

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	24000	MPa	ISO 527
Yield stress	325	MPa	ISO 527
Strain at break	2	%	ISO 527
Flexural modulus, 23°C	22500	MPa	ISO 178
Flexural strength	435	MPa	ISO 178
Charpy impact strength, +23°C	55	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	18	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	250	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	255	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	18	E-6/K	ISO 11359-1/-2

Electrical properties	Value	Unit	Test Standard
ASTM Data			
Surface Resistivity	100	Ohm	ASTM D 257

Other properties	Value	Unit	Test Standard
Humidity absorption	1.7	%	Sim. to ISO 62
Density	1280	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	310	°C	-
Mold temperature	80 - 160	°C	-
Zone 1	270 - 300	°C	-
Zone 2	270 - 300	°C	-
Zone 3	285 - 310	°C	-
Nozzle temperature	285 - 320	°C	-

Characteristics

Processing
Injection Molding, Compression Molding

Features
Creep Resistance, Fatigue Resistance, Long fiber reinforced

Delivery form
Pellets

Regional Availability
Europe

Special Characteristics
Heat stabilized or stable to heat