

General Information
General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.09	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	24	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	37.0	MPa	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	170	J/m	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	89.0	°C	ISO 306/B50

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	80	°C
Hot Air Dryer	80	°C
Drying Time		
Desiccant Dryer	2.0 to 4.0	hr
Hot Air Dryer	4.0 to 6.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	180 to 190	°C
Middle Temperature	200 to 210	°C
Front Temperature	220 to 230	°C
Nozzle Temperature	230	°C
Mold Temperature	50 to 70	°C
Injection Pressure	49.0 to 196	MPa
Back Pressure	0.490 to 1.96	MPa
Screw Speed	50 to 150	rpm

Injection Notes

Hot Runner Temperature: 220°C

Notes
¹ Typical properties: these are not to be construed as specifications.

² 5.0 mm/min