

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.4 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Stress at break	123 / 71.7	MPa	ISO 527
Strain at break	3 / 7	%	ISO 527
Flexural modulus, 23°C	6770 / 4200	MPa	ISO 178
Flexural strength	182 / 128	MPa	ISO 178
Charpy notched impact strength, +23°C	21 / 27.3	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	21 / 27.3	kJ/m ²	ISO 180/1A

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	204 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	211 / *	°C	ISO 75-1/-2

Other properties	dry / cond	Unit	Test Standard
Density	1340 / -	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	82.2	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	232 - 271	°C	-
Mold temperature	21.1 - 93.3	°C	-
Zone 1	216	°C	-
Zone 2	227 - 254	°C	-
Zone 3	238 - 266	°C	-
Nozzle temperature	238 - 266	°C	-
Screw speed	40 - 80	rpm	-
Injection pressure	82.7 - 172	MPa	-
Back pressure	0 - 0.345	MPa	-

Characteristics

Processing

Injection Molding

Delivery form

Pellets, Black

Additives

Lubricants

Special Characteristics

High impact or impact modified, Heat stabilized or stable to heat

Certifications

Recycled Resin Content, RoHS compliant

Regional Availability

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