

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	1.7	%	ISO 294-4, 2577
Molding shrinkage, normal	1.8	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2950	MPa	ISO 527
Yield stress	89	MPa	ISO 527
Yield strain	4.4	%	ISO 527
Strain at break	25	%	ISO 527
Flexural modulus, 23°C	2900	MPa	ISO 178
Flexural strength	97	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	5.6	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	6.1	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	4.4	kJ/m <sup>2</sup>	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Melting temperature, 10°C/min	262	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	63	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	176	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.4	mm	-

Other properties	Value	Unit	Test Standard
Humidity absorption	2.7	%	Sim. to ISO 62
Density	1140	kg/m <sup>3</sup>	ISO 1183

Material specific properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Viscosity number	300 <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	90	°C	-
Pre-drying - Time	6 - 8	h	-
Processing humidity	≤0.02	%	-
Melt temperature	280 - 290	°C	-
Mold temperature	50 - 90	°C	-
Zone 1	250 - 280	°C	-
Zone 2	275 - 290	°C	-
Zone 3	275 - 290	°C	-
Nozzle temperature	275 - 295	°C	-
Screw speed	50 - 120	rpm	-
Back pressure	0.5 - 3	MPa	-

**Characteristics**

**Processing**

Injection Molding, Other Extrusion

**Certifications**

RoHS compliant

**Additives**

Lubricants

**Regional Availability**

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

**Special Characteristics**

Heat stabilized or stable to heat