

Product Texts

- MVR (300 °C/1.2 kg) 34 cm³/10 min
- easy processing
- low viscosity
- easy release
- Vicat softening temperature 50 N, 50 °C/h = 110 °C
- LCD tv frame

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	34	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2700	MPa	ISO 527
^[C] Yield stress	75	MPa	ISO 527
^[C] Yield strain	5	%	ISO 527
^[C] Nominal strain at break	>50	%	ISO 527
^[C] Charpy impact strength, +23°C	220	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	N	kJ/m ²	ISO 179/1eU

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Vicat softening temperature, B	112	°C	ISO 306
^[C] Burning Behav. at thickness h	V-2	class	IEC 60695-11-10

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Density	1210	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	260	°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	90	°C	-
Pre-drying - Time	2 - 3	h	-
Processing humidity	≤0.02	%	-
Melt temperature	240 - 280	°C	-
Mold temperature	80 - 100	°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: 90 °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: 240-280 °C

Mold temperature: 80-100 °C

Use open nozzle.