

**HITHOR X 646 E21A**

PARA-CF30

MAIP SRL

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt flow index, MFI	<b>8</b>	g/10min	ISO 1133
Temperature	<b>275</b>	°C	-
Load	<b>5</b>	kg	-
Molding shrinkage, parallel	<b>0.7</b>	%	ISO 294-4, 2577
Molding shrinkage, normal	<b>0.2</b>	%	ISO 294-4, 2577

<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Stress at break	<b>210</b>	MPa	ISO 527
Strain at break	<b>7</b>	%	ISO 527
Flexural modulus, 23°C	<b>21500</b>	MPa	ISO 178
Flexural strength	<b>350</b>	MPa	ISO 178
Izod notched impact strength, +23°C	<b>9</b>	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	<b>R 129</b>	-	ISO 2039-2

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melting temperature, 10°C/min	<b>238</b>	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	<b>85</b>	°C	ISO 11357-1/-2
Temp. of deflection under load, 1.80 MPa	<b>230</b>	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	<b>235</b>	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	<b>15</b>	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	<b>45</b>	E-6/K	ISO 11359-1/-2
Burning behav. at thickness h	<b>HB</b>	class	IEC 60695-11-10
Burning rate, FMVSS, Thickness 1 mm	<b>100</b>	mm/min	ISO 3795 (FMVSS 302)

<b>Electrical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Volume resistivity	<b>10</b>	Ohm*m	IEC 62631-3-1
Surface resistivity	<b>100</b>	Ohm	IEC 62631-3-2

<b>Other properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1340</b>	kg/m <sup>3</sup>	ISO 1183

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>120</b>	°C	-
Pre-drying - Time	<b>2 - 6</b>	h	-
Processing humidity	<b>≤0.1</b>	%	-
Melt temperature	<b>260 - 290</b>	°C	-
Mold temperature	<b>130 - 150</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

Europe

**Special Characteristics**

Increased electrical conductivity, High impact or impact modified