

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

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	10500 / -	MPa	ISO 527
Stress at break	195 / -	MPa	ISO 527
Strain at break	3 / -	%	ISO 527
Flexural modulus, 23°C	8300 / -	MPa	ISO 178
Charpy impact strength, +23°C	65 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	19 / -	kJ/m ²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	253 / *	°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	29 / *	E-6/K	ISO 11359-1/-2

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
Electric strength	35 / -	kV/mm	IEC 60243-1
Comparative tracking index	500 / -	-	IEC 60112
ASTM Data			
Surface Resistivity	* / 1E13	Ohm	ASTM D 257

Other properties	dry / cond	Unit	Test Standard
Humidity absorption	1.4 / *	%	Sim. to ISO 62
Density	1530 / -	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	300	°C	-
Mold temperature	80 - 140	°C	-
Zone 1	270 - 300	°C	-
Zone 2	270 - 300	°C	-
Zone 3	285 - 300	°C	-

Characteristics

Processing

Injection Molding

Additives

Lubricants

Delivery form

Pellets

Regional Availability

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