

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|-------------------------------------|--------|-------|---------------|
| ASTM Data | | | |
| Mold Shrinkage, MD | 0.0175 | mm/mm | ASTM D 955 |

| Mechanical properties | Value | Unit | Test Standard |
|-----------------------------|-------|------|---------------|
| ASTM Data | | | |
| Tensile Strength at Yield | 82.7 | MPa | ASTM D 638 |
| Elongation at Yield | 10 | % | ASTM D 638 |
| Elongation at Break | 70 | % | ASTM D 638 |
| Flexural Modulus | 3034 | MPa | ASTM D 790 |
| Flexural Strength | 89.6 | MPa | ASTM D 790 |
| Rockwell Hardness | R110 | - | ASTM D 785 |
| Izod Impact notched, 1/8 in | 53.4 | J/m | ASTM D 256 |

| Thermal properties | Value | Unit | Test Standard |
|--------------------|-------|------|---------------|
| ASTM Data | | | |
| DTUL @ 264 psi | 82.2 | °C | ASTM D 648 |

| Other properties | Value | Unit | Test Standard |
|------------------------|-------|-------------------|---------------|
| Water Absorption, 24hr | 1.3 | % | ASTM D 570 |
| Density | 1140 | kg/m ³ | ASTM D 792 |

| Processing Recommendation Injection Molding | Value | Unit | Test Standard |
|---|---------------|------|---------------|
| Pre-drying - Temperature | 79.4 | °C | - |
| Pre-drying - Time | 2 - 4 | h | - |
| Melt temperature | 279 - 304 | °C | - |
| Mold temperature | 37.8 - 93.3 | °C | - |
| Zone 1 | 260 - 293 | °C | - |
| Zone 2 | 266 - 293 | °C | - |
| Zone 3 | 266 - 293 | °C | - |
| Nozzle temperature | 260 - 288 | °C | - |
| Screw speed | 60 - 120 | rpm | - |
| Back pressure | 0.345 - 0.689 | MPa | - |

Characteristics

Processing

Injection Molding

Regional Availability

North America

Delivery form

Pellets