

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.015	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Yield stress	80	MPa	ISO 527
Stress at break	75	MPa	ISO 527
Strain at break	25	%	ISO 527
Flexural modulus, 23°C	2900	MPa	ISO 178
Charpy impact strength, +23°C	80	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	6	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	5	kJ/m ²	ISO 180/1A
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	90	°C	ISO 75-1/-2
Vicat softening temperature, B	240	°C	ISO 306
Glow Wire Flammability Index (GWFI)	850	°C	IEC 60695-2-12
GWFI - thickness tested (1)	2	mm	-
Electrical properties			
ISO Data			
Surface resistivity	1E15	Ohm	IEC 62631-3-2
Electric strength	18	kV/mm	IEC 60243-1
Comparative tracking index	600	-	IEC 60112
Other properties			
Density	1140	kg/m ³	ISO 1183
Water Absorption, Equilibrium	1.3	%	ASTM D 570
Processing Recommendation Injection Molding			
Pre-drying - Temperature	85	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.12	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	70 - 90	°C	-
Zone 1	250 - 260	°C	-
Zone 2	260 - 270	°C	-
Zone 3	280 - 290	°C	-
Nozzle temperature	280 - 285	°C	-
Screw speed	50 - 80	rpm	-
Back pressure	0.4 - 0.8	MPa	-
Holding pressure	6 - 8	MPa	-

Characteristics

Processing

Injection Molding

Regional Availability

Europe

Special Characteristics

U.V. stabilized or stable to weather, Heat stabilized or stable to heat