

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	8000	MPa	ISO 527
Stress at break	135	MPa	ISO 527
Strain at break	4.5	%	ISO 527
Flexural modulus, 23°C	6800	MPa	ISO 178
Charpy impact strength, +23°C	65	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	11	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	14	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	220	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	200	°C	ISO 75-1/-2
Vicat softening temperature, B	210	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.6	mm	-
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.2	mm	-
Burning rate, FMVSS, Thickness 1 mm	100	mm/min	ISO 3795 (FMVSS 302)
Glow Wire Flammability Index (GWFI)	650	°C	IEC 60695-2-12
GWFI - thickness tested (1)	2	mm	-

Other properties	Value	Unit	Test Standard
Humidity absorption	0.15	%	Sim. to ISO 62
Density	1310	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	75	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.12	%	-
Melt temperature	240 - 270	°C	-
Mold temperature	70 - 90	°C	-
Zone 1	220 - 230	°C	-
Zone 2	230 - 245	°C	-
Zone 3	250 - 260	°C	-
Nozzle temperature	250 - 260	°C	-
Screw speed	50 - 80	rpm	-
Back pressure	0.4 - 0.8	MPa	-
Holding pressure	6 - 8	MPa	-

Characteristics

Processing

Injection Molding

Certifications

Recycled Resin Content

Delivery form

Natural Color

Regional Availability

Europe

Special Characteristics

High impact or impact modified, U.V. stabilized or stable to weather, Heat stabilized or stable to heat