



PRODUCT DESCRIPTION			TYPE
Product Code			710C0031
Color			Natural
PHYSICAL PROPERTIES	UNIT	TEST METHOD	TYPICAL VALUE
Density	g/cc	ASTM D792	1.12 ± 0.02
Linear mould Shrinkage in flow direction	%	CPPL/12	1.50 ± 0.20
MECHANICAL PROPERTIES	UNIT	TEST METHOD	TYPICAL VALUE
Tensile Strength at Yield @ 50 mm/min	MPa	ASTM D638	75 ± 10
Elongation at Yield @ 50 mm/min	%	ASTM D638	9 ± 1
Flexural Strength @ 2 mm/min	MPa	ASTM D790	110 ± 10
Notched Izod Impact Strength @ 23°C, 3.2 mm	J/m	ASTM D256	> 60
THERMAL PROPERTIES	UNIT	TEST METHOD	TYPICAL VALUE
Melting Point	°C	CPPL/16	220 ± 2
Un-annealed, HDT @ 1.82 MPa	°C	ASTM D648	60 ± 3
FLAMMABILITY	UNIT	TEST METHOD	TYPICAL VALUE
Flammability at 3.2mm thickness	Rating	UL-94	V2

PROCESSING PARAMETER

Injection	Nominal Value	Unit
Drying Temperature ¹ Dehumidified dryer	80	°C
Drying Time	2.0 to 4.0	hr
Rear Temperature	220 to 230	°C
Middle Temperature	235 to 245	°C
Front Temperature	245 to 255	°C
Nozzle Temperature	260 to 280	°C
Mold Temperature	60 to 80	°C

For Calco Poly Technik Pvt.Ltd.

Authorized Signatory

Note.: Properties measured at DAM conditions.



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Pigmented grades would record slightly lower mechanical properties as permitted by ASTM D 4066. The information on our products & recommendations on their use are based on our present knowledge and experience. As many factors affect the use of our products and since the conditions of use are beyond our control, all recommendations or suggestions are presented without guarantee or responsibility on our part. Furthermore, it is the responsibility of the users of our products to ensure that any proprietary rights, existing laws and legislation are observed. Due to continuous product improvement, we reserve the right to change the product specification without prior notice.

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