

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	<b>0.3</b>	%	ISO 294-4, 2577
Molding shrinkage, normal	<b>1.1</b>	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	<b>8000</b>	MPa	ISO 527
Tensile Strength	<b>170</b>	MPa	ISO 527
Strain at break	<b>3.5</b>	%	ISO 527
Charpy impact strength, +23°C	<b>70</b>	kJ/m <sup>2</sup>	ISO 179/1eU

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Melting temperature, 10°C/min	<b>260</b>	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	<b>72</b>	°C	ISO 11357-1/-2

Other properties	Value	Unit	Test Standard
Density	<b>1400</b>	kg/m <sup>3</sup>	ISO 1183
Bulk density	<b>660</b>	kg/m <sup>3</sup>	-

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>80</b>	°C	-
Pre-drying - Time	<b>4 - 8</b>	h	-
Processing humidity	<b>≤0.1</b>	%	-
Melt temperature	<b>290 - 310</b>	°C	-
Mold temperature	<b>90 - 150</b>	°C	-
Zone 1	<b>260 - 310</b>	°C	-

## Characteristics

### Processing

Injection Molding

### Delivery form

Pellets, Natural Color

### Additives

Lubricants

### Special Characteristics

Heat stabilized or stable to heat

### Regional Availability

North America, Europe, Asia Pacific, South and Central America