

Product Texts

Water-Heated Mold Injection Molding.

Processing/Physical Characteristics

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

Mechanical properties

	dry / cond	Unit	Test Standard
ISO Data			
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

	dry / cond	Unit	Test Standard
ISO Data			
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, Natural Color

Special Characteristics

High impact or impact modified

Certifications

Food contact, Food approval FDA 21 CFR, RoHS compliant

Regional Availability

North America, Europe, Asia Pacific