

## LNPTM COLORCOMPTM COMPOUND D10008PM

## **DESCRIPTION**

LNP COLORCOMP D10008PM is a special color compound based on UV stabilized Polycarbonate resin containing mold release with a MVR of 26.

GENERAL INFORMATION	
Features	Good Processability, High Flow, Amorphous, Aesthetics/Visual effects, Weatherable/UV stable
Fillers	Unreinforced
Polymer Types	Polycarbonate (PC)
Processing Techniques	Injection Molding
Regional Availability	Europe

INDUSTRY	SUB INDUSTRY
Automotive	Automotive Lighting
Building and Construction	Outdoor, Lawn and Landscape, Construction
Consumer	Personal Recreation
Electrical and Electronics	Electrical Devices and Displays, Lighting, Electrical Components and Infrastructure
Industrial	Electronic Material
Mass Transportation	Specialty Vehicles

## **TYPICAL PROPERTY VALUES**

Revision 20240731

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL (1)			
Tensile Stress, yield, 50 mm/min	63	MPa	ISO 527
Tensile Stress, break, 50 mm/min	50	MPa	ISO 527
Tensile Strain, yield, 50 mm/min	6	%	ISO 527
Tensile Strain, break, 50 mm/min	70	%	ISO 527
Tensile Modulus, 1 mm/min	2350	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	2300	MPa	ISO 178
Tensile Stress, yld, Type I, 50 mm/min	62	MPa	ASTM D638
Tensile Stress, brk, Type I, 50 mm/min	65	MPa	ASTM D638
Tensile Strain, yld, Type I, 50 mm/min	6	%	ASTM D638
Tensile Strain, brk, Type I, 50 mm/min	110	%	ASTM D638
Tensile Modulus, 5 mm/min	2370	MPa	ASTM D638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	93	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D790
IMPACT (1)			
Izod Impact, unnotched 80*10*3 +23°C	NB	kJ/m²	ISO 180/1U
Izod Impact, unnotched 80*10*3 -30°C	NB	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*3 +23°C	60	kJ/m²	ISO 180/1A
Izod Impact, notched 80*10*3 -30°C	11	kJ/m²	ISO 180/1A



Charpy 23°C, Vnotcht Edgew 80°10°3 sp=62mm         60         M/m²         ISO 179/1cA           Charpy, 30°C, Vnotcht Edgew 80°10°3 sp=62mm         12         M/m²         ISO 179/1cA           Charpy, 30°C, Unnotch Edgew 80°10°3 sp=62mm         N8         M/m²         ISO 179/1cU           Lozd Impact, notched, 23°C         640         J/m         ASTM D256           Tensile impact Strength, 1ype 5         378         M/m²         ASTM D1822           Instrumented Dart Impact Energy @ peak, 23°C         54         M/m²         ASTM D3763           TEREMAL 1°**         ************************************	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Charpy 23°C, Unnotch Edgew 80°10°3 sp=62mm         NB         I/Im²         SO 179/1eU           Charpy 30°C, Unnotch Edgew 80°10°3 sp=62mm         NB         kJ/m²         SO 179/1eU           Ized Impact, notched, 23°C         640         I/Im         ASTM D256           Instrumented Dart Impact Energy@peak, 23°C         54         I         ASTM D1376           THERMALI <sup>10</sup> "         M/m²°C         ISO 8302           THERMALI <sup>10</sup> "         ISO 8002         SO 8302           ETE, 23°C to 80°C, flow         7.6-05         I/°C         ISO 306           Ball Pressure Test, 125°C *J - 2°C         PASSES         -         IEC 60695-10-2           Vicat Softening Temp, Rate 8/50         145         °C         ISO 306           Vicat Softening Temp, Rate 8/120         140         °C         ISO 306           Vicat Softening Temp, Rate 8/120         140         °C         ISO 306           PUTJ (Re. 0.45MPa Edgew 120°10°4 sp=100mm         133         °C         ISO 75/ke           HDT/ (Ae. 1.8 MPa Edgew 120°10°4 sp=100mm         121         °C         ASTM IES31           CET40°C to 40°C, flow         8.840 to 11         1/°C         ASTM IES31           CET40°C to 40°C, flow         0.840 to 11         SO 62.1 <td>Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm</td> <td>60</td> <td>kJ/m²</td> <td>ISO 179/1eA</td>	Charpy 23°C, V-notch Edgew 80*10*3 sp=62mm	60	kJ/m²	ISO 179/1eA
