

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	16	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	40	MPa	ISO 527
Strain at break	25	%	ISO 527
Flexural modulus, 23°C	2500	MPa	ISO 178
Izod notched impact strength, +23°C	12	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	91	°C	ISO 75-1/-2
Vicat softening temperature, B	97	°C	ISO 306

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