

Product Texts

High Surface Hardness (Clear), Pencil Hardness 2H

Processing/Physical Characteristics

	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	26	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Melt flow index, MFI	27	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

Mechanical properties

	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2700	MPa	ISO 527
Yield stress	77	MPa	ISO 527
Yield strain	6	%	ISO 527
Strain at break	60	%	ISO 527
Flexural modulus, 23°C	2700	MPa	ISO 178
Flexural strength	107	MPa	ISO 178
Charpy impact strength, +23°C	130	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	3	kJ/m ²	ISO 179/1eA

Thermal properties

	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	100	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	113	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	65	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	67	E-6/K	ISO 11359-1/-2
Burning behav. at thickness h	V-2	class	IEC 60695-11-10
Thickness tested	0.4	mm	-
Yellow Card available	yes	-	-

Other properties

	Value	Unit	Test Standard
Water absorption	0.19	%	Sim. to ISO 62
Density	1160	kg/m ³	ISO 1183

Processing Recommendation Injection Molding

	Value	Unit	Test Standard
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	4 - 8	h	-
Mold temperature	60 - 100	°C	-
Zone 1	250 - 290	°C	-
Zone 2	250 - 290	°C	-
Zone 3	250 - 290	°C	-
Nozzle temperature	250 - 290	°C	-

Characteristics**Processing**

Injection Molding

Applications

General Purpose

Regional Availability

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