Charpy-30°C, Unnotch Edgew 80°10°3 sp=62mm         NB         kJ/m²         ISO 179/1eU           Izod Impact, notched, 23°C         640         J/m         ASTM D256           Tensile Impact Strength, Type S         38         kJ/m²         ASTM D256           Instrumented Dart Impact Energy@peak, 23°C         32         J         ASTM D3763           THERMAL.************************************	Charpy -30°C, V-notch Edgew 80*10*3 sp=62mm	12	kJ/m²	ISO 179/1eA
Ize of impact, notched, 23°C         640         I/m         ASTM D256           Tensile impact Strength, Type S         378         kJ/m²         ASTM D1822           Instrumented Dart Impact Energy @ peak, 23°C         54         J °C         ASTM D3763           THERMAL II         THERMAL II         SO 8302           TERMAL TO MINITED TO THE MI	Charpy 23°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m²	ISO 179/1eU
Tensile Impact Strength, Type S         378         ki/m²         ASTM D1822           Instrumented Dart Impact Energy @ peak, 23°C         54         J         ASTM D3763           THERMAL. III           THERMAL. III           The main Conductivity         0.2         W/m²C         ISO 802           CTE, 23°C to 80°C, flow         7.EOS         1/°C         ISO 1359-2           Ball Pressure Test, 125°C+/-2°C         PASSES         - C         ISO 306           Vicat Softening Temp, Rate B/50         145         °C         ISO 306           Vicat Softening Temp, Rate B/120         140         °C         ISO 306           HDT/JRe, 0.45MPa Edgew 120°10°4 sp=100mm         133         °C         ISO 506           HDT/JRe, 1.84MPa Edgew 120°10°4 sp=100mm         21         °C         ASTM D68           HDT, 1.82 MPa, 6.4 mm, unannealed         126         °C         ASTM D68           CEC. 40°C to 40°C, flow         7.EOS         1/°C         ASTM D68           CED. 40°C to 40°C, flow         5.DO         X         X           PHYSICAL           Design         1.2         X         X         X           Desinity         5.DO         X         X<	Charpy -30°C, Unnotch Edgew 80*10*3 sp=62mm	NB	kJ/m²	ISO 179/1eU
Internmented Dart Impact Energy@peak, 23°C         54         J         ATM D3763           THERMAL."           Thermal Conductivity         0.2         W/m°C         ISO 8302           CTE, 23°C to 80°C, flow         7.E-05         1/°C         ISD 1359-2           Ball Pressure Test, 125°C +/- 2°C         PMSES         6         ISO 306           Vicat Softening Temp, Rate A/50         145         °C         ISO 306           Vicat Softening Temp, Rate B/50         139         °C         ISO 306           Vicat Softening Temp, Rate B/120         140         °C         ISO 306           HDT/Be, 0.45MPa Edgew 120°10°4 sp=100mm         133         °C         ISO 75/Be           HDT/Be, 0.45MPa Edgew 120°10°4 sp=100mm         121         °C         ASTM D648           HDT, 1.82 MPa, 6.4 mm, unannealed         126         °C         ASTM D648           CTE, -40°C to 40°C, flow         5.84-05         1/°C         ASTM E831           CTE, -40°C to 40°C, flow         5.5 -0.7         \$         ASIM E831           PMYSICAL I'         1.2         SO 50.2         ISO 50.2           Wold Shrinkage on Tensile Bar, flow         0.5 -0.7         \$         SO 50.2           Moliture Absorption, (23°C/ sow Rri)	Izod Impact, notched, 23°C	640	J/m	ASTM D256
