

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	13	cm <sup>3</sup> /10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	10700	MPa	ISO 527
<sup>[C]</sup> Stress at break	145	MPa	ISO 527
<sup>[C]</sup> Strain at break	2.5	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	59	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	59	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	9.5	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	9	kJ/m <sup>2</sup>	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	209	°C	ISO 75-1/-2

[C]: CAMPUS

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
<sup>[C]</sup> Surface resistivity	>1E15	Ohm	IEC 62631-3-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
<sup>[C]</sup> Density	1670	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	121	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	235 - 255	°C	-
Mold temperature	65 - 93	°C	-

**Characteristics**

**Processing**

Injection Molding

**Additives**

Lubricants

**Delivery form**

Pellets

**Regional Availability**

Europe

**Other text information**

**Injection molding**

To avoid hydrolytic degradation during processing, CELANEX resins have to be dried to a moisture level equal to or less than 0.02%. Drying should be done in a dehumidifying hopper dryer capable of dewpoints <-30°F (-34°C) at 250°F (121°C) for 4 hours..

Rear Temperature 450-470(230-240) deg F (deg C)

Center Temperature 460-480(235-250) deg F (deg C)

Front Temperature 470-490(240-255) deg F (deg C)

Nozzle Temperature 480-490(250-255) deg F (deg C)  
Melt Temperature 460-490(235-255) deg F (deg C)  
Mold Temperature 150-200(65-93) deg F (deg C)  
Back Pressure 0-50 psi  
Screw Speed Medium  
Injection Speed Fast

Injection speed, injection pressure and holding pressure have to be optimized to the individual article geometry. To avoid material degradation during processing low back pressure and minimum screw speed have to be used. Overheating of the material has to be avoided, in particular for flame retardant grades. Up to 50% clean and dry regrind may be used for the '16 series' flame retardant grades.