

Easy-flow, general purpose injection moulding grade with high resistance to impact and heat distortion; intended for a wide range of applications, particularly in the housings sector.

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	19	cm ³ /10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2300	MPa	ISO 527
Yield stress	45	MPa	ISO 527
Yield strain	2.6	%	ISO 527
Nominal strain at break	10	%	ISO 527
Impact Strength (Charpy), +23°C	180	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C	100	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	22	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	8	kJ/m ²	ISO 179/1eA

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	94	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	99	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	96	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	95	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB	class	UL 94
Thickness tested	1.5	mm	-
UL recognition	yes	-	-
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	0.8	mm	-

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	2.9	-	IEC 62631-2-1
Relative permittivity, 1MHz	2.8	-	IEC 62631-2-1
Dissipation Factor, 100Hz	48	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	79	E-4	IEC 62631-2-1
Volume Resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	1E13	Ohm	IEC 62631-3-2
Electric Strength	41	kV/mm	IEC 60243-1
Comparative tracking index	600	-	IEC 60112

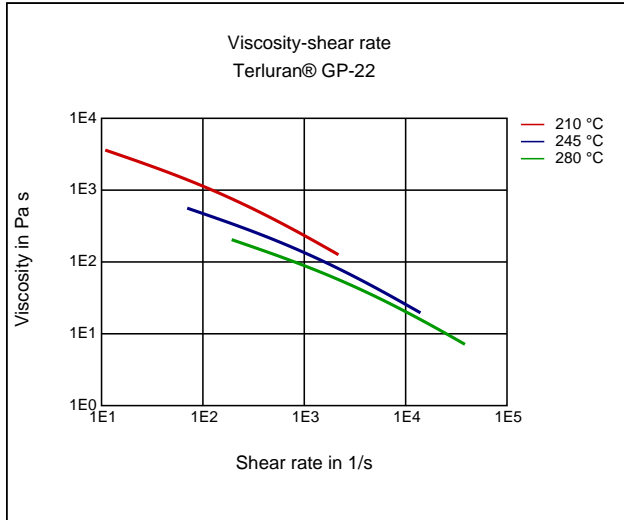
Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	1	%	Sim. to ISO 62
Humidity absorption	0.22	%	Sim. to ISO 62
Density	1040	kg/m ³	ISO 1183

Rheological calculation properties	Value	Unit	Test Standard
ISO Data			
Density of melt	930	kg/m ³	-
Thermal Conductivity of Melt	0.16	W/(m K)	-
Spec. heat capacity of melt	2400	J/(kg K)	-
Ejection temperature	93	°C	-

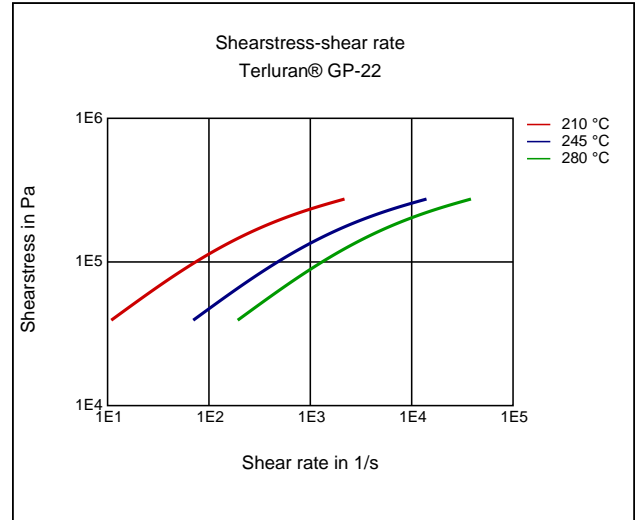
Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	250	°C	ISO 294
Injection Molding, mold temperature	60	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

