Recommendation Injection Molding			
Pre-drying - Temperature	82.2	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	232 - 271	°C	-
Mold temperature	21.1 - 93.3	°C	-
Zone 1	216	°C	-
Zone 2	227 - 254	°C	-
Zone 3	238 - 266	°C	-
Nozzle temperature	238 - 266	°C	-
Screw speed	40 - 80	rpm	-
Injection pressure	82.7 - 172	MPa	-
Back pressure	0 - 0.345	MPa	-

Characteristics

Processing

Injection Molding

Delivery form

Pellets, Black

Additives

Lubricants

Special Characteristics

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

Certifications

RoHS compliant

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa