

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	13	cm ³ /10min	ISO 1133
Temperature	260	°C	-
Load	2.16	kg	-
Mechanical properties			
ISO Data			
Tensile Modulus	2900	MPa	ISO 527
Stress at break	63	MPa	ISO 527
Strain at break	2.6	%	ISO 527
Charpy impact strength, +23°C	14	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	1.7	kJ/m ²	ISO 179/1eA
Thermal properties			
ISO Data			
Glass transition temperature, 10°C/min	142	°C	ISO 11357-1/-2
Temp. of deflection under load, 0.45 MPa	130	°C	ISO 75-1/-2
Optical properties			
ISO Data			
Luminous transmittance	91	%	ISO 13468-1, -2
Other properties			
Density	1020	kg/m ³	ISO 1183
Processing Recommendation Injection Molding			
Melt temperature	240 - 300	°C	-
Mold temperature	95 - 125	°C	-
Feed temperature	<100	°C	-
Zone 1	230 - 260	°C	-
Zone 2	240 - 270	°C	-
Zone 3	250 - 280	°C	-
Zone 4	260 - 290	°C	-
Nozzle temperature	240 - 300	°C	-
Screw speed	50 - 200	rpm	-
Injection speed	50 - 150	mm/s	-
Injection pressure	50 - 110	MPa	-
Back pressure	≤15	MPa	-
Holding pressure	30 - 60	MPa	-
Maximum residence time	<15	min	-

Characteristics

Processing

Injection Molding, Blow Molding

Special Characteristics

Heat stabilized or stable to heat, Transparent

Regional Availability

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