

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	30	g/10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	45	MPa	ISO 527
Stress at break	35	MPa	ISO 527
Strain at break	28	%	ISO 527
Flexural modulus, 23°C	2300	MPa	ISO 178
Izod notched impact strength, +23°C	25	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	108	°C	ISO 75-1/-2
Vicat softening temperature, A	126	°C	ISO 306
Vicat softening temperature, B	120	°C	ISO 306
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	-
Glow Wire Flammability Index (GWFI)	650	°C	IEC 60695-2-12
GWFI - thickness tested (1)	2	mm	-

Other properties	Value	Unit	Test Standard
Density	1130	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	230 - 260	°C	-
Mold temperature	50 - 80	°C	-
Zone 1	225 - 240	°C	-
Zone 2	250 - 265	°C	-
Zone 3	260 - 270	°C	-
Nozzle temperature	250 - 270	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.3 - 1.5	MPa	-
Holding pressure	3 - 7	MPa	-

Characteristics

Processing

Injection Molding

Regional Availability

Europe

Applications

General Purpose