

| Processing/Physical Characteristics                | Value       | Unit              | Test Standard   |
|----------------------------------------------------|-------------|-------------------|-----------------|
| <b>ISO Data</b>                                    |             |                   |                 |
| Molding shrinkage, parallel                        | 0.3         | %                 | ISO 294-4, 2577 |
| Molding shrinkage, normal                          | 1.0         | %                 | ISO 294-4, 2577 |
| <b>Mechanical properties</b>                       |             |                   |                 |
| <b>ISO Data</b>                                    |             |                   |                 |
| Tensile Strength                                   | 170         | MPa               | ISO 527         |
| Flexural modulus, 23°C                             | 10700       | MPa               | ISO 178         |
| Flexural strength                                  | 240         | MPa               | ISO 178         |
| <b>Thermal properties</b>                          |             |                   |                 |
| <b>ISO Data</b>                                    |             |                   |                 |
| Melting temperature, 10°C/min                      | 260         | °C                | ISO 11357-1/-3  |
| Temp. of deflection under load, 1.80 MPa           | 235         | °C                | ISO 75-1/-2     |
| <b>Other properties</b>                            |             |                   |                 |
| Density                                            | 1420        | kg/m <sup>3</sup> | ISO 1183        |
| <b>Processing Recommendation Injection Molding</b> |             |                   |                 |
| Pre-drying - Temperature                           | 80          | °C                | -               |
| Pre-drying - Time                                  | 2 - 4       | h                 | -               |
| Processing humidity                                | ≤0.15       | %                 | -               |
| Mold temperature                                   | 71 - 93     | °C                | -               |
| Zone 1                                             | 260 - 293   | °C                | -               |
| Zone 2                                             | 260 - 293   | °C                | -               |
| Zone 3                                             | 260 - 293   | °C                | -               |
| Nozzle temperature                                 | 254 - 293   | °C                | -               |
| Screw speed                                        | 30 - 120    | rpm               | -               |
| Injection pressure                                 | 34 - 138    | MPa               | -               |
| Back pressure                                      | 0.34 - 1.03 | MPa               | -               |

## Characteristics

### Processing

Injection Molding

### Applications

Automotive

### Certifications

Recycled Resin Content

### Regional Availability

North America