

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	12	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2350	MPa	ISO 527
Yield stress	66	MPa	ISO 527
Yield strain	6	%	ISO 527
Stress at break	70	MPa	ISO 527
Strain at break	120	%	ISO 527
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	N	kJ/m ²	ISO 179/1eU
Izod notched impact strength, +23°C	70 ^[1]	kJ/m ²	ISO 180/1A
Izod notched impact strength	15 ^[2]	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
Puncture - maximum force, +23°C	5400	N	ISO 6603-2
Puncture - maximum force, -30°C	6300	N	ISO 6603-2
Puncture energy, +23°C	60	J	ISO 6603-2
Puncture energy, -30°C	65	J	ISO 6603-2

1: 3 mm, partial break 2: 3 mm, complete break

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	122	°C	ISO 75-1/-2
Vicat softening temperature, B	142	°C	ISO 306

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	290	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	2 - 3	h	-
Processing humidity	≤0.02	%	-
Melt temperature	280 - 320	°C	-
Mold temperature	80 - 120	°C	-
Zone 1	250 - 260	°C	-
Zone 2	270 - 280	°C	-
Zone 3	280 - 290	°C	-
Nozzle temperature	290 - 300	°C	-
Back pressure	5 - 15	MPa	-

Characteristics

Processing

Injection Molding, Other Extrusion

Additives

Release agent

Special Characteristics

U.V. stabilized or stable to weather, Transparent

Regional Availability

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