

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.8 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Stress at break	230 / 180	MPa	ISO 527
Strain at break	2.5 / 3.5	%	ISO 527
Flexural modulus, 23°C	14800 / 12000	MPa	ISO 178
Flexural strength	320 / 280	MPa	ISO 178
Charpy impact strength, +23°C	95 / 100	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	85 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	18 / 25	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	13 / -	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	16 / 21	kJ/m ²	ISO 180/1A

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	257 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	257 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	262 / *	°C	ISO 75-1/-2
Vicat softening temperature, B	254 / *	°C	ISO 306

Other properties	dry / cond	Unit	Test Standard
Water absorption	4.1 / *	%	Sim. to ISO 62
Density	1560 / -	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	90	°C	-
Pre-drying - Time	4	h	-
Melt temperature	270 - 290	°C	-
Mold temperature	100 - 110	°C	-

Characteristics

Processing

Injection Molding

Chemical Resistance

Hydrolytically Stable

Delivery form

Black

Regional Availability

North America, Europe, South and Central America

Special Characteristics

U.V. stabilized or stable to weather, Heat stabilized or stable to heat