

**Product Texts**

Soluble or severely attacked after brief contact.

Please consider the information about the application of the materials.

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Molding shrinkage, parallel	1.0	%	ISO 294-4, 2577
Molding shrinkage, normal	1.0	%	ISO 294-4, 2577

<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Tensile Modulus	3000	MPa	ISO 527
Yield stress	85	MPa	ISO 527
Yield strain	4.3	%	ISO 527
Strain at break	26	%	ISO 527
Flexural modulus, 23°C	2900	MPa	ISO 178
Flexural strength	96	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	4.6	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	3.9	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	4	kJ/m <sup>2</sup>	ISO 180/1A

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melting temperature, 10°C/min	259	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	62	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	190	°C	ISO 75-1/-2

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

<b>Material specific properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Viscosity number	145 <sup>[1]</sup>	cm <sup>3</sup> /g	ISO 307, 1157, 1628

1: VN at 0.5% in sulfuric acid, nominal

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
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

**Applications**

General Purpose

**Delivery form**

White

**Regional Availability**

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

**Certifications**

RoHS compliant