

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|-------------------------------------|-------|------|-----------------|
| ISO Data | | | |
| Molding shrinkage, parallel | 1.9 | % | ISO 294-4, 2577 |
| Molding shrinkage, normal | 2.0 | % | ISO 294-4, 2577 |

| Mechanical properties | Value | Unit | Test Standard |
|------------------------|-------|------|---------------|
| ISO Data | | | |
| Tensile Strength | 50 | MPa | ISO 527 |
| Flexural modulus, 23°C | 1900 | MPa | ISO 178 |
| Flexural strength | 65 | MPa | ISO 178 |

| Thermal properties | Value | Unit | Test Standard |
|--|-------|-------|-----------------|
| ISO Data | | | |
| Melting temperature, 10°C/min | 260 | °C | ISO 11357-1/-3 |
| Temp. of deflection under load, 1.80 MPa | 55 | °C | ISO 75-1/-2 |
| Burning behav. at thickness h | HB | class | IEC 60695-11-10 |
| Thickness tested | 0.8 | mm | - |

| Other properties | Value | Unit | Test Standard |
|------------------|-------|-------------------|---------------|
| Density | 1090 | kg/m ³ | ISO 1183 |

| Processing Recommendation Injection Molding | Value | Unit | Test Standard |
|---|-------------|------|---------------|
| Pre-drying - Temperature | 80 | °C | - |
| Pre-drying - Time | 2 - 4 | h | - |
| Processing humidity | ≤0.15 | % | - |
| Melt temperature | 271 - 293 | °C | - |
| Mold temperature | 71 - 93 | °C | - |
| Zone 1 | 260 - 293 | °C | - |
| Zone 2 | 260 - 293 | °C | - |
| Zone 3 | 266 - 293 | °C | - |
| Nozzle temperature | 254 - 293 | °C | - |
| Screw speed | 30 - 120 | rpm | - |
| Injection pressure | 34 - 138 | MPa | - |
| Back pressure | 0.34 - 1.03 | MPa | - |

Characteristics

Processing

Injection Molding

Regional Availability

North America

Special Characteristics

High impact or impact modified