

An Ultra low-viscosity grade for general injection molding

- A standard unfilled and extra easy-flowing (ultra low-viscosity) grade for general injection molding
- Suitable for multi-cavity molds and thin-walled precision parts

Rheological properties

Moulding shrinkage, parallel	2.0	%	ISO 294-4, 2577
Typical mechanical properties			
Tensile Modulus	2900	MPa	ISO 527-1/-2
Yield stress, 50mm/min	65	MPa	ISO 527-1/-2
Yield strain, 50mm/min	7	%	ISO 527-1/-2
Nominal strain at break	13	%	ISO 527-1/-2
Flexural Modulus		MPa	ISO 178
Flexural Strength		MPa	ISO 178
Charpy notched impact strength, 23°C		kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C		kJ/m²	ISO 179/1eA
Poisson's ratio	0.418		
Thermal properties			
Melting temperature, 10°C/min	165	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	101	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	120	E-6/K	ISO 11359-1/-2
Electrical properties			
Volume resistivity	1E12	Ohm.m	IEC 62631-3-1
Surface resistivity	1E16	Ohm	IEC 62631-3-2
Electric strength	19	kV/mm	IEC 60243-1
Other properties			
Humidity absorption, 2mm	0.2	%	Sim. to ISO 62
Density		kg/m ³	ISO 1183
Injection			
Injection			
Drying Temperature	80 - 90		
Drying Time, Dehumidified Dryer	3 - 4	h	

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0.1 %

2 MPa

60 - 80 °C

Revised: 2023-05-10 Source: Celanese Materials Database

Processing Moisture Content

Max. mould temperature

Back pressure



Additional information

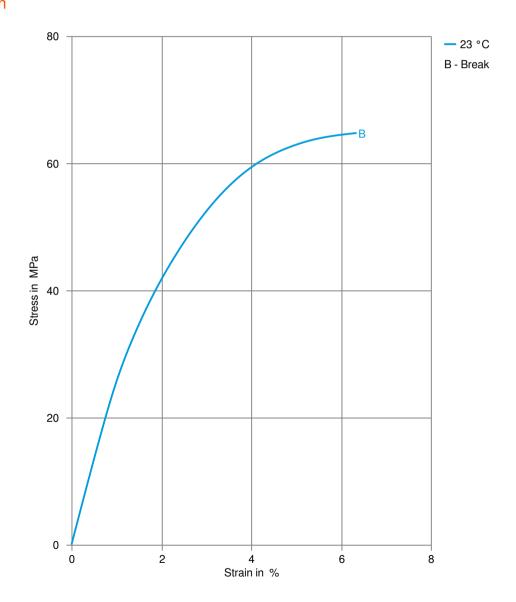
Injection molding

mold temperature: $60^{\circ}\text{C} \sim 80^{\circ}\text{C} (140^{\circ}\text{F} \sim 160^{\circ}\text{F})$ barrel temperature: $170^{\circ}\text{C} \sim 210^{\circ}\text{C} (338^{\circ}\text{F} \sim 410^{\circ}\text{F})$

screw speed: 150mm/s ~ 200mm/s

back pressure: max. 20bar

Stress-strain

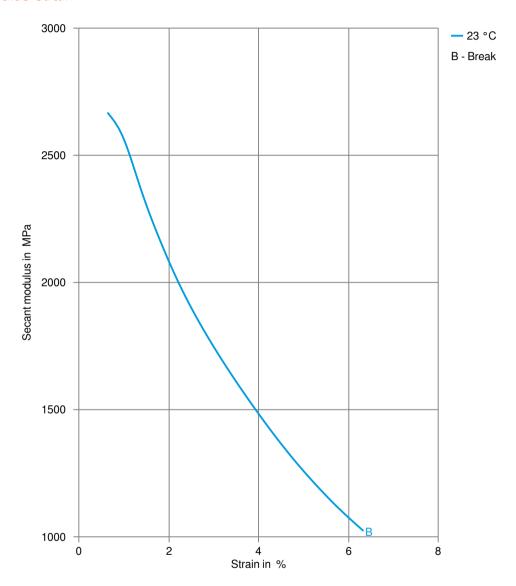


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Secant modulus-strain

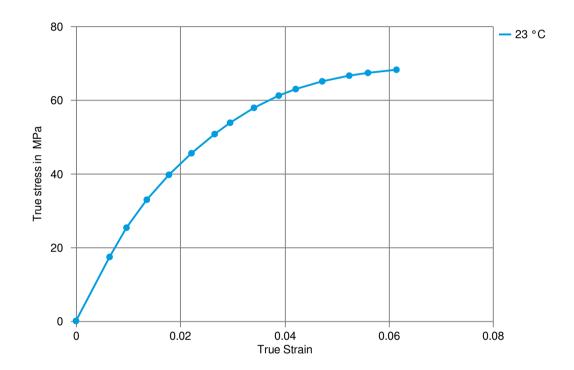


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True stress-strain



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Processing Texts

Pre-drying suggested pre-drying condition: 80 °C ~ 90 °C (176°F ~ 194°F) 3 h ~ 4 h

suggested max. moisture:0.1%

Injection molding mold temperature: $60^{\circ}\text{C} \sim 80^{\circ}\text{C} (140^{\circ}\text{F} \sim 160^{\circ}\text{F})$

barrel temperature: 170° C ~ 210° C (338° F ~ 410° F)

screw speed: 150mm/s ~ 200mm/s

back pressure: max. 20bar

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