

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Strength	78.6	MPa	ASTM D 638
Elongation at Break	12	%	ASTM D 638
Flexural Modulus	3447	MPa	ASTM D 790
Izod Impact notched, 1/8 in	69.4	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
DTUL @ 264 psi	207	°C	ASTM D 648
Melting Temperature	259	°C	ASTM D 3418

Other properties	Value	Unit	Test Standard
Density	1190	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	65 - 82	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.2	%	-
Melt temperature	287 - 316	°C	-
Mold temperature	49 - 93	°C	-
Zone 1	260 - 293	°C	-
Zone 2	277 - 299	°C	-
Zone 3	282 - 310	°C	-
Nozzle temperature	279 - 307	°C	-
Injection pressure	5 - 15	MPa	-
Back pressure	0 - 50	MPa	-
Holding pressure	4 - 12	MPa	-
Maximum residence time	6	min	-

**Characteristics**

**Processing**

Injection Molding

**Applications**

Automotive, General Purpose

**Special Characteristics**

High impact or impact modified

**Regional Availability**

North America