

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Yield stress	90	MPa	ISO 527
Strain at break	4	%	ISO 527
Flexural modulus, 23°C	3900	MPa	ISO 178
Flexural strength	80	MPa	ISO 178
Izod notched impact strength, +23°C	7	kJ/m ²	ISO 180/1A
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	180	°C	ISO 75-1/-2
Vicat softening temperature, B	220	°C	ISO 306
Other properties			
Humidity absorption	0.15	%	Sim. to ISO 62
Density	1240	kg/m ³	ISO 1183
Processing Recommendation Injection Molding			
Pre-drying - Temperature	85	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.12	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	70 - 90	°C	-
Zone 1	250 - 260	°C	-
Zone 2	260 - 270	°C	-
Zone 3	280 - 290	°C	-
Nozzle temperature	280 - 285	°C	-
Screw speed	50 - 80	rpm	-
Back pressure	0.4 - 0.8	MPa	-
Holding pressure	6 - 8	MPa	-

Characteristics

Processing

Injection Molding

Features

Thermal Stability

Certifications

Recycled Resin Content

Regional Availability

Europe