

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	4	g/10min	ISO 1133
Temperature	230	°C	-
Load	3.8	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Stress at break	38	MPa	ISO 527
Strain at break	>50	%	ISO 527
Flexural modulus, 23°C	1400	MPa	ISO 178
Charpy notched impact strength, +23°C	5.6	kJ/m ²	ISO 179/1eA
Rockwell hardness	M 100	-	ISO 2039-2
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	85	°C	ISO 75-1/-2
Vicat softening temperature, B	96	°C	ISO 306
Electrical properties			
ISO Data			
Relative permittivity, 1MHz	3.1	-	IEC 62631-2-1
Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Electric strength	20	kV/mm	IEC 60243-1
Optical properties			
ISO Data			
Haze	1.1	-	ISO 14782
Luminous transmittance	91	%	ISO 13468-1, -2
Other properties			
Water absorption	0.4	%	Sim. to ISO 62
Density	1150	kg/m ³	ISO 1183
Processing Recommendation Injection Molding			
Pre-drying - Temperature	75 - 80	°C	-
Pre-drying - Time	4 - 6	h	-
Mold temperature	60 - 80	°C	-
Zone 1	215 - 220	°C	-
Zone 2	220 - 240	°C	-
Zone 3	225 - 245	°C	-
Screw speed	40 - 60	rpm	-
Injection pressure	40 - 160	MPa	-
Back pressure	0.9 - 1.4	MPa	-
Holding pressure	20 - 80	MPa	-

Characteristics

Processing

Injection Molding

Special Characteristics

High impact or impact modified, U.V. stabilized or stable to weather, Transparent

Chemical Resistance

Alkali Resistance, General Chemical Resistance, Oil Resistance

Regional Availability

North America, Europe, Asia Pacific

Features

Light Diffusing