THERMAL. <sup>11</sup> Thermal Conductivity         0.2         W/m.°C         ISO 8302           CTE, 23°C to 80°C, flow         7.605         1/°C         ISO 11359-2           Ball Pressure Test, 125°C + /- 2°C         PASSES         -         IEC 60095-10-2           Vicat Softening Temp, Rate A/50         145         °C         ISO 306           Vicat Softening Temp, Rate B/50         139         °C         ISO 306           Vicat Softening Temp, Rate B/120         140         °C         ISO 306           HDT/Be, 0.45MPa Edgew 120°10°4 sp=100mm         133         °C         ISO 75/Be           HDT/, 1.82 MPa, 6.4 mm, unannealed         121         °C         ASTM 6831           CTE, -40°C to 40°C, flow         7.605         1/°C         ASTM 6831           CTE, -40°C to 40°C, flow         8.84°C5         1/°C         ASTM 6831           CTE, -40°C to 40°C, flow         1.2         3/°C         ISO 1183           PHYSICAL ''         1.2         3/°C         ASTM 6831           Water Absorption, (23°C/ saturated)         0.5 - 0.7         \$         SABC method           Moisture Absorption (23°C/ saturated)         0.15         \$         SAIC method           Melt Volume Rate, MVR at 300°C/1.2 kg         2         ASTM 0792	Tensile Impact Strength, Type S	378	kJ/m²	ASTM D1822
Thermal Conductivity         0.2         W/m°C         ISO 8302           CTE, 23°C to 80°C, flow         7.605         1/°C         ISO 11359-2           Ball Pressure Test, 125°C +/- 2°C         PASSES         -         IEC 60095-10-2           Vicat Softening Temp, Rate A/50         145         °C         ISO 306           Vicat Softening Temp, Rate B/120         140         °C         ISO 306           HDT/ Jee, 0.45MPa Edgew 120°10°4 sp=100mm         133         °C         ISO 75/Be           HDT/ Jee, 1.8 MPa Edgew 120°10°4 sp=100mm         121         °C         ASTM 668           HDT, 1.8.2 MPa, 6.4 mm, unannealed         126         °C         ASTM 6881           CTE, -40°C to 40°C, flow         7.60         ASTM 6881           CTE, -40°C to 40°C, flow         8.84c5         1/°C         ASTM 6881           CTE, 40°C to 40°C, flow         0.5 - 0.7         \$         ASTM 6881           Water Absorption, (23°C/saturated)         0.55         \$         So 62           Moisture Absorption, (23°C/saturated)         0.5         γ         So 62           Melt Volume Rate, MVR at 300°C/1.2 kg         26         cm³/10 min         So 1133           Specific Gravity         1.2         γ         ASTM D123	Instrumented Dart Impact Energy @ peak, 23°C	54	J	ASTM D3763
CTE, 23°C to 80°C, flow         7.EO5         1/°C         ISO 11359-2           Ball Pressure Test, 125°C +/- 2°C         PASSES         -         IEC 60695-10-2           Vicat Softening Temp, Rate A/50         145         *C         ISO 306           Vicat Softening Temp, Rate B/50         139         *C         ISO 306           Vicat Softening Temp, Rate B/120         140         *C         ISO 75/Be           HDT/Jee, 0.45MPa Edgew 120*10°4 sp=100mm         133         *C         ISO 75/Je           HDT/Jee, 1.8 MPa Edgew 120*10°4 sp=100mm         121         *C         ASTM D648           HDT, 1.82 MPa, 6.4 mm, unannealed         126         *C         ASTM E831           CTE, 40°C to 40°C, flow         7.E-05         1/°C         ASTM E831           CTE, 40°C to 40°C, xflow         5.5 − 0.7         \$MIC MORE MERSON           PHYSICAL (¹)         \$         ISO 183           Water Absorption (23°C/saturated)         0.5 − 0.7         \$         SABIC method           Moisture Absorption (23°C/saturated)         0.15         \$         ISO 1133           Water Absorption (23°C/saturated)         0.15         \$         SABIC method           Moil Shrinkage, flow, 3.2 mm (²)         0.5 − 0.7         \$         ASTM D792	THERMAL (1)			
