

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	6	g/10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	6	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.006	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2300	MPa	ISO 527
Yield stress	66	MPa	ISO 527
Stress at break	66	MPa	ISO 527
Strain at break	110	%	ISO 527
Flexural modulus, 23°C	2300	MPa	ISO 178
Flexural strength	93	MPa	ISO 178
Charpy notched impact strength, +23°C	80	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	85	kJ/m ²	ISO 180/1A
Rockwell hardness	R 120	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2300	MPa	ASTM D 638
Tensile Strength at Yield	65	MPa	ASTM D 638
Tensile Strength at Break	65	MPa	ASTM D 638
Elongation at Break	110	%	ASTM D 638
Flexural Modulus	2300	MPa	ASTM D 790
Flexural Strength	91	MPa	ASTM D 790
Rockwell Hardness	R 120	-	ASTM D 785
Izod Impact notched, 1/8 in	880	J/m	ASTM D 256
Izod Impact notched, 1/4 in	150	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	126	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	138	°C	ISO 75-1/-2
Vicat softening temperature, B	147	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	V-2	class	IEC 60695-11-10
Thickness tested	1.6	mm	-
Burning behav. at thickness h	V-2	class	IEC 60695-11-10
Thickness tested	2.0	mm	-
ASTM Data			
UL 94 Flame rating	V-2	-	UL 94
Thickness tested	1.6	mm	-
DTUL @ 66 psi	138	°C	ASTM D 648
DTUL @ 264 psi	128	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1200	kg/m ³	ISO 1183
Density	1200	kg/m ³	ASTM D 792

Processing Recommendation Extrusion	Value	Unit	Test Standard
Type of extrusion	sheet	-	-
Pre-drying - Temperature	120	°C	-

Pre-drying - Time	4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	290 - 300	°C	-
Mold temperature	80 - 120	°C	-
Zone 1	50 - 80	°C	-
Zone 2	250 - 270	°C	-
Zone 3	270 - 300	°C	-
Nozzle temperature	300	°C	-

Characteristics**Processing**

Sheet Extrusion

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color