

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	4.3	g/10min	ASTM D 1238
Temperature	275	°C	-
Load	0.325	kg	-

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	4000	MPa	ISO 527
Yield stress	83	MPa	ISO 527
Yield strain	4.4	%	ISO 527
Strain at break	25	%	ISO 527
Flexural modulus, 23°C	3300	MPa	ISO 178
Flexural strength	130	MPa	ISO 178
Charpy impact strength, +23°C	42	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	6.2	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact strength, +23°C	64	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C	6.2	kJ/m <sup>2</sup>	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Melting temperature, 10°C/min	265	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	224	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	235	°C	ISO 75-1/-2

Other properties	Value	Unit	Test Standard
Density	1140	kg/m <sup>3</sup>	ISO 1183
Moisture Content	0.4	%	-

Material specific properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Viscosity number	156 <sup>[1]</sup>	cm <sup>3</sup> /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	3 - 4	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, Other Extrusion

**Certifications**

RoHS compliant

**Applications**

General Purpose

**Regional Availability**

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