

Product Texts

Water-Heated Mold Injection Molding.

Processing/Physical Characteristics**ISO Data**

	dry / cond	Unit	Test Standard
Molding shrinkage, parallel	0.1 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6 / *	%	ISO 294-4, 2577

Mechanical properties**ISO Data**

	dry / cond	Unit	Test Standard
Tensile Modulus	10900 / 9600	MPa	ISO 527
Yield stress	185 / 145	MPa	ISO 527
Strain at break	2.5 / 4	%	ISO 527
Flexural modulus, 23°C	9000 / -	MPa	ISO 178
Flexural strength	260 / -	MPa	ISO 178
Charpy impact strength, +23°C	60 / 60	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	9.2 / 9.2	kJ/m ²	ISO 179/1eA

Thermal properties**ISO Data**

	dry / cond	Unit	Test Standard
Melting temperature, 10°C/min	260 / *	°C	ISO 11357-1/-3
Burning behav. at thickness h	HB / *	class	IEC 60695-11-10
Glow Wire Flammability Index (GWFI)	675	°C	IEC 60695-2-12
GWFI - thickness tested (1)	0.8	mm	-
Glow Wire Flammability Index (GWFI)	675	°C	IEC 60695-2-12
GWFI - thickness tested (2)	1.5	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
GWFI - thickness tested (3)	3	mm	-
Glow Wire Ignition Temperature (GWIT)	700	°C	IEC 60695-2-13
GWIT - thickness tested (1)	0.8	mm	-
Glow Wire Ignition Temperature (GWIT)	700	°C	IEC 60695-2-13
GWIT - thickness tested (2)	1.5	mm	-
Glow Wire Ignition Temperature (GWIT)	775	°C	IEC 60695-2-13
GWIT - thickness tested (3)	3	mm	-

Other properties

	dry / cond	Unit	Test Standard
Water absorption	5.1 / *	%	Sim. to ISO 62
Density	1410	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding

	Value	Unit	Test Standard
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

Delivery form

Pellets, Black

Special Characteristics

High impact or impact modified

Certifications

Food contact, Food approval FDA 21 CFR, RoHS compliant

Regional Availability

North America, Europe, Asia Pacific