

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.8 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	6400 / 4100	MPa	ISO 527
Yield stress	70 / 35	MPa	ISO 527
Stress at break	65 / 35	MPa	ISO 527
Strain at break	2.5 / 3	%	ISO 527
Flexural modulus, 23°C	6000 / 2800	MPa	ISO 178
Charpy impact strength, +23°C	30 / 23	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	3 / 7	kJ/m <sup>2</sup>	ISO 179/1eA
<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	125 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	190 / *	°C	ISO 75-1/-2
<b>Other properties</b>			
Density	1400 / -	kg/m <sup>3</sup>	ISO 1183
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	75 - 85	°C	-
Pre-drying - Time	2 - 4	h	-
Melt temperature	240 - 280	°C	-
Mold temperature	60 - 80	°C	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific

**Special Characteristics**

Heat stabilized or stable to heat