

Features: Food approved High gloss

Fillers: Mineral mix

Feature	Value	Unit	Testmethod
PHYSICAL PROPERTIES			
Density	1,18	g/cm ³	ISO 1183
MFI at 230°C/2,16kg	30	g/10min	ISO 1133
MECHANICAL PROPERTIES			
Flexural modulus at +23°C	2300	MPa	ISO 178
Maximum flexural strength	47	MPa	ISO 178
Maximum tensile strength	24	MPa	ISO 527-2
Elongation at break	18	%	ISO 527-2
Elongation at yield	8	%	ISO 527-2
IMPACT PROPERTIES			
Impact strength	--	--	--
Notched Charpy at +23°C	3	kJ/m ²	ISO 179
Notched Charpy at -20°C	2	kJ/m ²	ISO 179
Unnotched Charpy at +23°C	29	kJ/m ²	ISO 179
Unnotched Charpy at -20°C	12	kJ/m ²	ISO 179
THERMAL PROPERTIES			
Heat Distortion Temperature	--	--	--
HDT 120°C/h at 455kPa (B)	120	°C	ISO 75/1
HDT 120°C/h at 1820kPa (A)	61	°C	ISO 75/1
Softening temperature	--	--	--
Vicat 50°C/h at 9,81N (A)	152	°C	ISO 306
Vicat 50°C/h at 49,05N (B)	96	°C	ISO 306
FLAMMABILITY PROPERTIES			
Flammability	--	--	--
GWFI at 2 mm	750	°C	IEC 60695-2-12
UL94 at 1.6 mm	HB	--	UL94
ADDITIONAL INFORMATION			
Filler content	30	±2%	ISO 3451
Mould shrinkage (with flow)	1,1-1,3	%	Polykemi
Mould shrinkage (across flow)	1,1-1,3	%	Polykemi
PROCESS INSTRUCTIONS			
Drying time	2-4	h	--
Drying temperature	70-80	°C	--
Melt temperature	205-260	°C	--
Mould temperature	40-80	°C	--
Peripheral screw speed	600-750	mm/s	--
Back pressure	60-100	bar	--

Further material information is available upon request

Stated values in this datasheet are approximate. The values originate, if nothing else is stated, from standardized test specimens in natural color. All information, recommendations and advice, written or verbal, given by an individual company within, or agent affiliated with, The Polykemi Group are according to our knowledge to the date of this edition, correct and given in good faith. It is the responsibility of the customer to test and evaluate if the material suits the application and the environment in which it is intended to be used. Companies within, or agent affiliated with, The Polykemi Group can not be held responsible or liable for any loss incurred through incorrect or faulty use of the products. When producing details in flame retardant material, corrosion protected steel is to recommend for the mould.

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