Ball Pressure Test, 125°C+/- 2°C         PASSES         -         IEC 60695-10-2           Vicat Softening Temp, Rate A/50         145         °C         ISO 306           Vicat Softening Temp, Rate B/50         139         °C         ISO 306           Vicat Softening Temp, Rate B/120         140         °C         ISO 306           HDT/Be, 0.45MPa Edgew 120°10'4 sp=100mm         133         °C         ISO 75/Be           HDT/A, 1.8 MPa Edgew 120°10'4 sp=100mm         121         °C         ASTM D648           CTE, 40°C to 40°C, flow         7.E05         1°C         ASTM E831           CTE, 40°C to 40°C, flow         8.84E05         1°C         ASTM E831           CTE, 40°C to 40°C, flow         0.5−0.7         %         ASID Centrol           PHYSICAL <sup>(1)</sup> 1.2         g/cm³         ISO 1183           Water Absorption (23°C/saturated)         0.5 − 0.7         %         SO 62-1           Moisture Absorption (23°C/sorkH)         0.15         %         SO 62-1           Meit Volume Rate, MVR at 300°C/1.2 kg         26         cm³/10 min         ISO 1133           Specific Gravity         5         5         ASTM D792           Mold Shrinkage, flow, 3.2 mm <sup>(2)</sup> 5         5         3         ASTM D123	Thermal Conductivity	0.2	W/m-°C	ISO 8302
Vicat Softening Temp, Rate A/50         145         °C         ISO 306           Vicat Softening Temp, Rate B/50         139         °C         ISO 306           Vicat Softening Temp, Rate B/120         140         °C         ISO 306           HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm         133         °C         ISO 75/Be           HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm         121         °C         ISO 75/Ae           HDT, 1.82 MPa, 6.4 mm, unannealed         126         °C         ASTM E831           CTE, 40°C to 40°C, flow         7.E-05         1/°C         ASTM E831           CTE, 40°C to 40°C, flow         0.5-0.7         %         ASIM E831           PHYSICAL (¹)         1.2         g/cm³         ISO 1183           Water Absorption, (23°C/saturated)         0.5-0.7         %         SABIC method           Moisture Absorption (23°C/saturated)         0.15         %         SO 62-1           Meit Volume Rate, MVR at 300°C/1.2 kg         26         cm³/10 min         ISO 1133           Specific Gravity         5.0         2.9         ASTM D792           Mold Shrinkage, flow, 3.2 mm (²)         5.0         5.0         ASTM D792           Mole Flow Rate, 300°C/1.2 kgf         5.0         5.0         ASTM D792	CTE, 23°C to 80°C, flow	7.E-05	1/°C	ISO 11359-2
Vicat Softening Temp, Rate B/50         139         °C         ISO 306           Vicat Softening Temp, Rate B/120         140         °C         ISO 306           HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm         133         °C         ISO 75/Be           HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm         121         °C         ISO 75/Be           HDT, 1.82 MPa, 6.4 mm, unannealed         126         °C         ASTM D648           CTE, 40°C to 40°C, flow         7.E.05         1/°C         ASTM E831           CTE, 40°C to 40°C, flow         6.84E·05         1/°C         ASTM E831           PHYSICAL (*)*         **         SABIC method           Density         1.2         g/cm³         ISO 62-1           Moisture Absorption (23°C/saturated)         0.35         %         ISO 62-1           Moisture Absorption (23°C/saturated)         0.15         %         ISO 62-1           Melt Volume Rate, MVR at 300°C/1.2 kg         1.2         ~         ASTM D792           Moid Shrinkage, flow, 3.2 mm (*²)         0.5 - 0.7         %         ASBIC method           Melt Flow Rate, 300°C/1.2 kgf         0.5 - 0.7         %         ASIM D1238           INJECTION MOLDING (*³)         *         ASIM D1238           Drying Temperature	Ball Pressure Test, 125°C +/- 2°C	PASSES	-	IEC 60695-10-2
