

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.005	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.008	mm/mm	ASTM D 955

Mechanical properties	dry / cond	Unit	Test Standard
ASTM Data			
Tensile Strength	170 / 140	MPa	ASTM D 638
Flexural Modulus	10000 / 7000	MPa	ASTM D 790
Flexural Strength	260 / 220	MPa	ASTM D 790
Rockwell Hardness	M 110 /	-	ASTM D 785
Izod Impact notched, 1/8 in	80 / 90	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Coefficient of Thermal Expansion, MD	24	E-6/K	ASTM D 696
Coefficient of Thermal Expansion, TD	50	E-6/K	ASTM D 696
DTUL @ 264 psi	300	°C	ASTM D 648
Melting Temperature	310	°C	ASTM D 3418
Glass Transition Temperature	85	°C	ASTM E 1356

Electrical properties	dry / cond	Unit	Test Standard
ASTM Data			
Dielectric Strength, Short Time	28 / -	kV/mm	ASTM D 149
Dissipation Factor, 1 MHz	0.018 / -	-	ASTM D 150
Dielectric Constant, 1 MHz	4.5 / -	-	ASTM D 150
Volume Resistivity	>1E15 / -	Ohm*cm	ASTM D 257

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	0.3	%	ASTM D 570
Density	1420	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110	°C	-
Pre-drying - Time	2 - 6	h	-
Mold temperature	90 - 140	°C	-
Feed temperature	50 - 90	°C	-
Zone 1	300 - 325	°C	-
Zone 2	315 - 335	°C	-
Zone 3	320 - 335	°C	-
Nozzle temperature	315 - 335	°C	-
Screw speed	150	rpm	-

Characteristics

Processing
Injection Molding

Delivery form
Pellets

Applications
Electrical and Electronical

Regional Availability
North America, Europe, Asia Pacific