

Product Texts

- MVR (250 °C/2.16 kg) 17 cm³/10 min
- optical storage media
- suitable for all formats
- high purity

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	17	cm ³ /10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
^[C] Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.6	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2350	MPa	ISO 527
^[C] Yield stress	63	MPa	ISO 527
^[C] Yield strain	5.9	%	ISO 527
^[C] Nominal strain at break	>50	%	ISO 527
^[C] Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	N	kJ/m ²	ISO 179/1eU
^[C] Puncture - maximum force, +23°C	4700	N	ISO 6603-2
^[C] Puncture - maximum force, -30°C	5700	N	ISO 6603-2
^[C] Puncture energy, +23°C	50	J	ISO 6603-2
^[C] Puncture energy, -30°C	55	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Glass transition temperature, 10°C/min	145	°C	ISO 11357-1/-2
^[C] Temp. of deflection under load, 1.80 MPa	124	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	138	°C	ISO 75-1/-2
^[C] Vicat softening temperature, B	145	°C	ISO 306
^[C] Coeff. of linear therm. expansion, parallel	65	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	65	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at thickness h	V-2	class	IEC 60695-11-10
Thickness tested	0.7	mm	-
^[C] Oxygen index	28	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
ISO Data			
^[C] Comparative tracking index	225	-	IEC 60112

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Water absorption	0.3	%	Sim. to ISO 62
^[C] Humidity absorption	0.12	%	Sim. to ISO 62
^[C] Density	1190	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

[C]: CAMPUS

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	300 - 350	°C	-
Mold temperature	50 - 120	°C	-

Characteristics

Processing

Injection Molding

Special Characteristics

Transparent

Delivery form

Pellets

Regional Availability

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

Additives

Release agent

Other text information

Injection molding

PREPROCESSING

Max. Water content: 0.01 - 0.02 %

Drying temperature: 120 °C

Drying time:

Circulating air drying oven (50 % fresh air) 4-8 h

Fresh air dryer (high speed dryer) 2-4 h

Dry air dryer 2-3 h

PROCESSING

Melt temperature: 300-350 °C

Mold temperature: 50-60 (120) °C

Use open nozzle.