

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

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	3100	MPa	ISO 527
Yield stress	84	MPa	ISO 527
Yield strain	4.4	%	ISO 527
Strain at break	30	%	ISO 527
Flexural modulus, 23°C	2900	MPa	ISO 178
Flexural strength	94	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	5	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	4.2	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	5	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	261	°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	185	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	90	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	90	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	V-2	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Burning behav. at thickness h	V-2	class	IEC 60695-11-10
Thickness tested	0.4	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
GWFI - thickness tested (1)	0.71	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
GWFI - thickness tested (2)	1.5	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
GWFI - thickness tested (3)	3	mm	-

Electrical properties	Value	Unit	Test Standard
ISO Data			
Comparative tracking index	600	-	IEC 60112
Other Standards^[S]			
Electric strength	18	kV/mm	UL 746A
Arc Resistance	420	s	UL 746A

S: These properties are reported by the producer according standards that are different to our defaults.

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	147 ^[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	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

Delivery form

Natural Color

Additives

Lubricants

Special Characteristics

Heat stabilized or stable to heat

Certifications

RoHS compliant

Regional Availability

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