

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	2.1	%	ISO 294-4, 2577
Molding shrinkage, normal	2.2	%	ISO 294-4, 2577
ASTM Data			
Mold Shrinkage, MD	0.013	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Strength	60	MPa	ISO 527
Flexural modulus, 23°C	2000	MPa	ISO 178
Charpy notched impact strength, +23°C	25	kJ/m ²	ISO 179/1eA
Rockwell hardness	R 101	-	ISO 2039-2
ASTM Data			
Tensile Strength	64	MPa	ASTM D 638
Flexural Modulus	1863	MPa	ASTM D 790
Flexural Strength	88	MPa	ASTM D 790
Rockwell Hardness	R 110	-	ASTM D 785
Izod Impact notched, 1/8 in	245	J/m	ASTM D 256
Thermal properties			
ISO Data			
Melting temperature, 10°C/min	255	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	74	°C	ISO 75-1/-2
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	0.8	mm	-
Coefficient of Thermal Expansion, MD	60	E-6/K	ASTM D 696
DTUL @ 66 psi	220	°C	ASTM D 648
DTUL @ 264 psi	75	°C	ASTM D 648
Melting Temperature	255	°C	ASTM D 3418
Electrical properties			
ASTM Data			
Dielectric Strength, Short Time	20	kV/mm	ASTM D 149
Dielectric Constant, 1 MHz	3.1	-	ASTM D 150
Arc Resistance	125	s	ASTM D 495
Other properties			
Density	1120	kg/m ³	ISO 1183
Water Absorption, 24hr	1	%	ASTM D 570
Density	1120	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	80 - 100	°C	-
Pre-drying - Time	4 - 5	h	-
Processing humidity	≤0.05	%	-
Mold temperature	60 - 80	°C	-
Zone 1	250	°C	-
Zone 2	260	°C	-
Zone 3	265	°C	-
Nozzle temperature	270	°C	-

Characteristics

Processing

Injection Molding

Regional Availability

North America, Asia Pacific

Special Characteristics

High impact or impact modified