Vicat Softening Temp, Rate B/50         139         °C         ISO 306           Vicat Softening Temp, Rate B/120         140         °C         ISO 306           HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm         133         °C         ISO 75/Be           HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm         121         °C         ISO 75/Be           HDT, 1.82 MPa, 6.4 mm, unannealed         126         °C         ASTM D648           CTE, 40°C to 40°C, flow         7.E.05         1/°C         ASTM E831           CTE, 40°C to 40°C, flow         6.84E05         1/°C         ASTM E831           PHYSICAL (*)         **         ASTM E831           Physic CAL (*)         **         ASBIC method           Density         1.2         g/cm³         ISO 62-1           Moisture Absorption (23°C/saturated)         0.15         %         ISO 62-1           Melit Volume Rate, MVR at 300°C/1.2 kg         26         cm³/10 min         ISO 1133           Specific Gravity         1.2          ASTM D792           Mold Shrinkage, flow, 3.2 mm (*²)         5.5 - 0.7         %         ASBIC method           Melit Flow Rate, 300°C/1.2 kgf         25         (7         %         ASIM D792           Physic Gravity         5.	·	145	°C	ISO 306
HDT/Be, 0.45MPa Edgew 120°10°4 sp=100mm         133         °C         ISO 75/Be           HDT/Ae, 1.8 MPa Edgew 120°10°4 sp=100mm         121         °C         ISO 75/Ae           HDT, 1.82 MPa, 6.4 mm, unannealed         126         °C         ASTM D648           CTE, -40°C to 40°C, flow         7.6:05         1/°C         ASTM E831           CTE, -40°C to 40°C, xflow         6.84E·05         1/°C         ASTM E831           PHYSICAL (¹)         V         SABIC method           Bodid Shrinkage on Tensile Bar, flow         0.5 − 0.7         %         SABIC method           Density         1.2         g/cm³         ISO 62·1           Moisture Absorption (23°C/saturated)         0.35         %         ISO 62·1           Melt Volume Rate, MVR at 300°C/1.2 kg         26         cm³/10 min         ISO 1133           Specific Gravity         1.2         cm³/10 min         SAIT D792           Mold Shrinkage, flow, 3.2 mm (²)         0.5 − 0.7         %         SABIC method           INJECTION MOLDING (³)         25         3 − 0         ASTM D1238           INJECTION MOLDING (³)         25         3 − 4         HIS           Drying Time (Cumulative)         48         HIS           Drying Time (Cumulative)         48	Vicat Softening Temp, Rate B/50	139	°C	ISO 306
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm         121         °C         ISO 75/Ae           HDT, 1.82 MPa, 6.4 mm, unannealed         126         °C         ASTM D648           CTE, -40°C to 40°C, flow         7.E05         1/°C         ASTM E831           CTE, -40°C to 40°C, xflow         6.84E-05         1/°C         ASTM E831           PHYSICAL (¹)         ***         SABIC method           Mold Shrinkage on Tensile Bar, flow         0.5 − 0.7         %         SABIC method           Density         1.2         g/cm³         ISO 62-1           Moisture Absorption, (23°C/saturated)         0.35         %         ISO 62-1           Melt Volume Rate, MVR at 300°C/1.2 kg         26         cm³/10 min         ISO 1133           Specific Gravity         1.2         ASTM D792           Mold Shrinkage, flow, 3.2 mm (²)         0.5 − 0.7         %         SABIC method           Melt Flow Rate, 300°C/1.2 kg         0.5 − 0.7         %         SABIC method           INJECTION MOLDING (³)         25         g/10 min         ASTM D1238           INJECTION MOLDING (³)         2         C           Drying Time         (Cumulative)         48         Hrs           Drying Time (Cumulative)         48         Hrs <td>Vicat Softening Temp, Rate B/120</td> <td>140</td> <td>°C</td> <td>ISO 306</td>	Vicat Softening Temp, Rate B/120	140	°C	ISO 306
HDT, 1.82 MPa, 6.4 mm, unannealed         126         °C         ASTM D648           CTE, -40°C to 40°C, flow         7.6-05         1/°C         ASTM E831           CTE, -40°C to 40°C, xflow         6.84e.05         1/°C         ASTM E831           PHYSICAL (¹¹)           Wold Shrinkage on Tensile Bar, flow         0.5 − 0.7         %         SABIC method           Density         1.2         g/cm³         ISO 1183           Water Absorption, (23°C/saturated)         0.35         %         ISO 62-1           Moisture Absorption (23°C / 50% RH)         0.15         %         ISO 62-1           Melt Volume Rate, MVR at 300°C/1.2 kg         26         cm³/10 min         ISO 1133           Specific Gravity         1.2         .         ASTM D792           Mold Shrinkage, flow, 3.2 mm (²²)         0.5 − 0.7         %         SABIC method           Melt Flow Rate, 300°C/1.2 kgf         0.5 − 0.7         %         SABIC method           INJECTION MOLDING (³²)         2         C           Drying Temperature         120         °C           Drying Time (Cumulative)         48         Hrs           Maximum Moisture Content         48         Hrs	HDT/Be, 0.45MPa Edgew 120*10*4 sp=100mm	133	°C	ISO 75/Be
CTE, -40°C to 40°C, flow         7.E·05         1/°C         ASTM E831           CTE, -40°C to 40°C, xflow         6.84E·05         1/°C         ASTM E831           PHYSICAL <sup>(1)</sup> While Shrinkage on Tensile Bar, flow         0.5 − 0.7         \$ SABIC method           Density         1.2         g/cm³         ISO 1183           Water Absorption, (23°C/saturated)         0.35         %         ISO 62·1           Moisture Absorption (23°C / 50% RH)         0.15         %         ISO 62·1           Melt Volume Rate, MVR at 300°C/1.2 kg         26         cm³/10 min         ISO 1133           Specific Gravity         1.2         -         ASTM D792           Mold Shrinkage, flow, 3.2 mm (²)         0.5 − 0.7         %         SABIC method           Melt Flow Rate, 300°C/1.2 kgf         25         g/10 min         ASTM D1238           INJECTION MOLDING (³)           Injection Molphage         120         °C           Drying Time         2         48         Hrs           Drying Time (Cumulative)         48         Hrs           Maximum Moisture Content         0.02         %	HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	121	°C	ISO 75/Ae
PHYSICAL (1)  Mold Shrinkage on Tensile Bar, flow 0.5 – 0.7 % SABIC method  Density 1.2 % SABIC method  Moisture Absorption (23°C / 50% RH) 0.15 % SO 62-1  Mold Shrinkage, flow, 3.2 mm (2) 0.5 – 0.7 % SABIC method  Specific Gravity 1.2 % SABIC method  Mold Shrinkage, flow, 3.2 mm (2) 0.5 – 0.7 % SABIC method  Mold Shrinkage, flow, 3.	HDT, 1.82 MPa, 6.4 mm, unannealed	126	°C	ASTM D648
