

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.013	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Yield stress	77	MPa	ISO 527
Flexural modulus, 23°C	2500	MPa	ISO 178
Izod notched impact strength, +23°C	6	kJ/m ²	ISO 180/1A
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	75	°C	ISO 75-1/-2
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	-
Other properties			
Humidity absorption	3	%	Sim. to ISO 62
Density	1140	kg/m ³	ISO 1183
Processing Recommendation Injection Molding			
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

Regional Availability

Europe