

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	20	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	42	MPa	ISO 527
Stress at break	35	MPa	ISO 527
Strain at break	28	%	ISO 527
Flexural modulus, 23°C	2700	MPa	ISO 178
Izod notched impact strength, +23°C	9	kJ/m ²	ISO 180/1A
Izod notched impact strength	5	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	88	°C	ISO 75-1/-2
Vicat softening temperature, A	98	°C	ISO 306
Vicat softening temperature, B	92	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.6	mm	-
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.2	mm	-
Glow Wire Flammability Index (GWFI)	650	°C	IEC 60695-2-12
GWFI - thickness tested (1)	2	mm	-

Other properties	Value	Unit	Test Standard
Density	1050	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 90	°C	-
Pre-drying - Time	2 - 3	h	-
Processing humidity	≤0.1	%	-
Melt temperature	210 - 240	°C	-
Mold temperature	40 - 60	°C	-
Zone 1	205 - 215	°C	-
Zone 2	220 - 230	°C	-
Zone 3	230 - 240	°C	-
Nozzle temperature	230 - 235	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 1.5	MPa	-
Holding pressure	3 - 6	MPa	-

Characteristics

Processing
Injection Molding

Regional Availability
Europe

Applications
General Purpose