

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	18	cm <sup>3</sup> /10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
<sup>[C]</sup> Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
<sup>[C]</sup> Density of melt	1010	kg/m <sup>3</sup>	-
<sup>[C]</sup> Spec. heat capacity of melt	2280	J/(kg K)	-
<sup>[C]</sup> Eff. thermal diffusivity	1E-7	m <sup>2</sup> /s	-
<sup>[C]</sup> Ejection temperature	110	°C	-

[C]: CAMPUS

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	2100	MPa	ISO 527
<sup>[C]</sup> Yield stress	55	MPa	ISO 527
<sup>[C]</sup> Yield strain	5	%	ISO 527
<sup>[C]</sup> Nominal strain at break	>50	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	50	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	40	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Puncture energy, +23°C	40	J	ISO 6603-2
<sup>[C]</sup> Puncture energy, -30°C	40	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	111	°C	ISO 75-1/-2
<sup>[C]</sup> Vicat softening temperature, B	132	°C	ISO 306
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	70	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	70	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
<sup>[C]</sup> Water absorption	0.5	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	0.2	%	Sim. to ISO 62
<sup>[C]</sup> Density	1140	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.03	%	-
Melt temperature	240 - 270	°C	-
Mold temperature	50 - 80	°C	-
Zone 1	230 - 250	°C	-
Zone 2	235 - 255	°C	-
Zone 3	240 - 260	°C	-
Nozzle temperature	230 - 250	°C	-

**Characteristics****Processing**

Injection Molding

**Additives**

Release agent

**Delivery form**

Pellets

**Regional Availability**

Europe

**Other text information****Injection molding**[Injection Molding Recommendations](#)