

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	1.5	cm ³ /10min	ISO 1133
Temperature	200	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	1.5	g/10min	ASTM D 1238
Temperature	200	°C	-
Load	5	kg	-
Mechanical properties			
ISO Data			
Yield stress	67	MPa	ISO 527
Flexural modulus, 23°C	2500	MPa	ISO 178
Flexural strength	90	MPa	ISO 178
Charpy notched impact strength, +23°C	2	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	2	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	3	kJ/m ²	ISO 180/1A
Izod notched impact strength	2.7	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
ASTM Data			
Tensile Strength at Break	67.4	MPa	ASTM D 638
Flexural Modulus	3034	MPa	ASTM D 790
Flexural Strength	97.9	MPa	ASTM D 790
Rockwell Hardness	M 85	-	ASTM D 785
Izod Impact notched, 1/8 in	19.8	J/m	ASTM D 256
Izod Impact notched, 1/4 in	17.6	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	82	°C	ISO 75-1/-2
Vicat softening temperature, A	106	°C	ISO 306
Vicat softening temperature, B	101	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.59	mm	-
Vicat Temperature	106	°C	ASTM D 1525
Optical properties			
ASTM Data			
Light Transmittance	91.5	%	ASTM D 1003
Other properties			
Density	1120	kg/m ³	ISO 1183
Density	1120	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	70 - 80	°C	-
Pre-drying - Time	3 - 4	h	-
Mold temperature	40 - 70	°C	-
Feed temperature	180 - 230	°C	-
Zone 1	200 - 240	°C	-
Nozzle temperature	210 - 240	°C	-
Injection pressure	5 - 7	MPa	-
Back pressure	0.5 - 1.5	MPa	-

Holding pressure

4 - 6

MPa

-

Characteristics**Processing**

Injection Molding, Other Extrusion

Special Characteristics

Transparent

Certifications

Food contact, RoHS compliant

Applications

Building Construction, Electrical and Electronical, General Purpose, Packaging, Toys

Regional Availability

Asia Pacific