

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.00425	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Break	138	MPa	ASTM D 638
Elongation at Yield	2	%	ASTM D 638
Elongation at Break	3	%	ASTM D 638
Flexural Modulus	6895	MPa	ASTM D 790
Flexural Strength	221	MPa	ASTM D 790
Rockwell Hardness	R120	-	ASTM D 785
Izod Impact notched, 1/8 in	53.4	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 264 psi	221	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	1.9	%	ASTM D 570
Density	1350	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	82.2	°C	-
Pre-drying - Time	2 - 4	h	-
Melt temperature	279 - 304	°C	-
Mold temperature	37.8 - 93.3	°C	-
Zone 1	260 - 293	°C	-
Zone 2	266 - 293	°C	-
Zone 3	266 - 293	°C	-
Nozzle temperature	260 - 288	°C	-
Screw speed	60 - 120	rpm	-
Back pressure	0.345 - 0.689	MPa	-

Characteristics

Processing

Injection Molding

Regional Availability

North America

Delivery form

Pellets