

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.4 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Stress at break	170 / 110	MPa	ISO 527
Strain at break	2 / 5	%	ISO 527
Flexural modulus, 23°C	10200 / 6320	MPa	ISO 178
Flexural strength	280 / 174	MPa	ISO 178
Charpy notched impact strength, +23°C	13 / 23.1	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	13 / 23.1	kJ/m <sup>2</sup>	ISO 180/1A

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	221 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	230 / *	°C	ISO 75-1/-2

Other properties	dry / cond	Unit	Test Standard
Density	1490 / -	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	71.1	°C	-
Pre-drying - Time	4	h	-
Melt temperature	271 - 293	°C	-
Mold temperature	26.7 - 93.3	°C	-
Zone 1	254	°C	-
Zone 2	268	°C	-
Zone 3	285	°C	-
Nozzle temperature	266 - 282	°C	-
Screw speed	30 - 60	rpm	-
Injection pressure	68.9	MPa	-
Back pressure	0.0689 - 0.689	MPa	-

**Characteristics**

**Processing**

Injection Molding

**Delivery form**

Pellets, Black

**Additives**

Lubricants

**Special Characteristics**

Heat stabilized or stable to heat

**Regional Availability**

North America, Europe, Asia Pacific, South and Central America, Near East/Africa