Diagrams

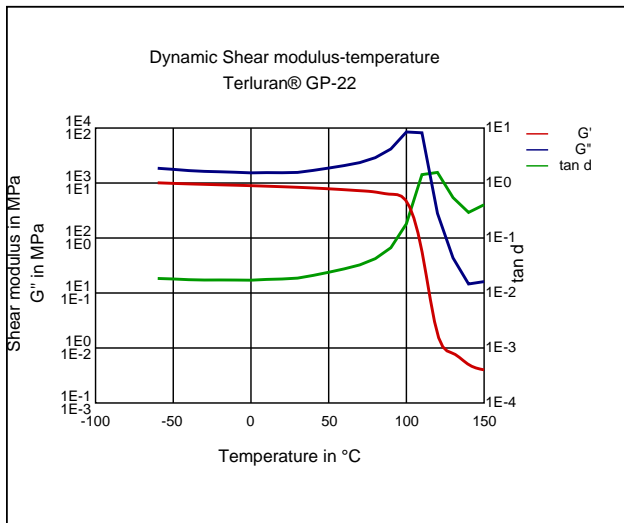
Viscosity-shear rate



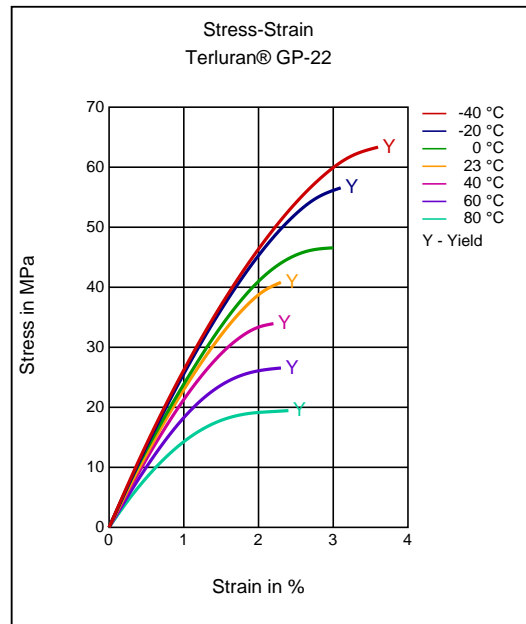
Shearstress-shear rate



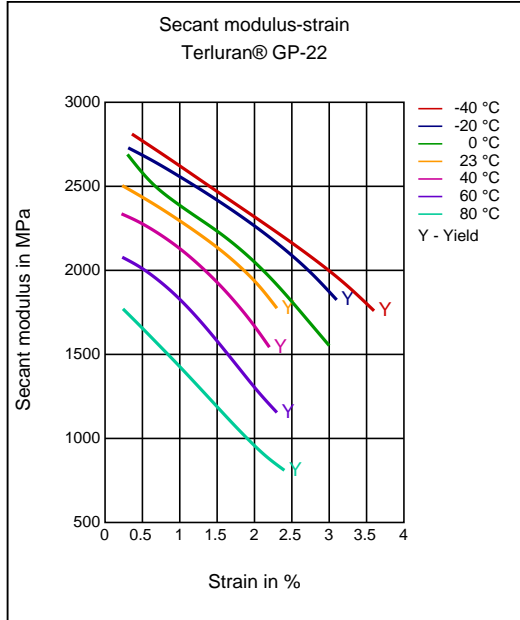
Dynamic Shear modulus-temperature



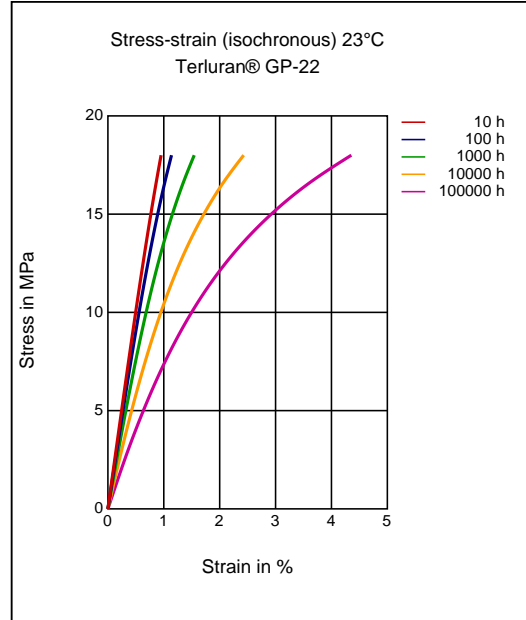
Stress-strain



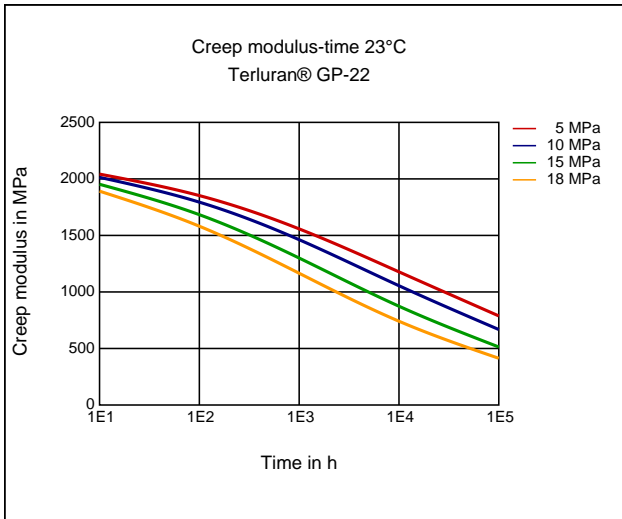
Secant modulus-strain



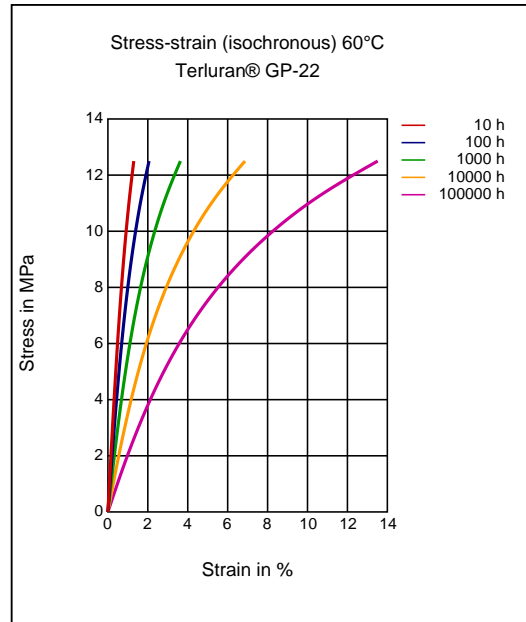
Stress-strain (isochronous) 23 °C



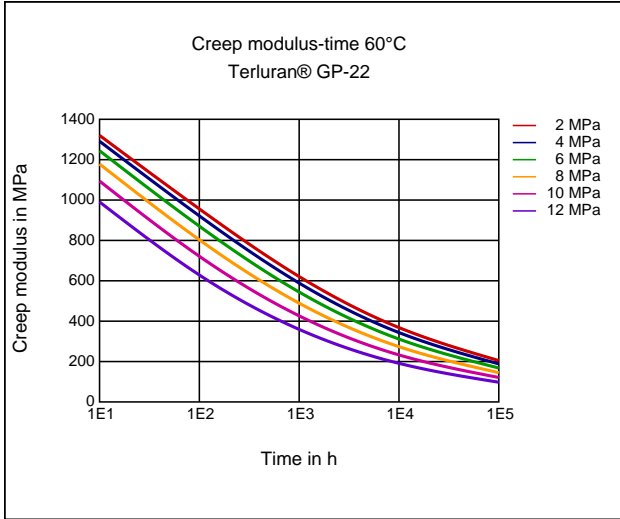
Creep modulus-time 23 °C



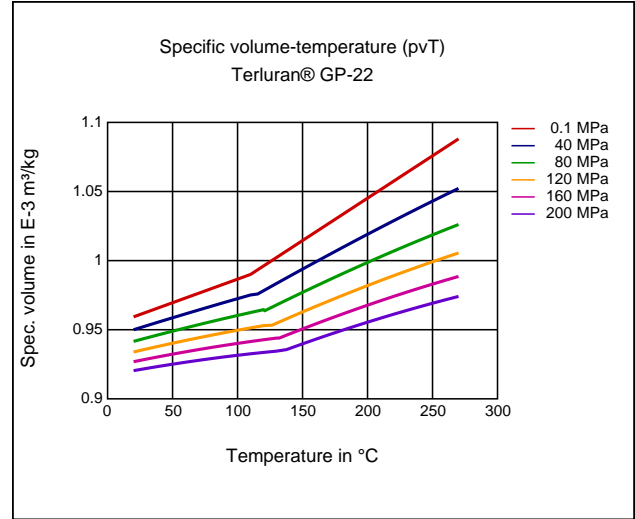
Stress-strain (isochronous) 60 °C



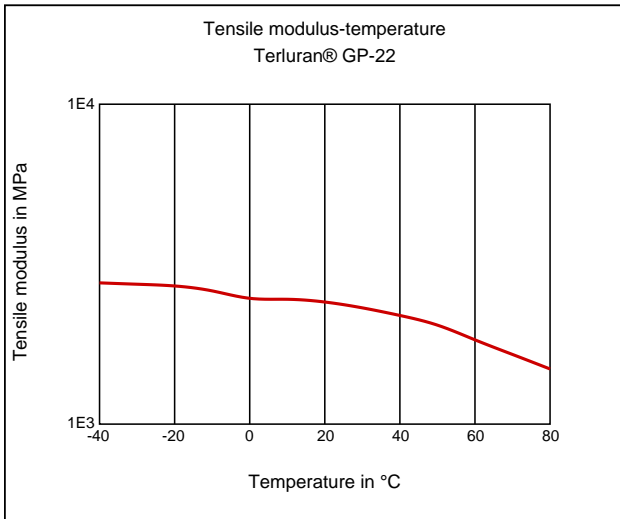
Creep modulus-time 60 °C



Specific volume-temperature (pvT)



Tensile Modulus-Temperature



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Special Characteristics

Platable

Injection Molding

PREPROCESSING

Pre/Post-processing, Pre-drying, Temperature: 80 °C

Pre/Post-processing, Pre-drying, Time: 2 - 4 h

PROCESSING

injection molding, Melt temperature, range: 220 - 260 °C

injection molding, Melt temperature, recommended: 250 °C

injection molding, Mold temperature, range: 30 - 60 °C

injection molding, Mold temperature, recommended: 50 °C

Disclaimer

Liability Exclusion

These guide values are measured and provided by the product manufacturer and have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions. M-Base has taken the guide values from the producer's original Technical Data Sheet. **ALBIS AND M-BASE ARE THEREFORE NOT RESPONSIBLE FOR THE ACCURACY OF THE GUIDE VALUES AND CANNOT GIVE ANY WARRANTY WITH REGARD TO THEIR CORRECTNESS.**

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