

**Product Texts**

Water-Heated Mold Injection Molding.

<b>Processing/Physical Characteristics</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Molding shrinkage, parallel	0.1 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577

<b>Mechanical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Tensile Modulus	8150 / 7100	MPa	ISO 527
Yield stress	140 / 120	MPa	ISO 527
Strain at break	2.2 / 3.9	%	ISO 527
Flexural modulus, 23°C	6700 / -	MPa	ISO 178
Flexural strength	200 / -	MPa	ISO 178
Charpy impact strength, +23°C	42 / 42	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	6.5 / 6.5	kJ/m <sup>2</sup>	ISO 179/1eA

<b>Thermal properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melting temperature, 10°C/min	260 / *	°C	ISO 11357-1/-3
Burning behav. at thickness h	HB / *	class	IEC 60695-11-10

<b>Other properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Water absorption	5.1 / *	%	Sim. to ISO 62
Density	1320	kg/m <sup>3</sup>	ASTM D 792

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4 - 12	h	-
Melt temperature	275 - 290	°C	-
Mold temperature	80 - 120	°C	-
Zone 1	250	°C	-
Zone 2	285	°C	-

**Characteristics**

**Processing**

Injection Molding

**Certifications**

Food contact, Food approval FDA 21 CFR, RoHS compliant

**Delivery form**

Pellets, Black

**Regional Availability**

North America, Europe, Asia Pacific

**Special Characteristics**

High impact or impact modified