

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	1.1	%	ISO 294-4, 2577
Molding shrinkage, normal	1.1	%	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	3.9	%	ISO 527
Strain at break	45	%	ISO 527
Flexural modulus, 23°C	2700	MPa	ISO 178
Flexural strength	91	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	4.7	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	4.5	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	4.8	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	264	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	69	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	199	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	80	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	90	E-6/K	ISO 11359-1/-2

Other properties	Value	Unit	Test Standard
Humidity absorption	2.6	%	Sim. to ISO 62
Density	1140	kg/m ³	ISO 1183

Material specific properties	Value	Unit	Test Standard
ISO Data			
Viscosity number	126 ^[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	8 - 12	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

Features

Color Stability

Regional Availability

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