

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	30	g/10min	ASTM D 1238
Temperature	276	°C	-
Load	5	kg	-
Mold Shrinkage, MD	0.175	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	52.4	MPa	ASTM D 638
Tensile Strength at Break	46.9	MPa	ASTM D 638
Elongation at Yield	18	%	ASTM D 638
Elongation at Break	70	%	ASTM D 638
Flexural Modulus	1999	MPa	ASTM D 790
Flexural Strength	72.4	MPa	ASTM D 790
Rockwell Hardness	D75	-	ASTM D 785
Izod Impact notched, 1/8 in	854	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 264 psi	71.1	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	1.3	%	ASTM D 570
Density	1050	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	268 - 293	°C	-
Mold temperature	37.8 - 93.3	°C	-
Zone 1	249 - 282	°C	-
Zone 2	254 - 282	°C	-
Zone 3	254 - 282	°C	-
Nozzle temperature	249 - 277	°C	-
Screw speed	60 - 120	rpm	-
Back pressure	0.345 - 0.689	MPa	-

Characteristics

Processing

Injection Molding

Delivery form

Pellets

Features

Ductile

Chemical Resistance

General Chemical Resistance

Regional Availability

North America