

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
Molding shrinkage, normal	1.3	%	ISO 294-4, 2577
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	3750	MPa	ISO 527
Yield stress	75	MPa	ISO 527
Izod notched impact strength, +23°C	4.5	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength Temperature	3.5	kJ/m <sup>2</sup>	ISO 180/1A
	-30	°C	-
<b>Thermal properties</b>			
<b>ISO Data</b>			
Melting temperature, 10°C/min	263	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	85	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	225	°C	ISO 75-1/-2
Vicat softening temperature, B	245	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn. Thickness tested	V-0	class	IEC 60695-11-10
	1.6	mm	-
Burning behav. at thickness h Thickness tested	V-0	class	IEC 60695-11-10
	0.8	mm	-
<b>Electrical properties</b>			
<b>ISO Data</b>			
Volume resistivity	1E13	Ohm*m	IEC 62631-3-1
Surface resistivity	1E13	Ohm	IEC 62631-3-2
Comparative tracking index	600	-	IEC 60112
<b>Other properties</b>			
Density	1190	kg/m <sup>3</sup>	ISO 1183
Moisture Content	0.2	%	-
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	90 - 100	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.2	%	-
Melt temperature	260 - 290	°C	-
Mold temperature	70 - 110	°C	-
Zone 1	260 - 280	°C	-
Zone 2	260 - 280	°C	-
Zone 3	260 - 280	°C	-
Nozzle temperature	250 - 270	°C	-
Back pressure	50 - 100	MPa	-

## Characteristics

### Processing

Injection Molding

### Delivery form

Pellets, Natural Color

### Special Characteristics

Flame retardant, Halogen-free

### Regional Availability

Europe, Near East/Africa