

| Processing/Physical Characteristics | dry / cond | Unit | Test Standard |
|--|-------------|-------------------|-----------------|
| ISO Data | | | |
| Molding shrinkage, parallel | 1.8 / * | % | ISO 294-4, 2577 |
| Mechanical properties | | | |
| ISO Data | | | |
| Stress at break | 65 / 44 | MPa | ISO 527 |
| Strain at break | 40 / 45 | % | ISO 527 |
| Flexural modulus, 23°C | 2100 / 717 | MPa | ISO 178 |
| Flexural strength | 75.8 / 27 | MPa | ISO 178 |
| Charpy notched impact strength, +23°C | 14.9 / 35.7 | kJ/m ² | ISO 179/1eA |
| Izod notched impact strength, +23°C | 14.9 / 35.7 | kJ/m ² | ISO 180/1A |
| Thermal properties | | | |
| ISO Data | | | |
| Temp. of deflection under load, 1.80 MPa | 71 / * | °C | ISO 75-1/-2 |
| Temp. of deflection under load, 0.45 MPa | 228 / * | °C | ISO 75-1/-2 |
| ASTM Data | | | |
| DTUL @ 66 psi | 216 | °C | ASTM D 648 |
| DTUL @ 264 psi | 71.1 | °C | ASTM D 648 |
| Melting Temperature | 255 | °C | ASTM D 3418 |
| Other properties | | | |
| Density | 1100 / - | kg/m ³ | 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, U.V. stabilized or stable to weather, Heat stabilized or stable to heat

Certifications

RoHS compliant

Regional Availability

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