

| Processing/Physical Characteristics                | Value     | Unit              | Test Standard   |
|--|-----------|-------------------|-----------------|
| <b>ISO Data</b>                                    |           |                   |                 |
| Melt flow index, MFI                               | 1.8       | g/10min           | ISO 1133        |
| Temperature  | 200       | °C                | -               |
| Load   | 5         | kg                | -               |
| Molding shrinkage, parallel                        | 0.4       | %                 | ISO 294-4, 2577 |
| <b>Mechanical properties</b>                       |           |                   |                 |
| <b>ISO Data</b>                                    |           |                   |                 |
| Stress at break                                    | 67        | MPa               | ISO 527         |
| Flexural modulus, 23°C                             | 3400      | MPa               | ISO 178         |
| Flexural strength                                  | 115       | MPa               | ISO 178         |
| Charpy notched impact strength, +23°C              | 2         | kJ/m <sup>2</sup> | ISO 179/1eA     |
| Rockwell hardness                                  | M 84      | -                 | ISO 2039-2      |
| <b>Thermal properties</b>                          |           |                   |                 |
| <b>ISO Data</b>                                    |           |                   |                 |
| Temp. of deflection under load, 1.80 MPa           | 79        | °C                | ISO 75-1/-2     |
| Vicat softening temperature, B                     | 100       | °C                | ISO 306         |
| Burning behav. at thickness h                      | HB        | class             | IEC 60695-11-10 |
| Yellow Card available                              | yes       | -                 | -               |
| <b>Optical properties</b>                          |           |                   |                 |
| <b>ISO Data</b>                                    |           |                   |                 |
| Haze   | 0.2       | -                 | ISO 14782       |
| Luminous transmittance                             | 92        | %                 | ISO 13468-1, -2 |
| <b>ASTM Data</b>                                   |           |                   |                 |
| Index of Refraction                                | 1.54      | -                 | ASTM D 542      |
| <b>Other properties</b>                            |           |                   |                 |
| Density  | 1130      | kg/m <sup>3</sup> | ISO 1183        |
| Water Absorption, 24hr                             | 0.12      | %                 | ASTM D 570      |
| <b>Processing Recommendation Injection Molding</b> |           |                   |                 |
| Pre-drying - Temperature                           | 70 - 80   | °C                | -               |
| Pre-drying - Time                                  | 3 - 4     | h                 | -               |
| Mold temperature                                   | 40 - 70   | °C                | -               |
| Zone 1   | 190 - 240 | °C                | -               |
| Nozzle temperature                                 | 220 - 240 | °C                | -               |

## Characteristics

### Processing

Injection Molding

### Regional Availability

North America, Europe, Asia Pacific