

Features: Heat stabilized High density

Fillers: Filler mix Glass fiber Mineral

Feature	Value	Unit	Testmethod
PHYSICAL PROPERTIES			
Density	1,84	g/cm ³	ISO 1183
MFI at 230°C/2,16kg	5	g/10min	ISO 1133
MECHANICAL PROPERTIES			
Flexural modulus at +23°C	5000	MPa	ISO 178
Maximum flexural strength	55	MPa	ISO 178
Tensile modulus at +23°C	5500	MPa	ISO 527-2
Maximum tensile strength	28	MPa	ISO 527-2
Elongation at break	2,2	%	ISO 527-2
Elongation at yield	2,0	%	ISO 527-2
IMPACT PROPERTIES			
Impact strength	--	--	--
Notched Charpy at +23°C	6	kJ/m ²	ISO 179
Notched Charpy at -20°C	5	kJ/m ²	ISO 179
Unnotched Charpy at +23°C	22	kJ/m ²	ISO 179
Unnotched Charpy at -20°C	22	kJ/m ²	ISO 179
Izod notched at +23°C	5	kJ/m ²	ISO 180/4A
THERMAL PROPERTIES			
Heat Distortion Temperature	--	--	--
HDT 120°C/h at 455kPa (B)	147	°C	ISO 75/1
HDT 120°C/h at 1820kPa (A)	105	°C	ISO 75/1
Softening temperature	--	--	--
Vicat 50°C/h at 9,81N (A)	155	°C	ISO 306
Vicat 50°C/h at 49,05N (B)	98	°C	ISO 306
Heat aging at 150°C, passes	336	hours	Polykemi
FLAMMABILITY PROPERTIES			
Flammability	--	--	--
GWFI at 2 mm	750	°C	IEC 60695-2-12
UL94 at 1.6 mm	HB	--	UL94
ADDITIONAL INFORMATION			
Filler content	65	±2%	ISO 3451
Mould shrinkage (with flow)	0,3-0,5	%	Polykemi
Mould shrinkage (across flow)	0,4-0,7	%	Polykemi
Coefficient of linear thermal expansion (CLTE)	55-65	10E-6/°C	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.

Visiting address
Bronsgatan 8
SE-271 39 YSTAD

+46 (0)411 170 30
polykemi@polykemi.se
www.polykemi.com

THE POLYKEMI GROUP
polykemi 
rondo scanfill 