PHYSICAL (1)           Mold Shrinkage on Tensile Bar, flow         0.5 – 0.7         \$ SABIC method           Density         1.2         g/cm³         ISO 1183           Water Absorption, (23°C/saturated)         0.35         \$ ISO 62-1           Moisture Absorption (23°C / 50% RH)         0.15         \$ ISO 62           Melt Volume Rate, MVR at 300°C/1.2 kg         26         cm³/10 min         ISO 1133           Specific Gravity         1.2         -         ASTM D792           Mold Shrinkage, flow, 3.2 mm (2)         0.5 – 0.7         \$ SABIC method           Melt Flow Rate, 300°C/1.2 kgf         25         g/10 min         ASTM D1238           INJECTION MOLDING (3)         -         C           Drying Temperature         120         ° C           Drying Time (Cumulative)         48         Hrs           Drying Time (Cumulative)         48         Hrs	CTE, -40°C to 40°C, flow	7.E-05	1/°C	ASTM E831
Mold Shrinkage on Tensile Bar, flow         0.5 - 0.7         %         SABIC method           Density         1.2         g/cm³         ISO 1183           Water Absorption, (23°C/saturated)         0.35         %         ISO 62-1           Moisture Absorption (23°C / 50% RH)         0.15         %         ISO 62           Melt Volume Rate, MVR at 300°C/1.2 kg         26         cm³/10 min         ISO 1133           Specific Gravity         1.2         -         ASTM D792           Mold Shrinkage, flow, 3.2 mm (²)         0.5 - 0.7         %         SABIC method           Melt Flow Rate, 300°C/1.2 kgf         25         g/10 min         ASTM D1238           INJECTION MOLDING (³)         C         C           Drying Temperature         120         °C           Drying Time (Cumulative)         48         Hrs           Drying Time (Cumulative)         48         Hrs	CTE, -40°C to 40°C, xflow	6.84E-05	1/°C	ASTM E831
Density         1.2         g/cm³         ISO 1183           Water Absorption, (23°C/saturated)         0.35         %         ISO 62·1           Moisture Absorption (23°C / 50% RH)         0.15         %         ISO 62           Melt Volume Rate, MVR at 300°C/1.2 kg         26         cm³/10 min         ISO 1133           Specific Gravity         1.2         -         ASTM D792           Mold Shrinkage, flow, 3.2 mm (²)         0.5 - 0.7         %         SABIC method           Melt Flow Rate, 300°C/1.2 kgf         25         g/10 min         ASTM D1238           INJECTION MOLDING (³)         T         C           Drying Temperature         120         °C           Drying Time (Cumulative)         48         Hrs           Drying Time (Cumulative)         48         Hrs	PHYSICAL (1)			
Water Absorption, (23°C/saturated)         0.35         %         ISO 62-1           Moisture Absorption (23°C / 50% RH)         0.15         %         ISO 62           Melt Volume Rate, MVR at 300°C/1.2 kg         26         cm³/10 min         ISO 1133           Specific Gravity         1.2         -         ASTM D792           Mold Shrinkage, flow, 3.2 mm (2)         0.5 - 0.7         %         SABIC method           Melt Flow Rate, 300°C/1.2 kgf         25         g/10 min         ASTM D1238           INJECTION MOLDING (3)         C           Drying Temperature         120         °C           Drying Time (Cumulative)         48         Hrs           Drying Time (Cumulative)         48         Hrs           Maximum Moisture Content         0.02         %	Mold Shrinkage on Tensile Bar, flow	0.5 – 0.7	%	SABIC method
Moisture Absorption (23°C / 50% RH)         0.15         %         ISO 62           Melt Volume Rate, MVR at 300°C/1.2 kg         26         cm³/10 min         ISO 1133           Specific Gravity         1.2         -         ASTM D792           Mold Shrinkage, flow, 3.2 mm (2)         0.5 – 0.7         %         SABIC method           Melt Flow Rate, 300°C/1.2 kgf         25         g/10 min         ASTM D1238           INJECTION MOLDING (3)         **         C           Drying Temperature         120         **         C           Drying Time (Cumulative)         48         Hrs           Drying Time (Cumulative)         48         Hrs           Maximum Moisture Content         0.02         %	Density	1.2	g/cm³	ISO 1183
