

| Processing/Physical Characteristics                | dry / cond  | Unit               | Test Standard       |
|--|-------------|--------------------|---------------------|
| <b>ISO Data</b>                                    |             |                    |                     |
| Molding shrinkage, parallel                        | 0.3 / *     | %                  | ISO 294-4, 2577     |
| Molding shrinkage, normal                          | 0.8 / *     | %                  | ISO 294-4, 2577     |
| <b>Mechanical properties</b>                       |             |                    |                     |
| <b>ISO Data</b>                                    |             |                    |                     |
| Tensile Modulus                                    | 8800 / 5700 | MPa                | ISO 527             |
| Stress at break                                    | 150 / 95    | MPa                | ISO 527             |
| Strain at break                                    | 3 / 6       | %                  | ISO 527             |
| Flexural modulus, 23°C                             | 7500 / 4500 | MPa                | ISO 178             |
| Charpy impact strength, +23°C                      | 45 / 60     | kJ/m <sup>2</sup>  | ISO 179/1eU         |
| Charpy notched impact strength, +23°C              | 6.5 / 11    | kJ/m <sup>2</sup>  | ISO 179/1eA         |
| Izod impact strength, +23°C                        | 40 / 55     | kJ/m <sup>2</sup>  | ISO 180/1U          |
| Izod notched impact strength, +23°C                | 6 / 10      | kJ/m <sup>2</sup>  | ISO 180/1A          |
| Rockwell hardness                                  | R 122       | -                  | ISO 2039-2          |
| <b>Thermal properties</b>                          |             |                    |                     |
| <b>ISO Data</b>                                    |             |                    |                     |
| Melting temperature, 10°C/min                      | 221 / *     | °C                 | ISO 11357-1/-3      |
| Temp. of deflection under load, 1.80 MPa           | 200 / *     | °C                 | ISO 75-1/-2         |
| Temp. of deflection under load, 0.45 MPa           | 215 / *     | °C                 | ISO 75-1/-2         |
| Vicat softening temperature, B                     | 210 / *     | °C                 | ISO 306             |
| Burning behav. at thickness h                      | HB / *      | class              | IEC 60695-11-10     |
| Thickness tested                                   | 0.8 / *     | mm                 | -                   |
| <b>Electrical properties</b>                       |             |                    |                     |
| <b>ISO Data</b>                                    |             |                    |                     |
| Volume resistivity                                 | 1E13 / -    | Ohm*m              | IEC 62631-3-1       |
| Surface resistivity                                | * / 1E13    | Ohm                | IEC 62631-3-2       |
| <b>Other properties</b>                            |             |                    |                     |
| Density  | 1360 / -    | kg/m <sup>3</sup>  | ISO 1183            |
| <b>Material specific properties</b>                |             |                    |                     |
| <b>ISO Data</b>                                    |             |                    |                     |
| Viscosity number                                   | 135 / *     | cm <sup>3</sup> /g | ISO 307, 1157, 1628 |
| <b>Processing Recommendation Injection Molding</b> |             |                    |                     |
| Pre-drying - Temperature                           | 75 - 85     | °C                 | -                   |
| Pre-drying - Time                                  | 2 - 4       | h                  | -                   |
| Melt temperature                                   | 240 - 270   | °C                 | -                   |
| Mold temperature                                   | 90 - 100    | °C                 | -                   |

## Characteristics

### Processing

Injection Molding

### Regional Availability

North America, Europe, Asia Pacific