

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|-------------------------------------|-------|------|-----------------|
| ISO Data | | | |
| Molding shrinkage, parallel | 0.3 | % | ISO 294-4, 2577 |
| Molding shrinkage, normal | 0.7 | % | ISO 294-4, 2577 |

| Mechanical properties | Value | Unit | Test Standard |
|---------------------------------------|-------|-------------------|---------------|
| ISO Data | | | |
| Tensile Modulus | 9500 | MPa | ISO 527 |
| Stress at break | 170 | MPa | ISO 527 |
| Strain at break | 3.5 | % | ISO 527 |
| Flexural modulus, 23°C | 9000 | MPa | ISO 178 |
| Charpy impact strength, +23°C | 60 | kJ/m ² | ISO 179/1eU |
| Charpy notched impact strength, +23°C | 8 | kJ/m ² | ISO 179/1eA |

| Thermal properties | Value | Unit | Test Standard |
|--|-------|--------|----------------------|
| ISO Data | | | |
| Temp. of deflection under load, 1.80 MPa | 230 | °C | ISO 75-1/-2 |
| Vicat softening temperature, B | 245 | °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 | 0.1 | % | Sim. to ISO 62 |
| Density | 1480 | kg/m ³ | 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