

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	34	cm ³ /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2200	MPa	ISO 527
Yield stress	63	MPa	ISO 527
Yield strain	6	%	ISO 527
Nominal strain at break	>50	%	ISO 527
Stress at break	60	MPa	ISO 527
Strain at break	125	%	ISO 527
Charpy impact strength, -30°C	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C, 3mm	60	kJ/m ²	ISO 179/1eA
Type of failure	P	-	-
Charpy notched impact strength, -30°C, 3mm	15	kJ/m ²	ISO 179/1eA
Type of failure	C	-	-
Izod notched impact strength, +23°C	55 ⁽¹⁾	kJ/m ²	ISO 180/1A
Izod notched impact strength	13 ⁽¹⁾	kJ/m ²	ISO 180/1A
Temperature	-20	°C	-
Puncture - maximum force, +23°C	4900	N	ISO 6603-2
Puncture - maximum force, -30°C	5900	N	ISO 6603-2
Puncture energy, +23°C	50	J	ISO 6603-2
Puncture energy, -30°C	55	J	ISO 6603-2

1: 3 mm

Thermal properties	Value	Unit	Test Standard
ISO Data			
Glass transition temperature, 10°C/min	145	°C	ISO 11357-1/-2
Temp. of deflection under load, 1.80 MPa	125	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	138	°C	ISO 75-1/-2
Vicat softening temperature, B	145	°C	ISO 306
Coeff. of linear therm. expansion, parallel	67	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	67	E-6/K	ISO 11359-1/-2
Oxygen index	28	%	ISO 4589-1/-2

Optical properties	Value	Unit	Test Standard
ISO Data			
Haze	13 ⁽²⁾	-	ISO 14782
Luminous transmittance	85 ⁽²⁾	%	ISO 13468-1, -2

2: 4 mm

Other properties	Value	Unit	Test Standard
Water absorption	0.3	%	Sim. to ISO 62
Humidity absorption	0.12	%	Sim. to ISO 62
Density	1190	kg/m ³	ISO 1183
Bulk density	660	kg/m ³	-

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	2 - 3	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 300	°C	-
Mold temperature	80 - 120	°C	-
Zone 1	230 - 240	°C	-
Zone 2	250 - 260	°C	-
Zone 3	260 - 270	°C	-
Nozzle temperature	260 - 270	°C	-
Back pressure	5 - 15	MPa	-

Characteristics

Processing

Injection Molding

Delivery form

Pellets

Additives

Release agent

Special Characteristics

Transparent

Features

Light Guiding

Applications

Automotive

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa