

| Processing/Physical Characteristics                | Value    | Unit              | Test Standard   |
|--|----------|-------------------|-----------------|
| <b>ISO Data</b>                                    |          |                   |                 |
| Molding shrinkage, parallel                        | 0.4      | %                 | ISO 294-4, 2577 |
| Molding shrinkage, normal                          | 0.8      | %                 | ISO 294-4, 2577 |
| <b>ASTM Data</b>                                   |          |                   |                 |
| Mold Shrinkage, MD                                 | 0.006    | mm/mm             | ASTM D 955      |
| <b>Mechanical properties</b>                       |          |                   |                 |
| <b>ISO Data</b>                                    |          |                   |                 |
| Tensile Strength                                   | 160      | MPa               | ISO 527         |
| Flexural modulus, 23°C                             | 7700     | MPa               | ISO 178         |
| Charpy notched impact strength, +23°C              | 12       | kJ/m <sup>2</sup> | ISO 179/1eA     |
| <b>ASTM Data</b>                                   |          |                   |                 |
| Tensile Strength                                   | 167      | MPa               | ASTM D 638      |
| Flexural Modulus                                   | 8238     | MPa               | ASTM D 790      |
| Flexural Strength                                  | 273      | MPa               | ASTM D 790      |
| Rockwell Hardness                                  | R 120    | -                 | ASTM D 785      |
| Izod Impact notched, 1/8 in                        | 157      | J/m               | ASTM D 256      |
| <b>Thermal properties</b>                          |          |                   |                 |
| <b>ISO Data</b>                                    |          |                   |                 |
| Melting temperature, 10°C/min                      | 225      | °C                | ISO 11357-1/-3  |
| Temp. of deflection under load, 1.80 MPa           | 193      | °C                | ISO 75-1/-2     |
| <b>ASTM Data</b>                                   |          |                   |                 |
| UL 94 Flame rating                                 | HB       | -                 | UL 94           |
| Thickness tested                                   | 0.8      | mm                | -               |
| Coefficient of Thermal Expansion, MD               | 30       | E-6/K             | ASTM D 696      |
| DTUL @ 66 psi                                      | 210      | °C                | ASTM D 648      |
| DTUL @ 264 psi                                     | 205      | °C                | ASTM D 648      |
| Melting Temperature                                | 220      | °C                | ASTM D 3418     |
| <b>Electrical properties</b>                       |          |                   |                 |
| <b>ASTM Data</b>                                   |          |                   |                 |
| Dielectric Strength, Short Time                    | 21       | kV/mm             | ASTM D 149      |
| Dielectric Constant, 1 MHz                         | 3.6      | -                 | ASTM D 150      |
| Arc Resistance                                     | 130      | s                 | ASTM D 495      |
| <b>Other properties</b>                            |          |                   |                 |
| Density  | 1360     | kg/m <sup>3</sup> | ISO 1183        |
| Water Absorption, 24hr                             | 0.4      | %                 | ASTM D 570      |
| Density  | 1360     | kg/m <sup>3</sup> | ASTM D 792      |
| <b>Processing Recommendation Injection Molding</b> |          |                   |                 |
| Pre-drying - Temperature                           | 80 - 100 | °C                | -               |
| Pre-drying - Time                                  | 4 - 5    | h                 | -               |
| Processing humidity                                | ≤0.05    | %                 | -               |
| Mold temperature                                   | 60 - 80  | °C                | -               |
| Zone 1   | 230      | °C                | -               |
| Zone 2   | 245      | °C                | -               |
| Zone 3   | 250      | °C                | -               |
| Nozzle temperature                                 | 255      | °C                | -               |

## Characteristics

### Processing

Injection Molding

### Special Characteristics

Heat stabilized or stable to heat

**Delivery form**

Black

**Regional Availability**

North America, Asia Pacific