Melt Volume Rate, MVR at 300°C/1.2 kg         26         cm³/10 min         ISO 1133           Specific Gravity         1.2         -         ASTM D792           Mold Shrinkage, flow, 3.2 mm (²)         0.5 – 0.7         %         SABIC method           Melt Flow Rate, 300°C/1.2 kgf         25         g/10 min         ASTM D1238           INJECTION MOLDING (³)           Drying Temperature         120         °C           Drying Time         Hrs           Drying Time (Cumulative)         48         Hrs           Maximum Moisture Content         0.02         %	Water Absorption, (23°C/saturated)	0.35	%	ISO 62-1
Specific Gravity         1.2         - ASTM D792           Mold Shrinkage, flow, 3.2 mm (2)         0.5 – 0.7         %         SABIC method           Melt Flow Rate, 300°C/1.2 kgf         25         g/10 min         ASTM D1238           INJECTION MOLDING (3)         C           Drying Temperature         120         °C           Drying Time         3 – 4         Hrs           Drying Time (Cumulative)         48         Hrs           Maximum Moisture Content         0.02         %	Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
Mold Shrinkage, flow, 3.2 mm <sup>(2)</sup> 0.5 – 0.7         %         SABIC method           Melt Flow Rate, 300°C/1.2 kgf         25         g/10 min         ASTM D1238           INJECTION MOLDING <sup>(3)</sup> Drying Temperature         120         °C           Drying Time         Hrs           Drying Time (Cumulative)         48         Hrs           Maximum Moisture Content         0.02         %	Melt Volume Rate, MVR at 300°C/1.2 kg	26	cm³/10 min	ISO 1133
Melt Flow Rate, 300°C/1.2 kgf         25         g/10 min         ASTM D1238           INJECTION MOLDING (3)         °C           Drying Temperature         120         °C         Hrs           Drying Time (Cumulative)         48         Hrs         Use of the color of	Specific Gravity	1.2	-	ASTM D792
Melt Flow Rate, 300°C/1.2 kgf         25         g/10 min         ASTM D1238           INJECTION MOLDING (3)         °C           Drying Temperature         120         °C         Hrs           Drying Time (Cumulative)         48         Hrs         Use of the color of	Mold Shrinkage, flow, 3.2 mm (2)	0.5 - 0.7	%	SABIC method
Drying Temperature120°CDrying Time3 - 4HrsDrying Time (Cumulative)48HrsMaximum Moisture Content0.02%		25	g/10 min	ASTM D1238
Drying Time (Cumulative)  A8  Maximum Moisture Content  3 - 4  48  Hrs  Was Maximum Moisture Content  0.02  %	INJECTION MOLDING (3)			
Drying Time (Cumulative) 48 Hrs Maximum Moisture Content 0.02 %	Drying Temperature	120	°C	
Maximum Moisture Content 0.02 %	Drying Time	3 – 4	Hrs	
	Drying Time (Cumulative)	48	Hrs	
Melt Temperature 270 − 295 °C	Maximum Moisture Content	0.02	%	
	Melt Temperature	270 – 295	°C	
Nozzle Temperature 265 – 290 °C	Nozzle Temperature	265 – 290	°C	
Front - Zone 3 Temperature         270 – 295         °C	Front - Zone 3 Temperature	270 – 295	°C	
Middle - Zone 2 Temperature 260 – 280 °C	Middle - Zone 2 Temperature	260 – 280	°C	
Rear - Zone 1 Temperature 250 – 270 °C	Rear - Zone 1 Temperature	250 – 270	°C	
<b>Mold Temperature</b> 70 − 95 °C	Mold Temperature	70 – 95	°C	
Back Pressure 0.3 – 0.7 MPa	Back Pressure	0.3 – 0.7	MPa	
Screw Speed         40 – 70         rpm	Screw Speed	40 – 70	rpm	
Shot to Cylinder Size 40 – 60 %	Shot to Cylinder Size	40 - 60	%	
	Vent Depth	0.025 – 0.076	mm	



- (1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.
- (2) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.
- (3) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

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