

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	16	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2310	MPa	ISO 527
Yield stress	60	MPa	ISO 527
Yield strain	5.7	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Stress at break	55	MPa	ISO 527
Strain at break	100	%	ISO 527
Flexural modulus, 23°C	2320	MPa	ISO 178
Flexural strength	92	MPa	ISO 178
Charpy notched impact strength, +23°C	56	kJ/m ²	ISO 179/1eA
Type of failure	P	-	-
Charpy notched impact strength, -30°C	18	kJ/m ²	ISO 179/1eA
Type of failure	C	-	-
Izod notched impact strength, +23°C	56 ^[1]	kJ/m ²	ISO 180/1A
Izod notched impact strength	16 ^[1]	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
Puncture - maximum force, +23°C	5000	N	ISO 6603-2
Puncture energy, +23°C	51	J	ISO 6603-2

1: 3 mm

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	118	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	133	°C	ISO 75-1/-2
Vicat softening temperature, B	138	°C	ISO 306
Coeff. of linear therm. expansion, parallel	61	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	66	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
GWFI - thickness tested (1)	1.5	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
GWFI - thickness tested (2)	3	mm	-
Glow Wire Ignition Temperature (GWIT)	850	°C	IEC 60695-2-13
GWIT - thickness tested (1)	1.5	mm	-
Glow Wire Ignition Temperature (GWIT)	900	°C	IEC 60695-2-13
GWIT - thickness tested (2)	3	mm	-

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

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	300	°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

Additives

Release agent

Special Characteristics

Flame retardant, High impact or impact modified

Applications

Electrical and Electronical

Regional Availability

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