

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	1.9 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Stress at break	52 / 36	MPa	ISO 527
Strain at break	55 / 45	%	ISO 527
Flexural modulus, 23°C	1720 / 550	MPa	ISO 178
Flexural strength	68 / 20	MPa	ISO 178
Charpy notched impact strength, +23°C	79.9 / 120	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	79.9 / 120	kJ/m <sup>2</sup>	ISO 180/1A

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	60 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	148 / *	°C	ISO 75-1/-2

Other properties	dry / cond	Unit	Test Standard
Density	1080 / -	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	71.1	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	271 - 293	°C	-
Mold temperature	21.1 - 93.3	°C	-
Zone 1	254	°C	-
Zone 2	268	°C	-
Zone 3	285	°C	-
Nozzle temperature	266 - 282	°C	-
Screw speed	30 - 60	rpm	-
Injection pressure	82.7 - 172	MPa	-
Back pressure	0 - 0.68	MPa	-

**Characteristics**

**Processing**

Injection Molding

**Delivery form**

Pellets, Natural Color

**Additives**

Lubricants

**Special Characteristics**

High impact or impact modified, Heat stabilized or stable to heat

**Certifications**

RoHS compliant

**Regional Availability**

North America, Europe, Asia Pacific, South and Central America, Near East/Africa