

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.0125	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	50	MPa	ISO 527
Stress at break	45	MPa	ISO 527
Strain at break	20	%	ISO 527
Flexural modulus, 23°C	2400	MPa	ISO 178
Charpy notched impact strength, +23°C	6.5	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	6.5	kJ/m ²	ISO 180/1A
Izod notched impact strength Temperature	7 -23	kJ/m ² °C	ISO 180/1A -

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	50	°C	ISO 75-1/-2
Vicat softening temperature, B	190	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn. Thickness tested	HB 1.6	class mm	IEC 60695-11-10 -
Burning behav. at thickness h Thickness tested	HB 3.2	class mm	IEC 60695-11-10 -
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	0.25	%	Sim. to ISO 62
Density	1090	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

Delivery form

Natural Color

Special Characteristics

U.V. stabilized or stable to weather

Certifications

Recycled Resin Content

Regional Availability

Europe