

Product Texts

Limited resistance. Considerable dimensional changes, and possibly irreversible changes in properties after prolonged contact. Consultation advisable before use.

Please consider the information about the application of the materials.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	1.3	%	ISO 294-4, 2577
Molding shrinkage, normal	1.5	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	3000	MPa	ISO 527
Yield stress	82	MPa	ISO 527
Yield strain	4.5	%	ISO 527
Strain at break	9	%	ISO 527
Flexural modulus, 23°C	2800	MPa	ISO 178
Flexural strength	116	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	70	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	4.4	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	4.3	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	3.7	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	265	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	73	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	207	°C	ISO 75-1/-2

Other properties	Value	Unit	Test Standard
Density	1140	kg/m ³	ISO 1183

Material specific properties	Value	Unit	Test Standard
ISO Data			
Viscosity number	100 ^[1]	cm ³ /g	ISO 307, 1157, 1628
1: VN at 0.5% in sulfuric acid, nominal			

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	10 - 16	h	-
Processing humidity	≤0.2	%	-
Melt temperature	280 - 295	°C	-
Mold temperature	50 - 90	°C	-
Zone 1	250 - 270	°C	-
Zone 2	270 - 290	°C	-
Zone 3	270 - 290	°C	-
Nozzle temperature	270 - 290	°C	-
Screw speed	75 - 180	rpm	-
Back pressure	0.2 - 1	MPa	-

Characteristics

Processing

Injection Molding

Regional Availability

North America, Europe, Asia Pacific, South and Central America

Certifications

RoHS compliant