

**Product Texts**

Medium viscosity standard grade for moulding parts of all kind.

Wheels, rollers applications, clips, fasteners, nuts and screws, bearings and clutch parts.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	9	g/10min	ISO 1133
Temperature	190	°C	-
Load	2.16	kg	-

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2800	MPa	ISO 527
Tensile Strength	62	MPa	ISO 527
Yield strain	10	%	ISO 527
Strain at break	50	%	ISO 527
Flexural strength	64	MPa	ISO 178
Charpy impact strength, +23°C	200	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	180	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	6	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	5.5	kJ/m <sup>2</sup>	ISO 179/1eA
Ball indentation hardness	145	MPa	ISO 2039-1

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	115	°C	ISO 75-1/-2
Vicat softening temperature, B	150	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.6	mm	-

Other properties	Value	Unit	Test Standard
Density	1410	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	2 - 3	h	-
Processing humidity	≤0.1	%	-
Mold temperature	60 - 120	°C	-
Feed temperature	150 - 170	°C	-
Zone 1	170 - 190	°C	-
Nozzle temperature	190 - 210	°C	-
Maximum residence time	20	min	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

Europe