

| Processing/Physical Characteristics                | Value    | Unit              | Test Standard  |
|--|----------|-------------------|----------------|
| <b>ASTM Data</b>                                   |          |                   |                |
| Mold Shrinkage, MD                                 | 0.014    | mm/mm             | ASTM D 955     |
| <b>Mechanical properties</b>                       |          |                   |                |
| <b>ISO Data</b>                                    |          |                   |                |
| Tensile Strength                                   | 80       | MPa               | ISO 527        |
| Flexural modulus, 23°C                             | 2600     | MPa               | ISO 178        |
| Charpy notched impact strength, +23°C              | 5.5      | kJ/m <sup>2</sup> | ISO 179/1eA    |
| Rockwell hardness                                  | R 118    | -                 | ISO 2039-2     |
| <b>ASTM Data</b>                                   |          |                   |                |
| Tensile Strength                                   | 82       | MPa               | ASTM D 638     |
| Flexural Modulus                                   | 2942     | MPa               | ASTM D 790     |
| Flexural Strength                                  | 128      | MPa               | ASTM D 790     |
| Rockwell Hardness                                  | R 120    | -                 | ASTM D 785     |
| Izod Impact notched, 1/8 in                        | 69       | J/m               | ASTM D 256     |
| <b>Thermal properties</b>                          |          |                   |                |
| <b>ISO Data</b>                                    |          |                   |                |
| Melting temperature, 10°C/min                      | 225      | °C                | ISO 11357-1/-3 |
| Temp. of deflection under load, 1.80 MPa           | 90       | °C                | ISO 75-1/-2    |
| <b>ASTM Data</b>                                   |          |                   |                |
| UL 94 Flame rating                                 | HB       | -                 | UL 94          |
| Thickness tested                                   | 0.8      | mm                | -              |
| Coefficient of Thermal Expansion, MD               | 80       | E-6/K             | ASTM D 696     |
| DTUL @ 66 psi                                      | 180      | °C                | ASTM D 648     |
| DTUL @ 264 psi                                     | 65       | °C                | ASTM D 648     |
| Melting Temperature                                | 220      | °C                | ASTM D 3418    |
| <b>Electrical properties</b>                       |          |                   |                |
| <b>ASTM Data</b>                                   |          |                   |                |
| Dielectric Strength, Short Time                    | 20       | kV/mm             | ASTM D 149     |
| Dielectric Constant, 1 MHz                         | 3.4      | -                 | ASTM D 150     |
| Arc Resistance                                     | 120      | s                 | ASTM D 495     |
| <b>Other properties</b>                            |          |                   |                |
| Density  | 1140     | kg/m <sup>3</sup> | ISO 1183       |
| Density  | 1140     | kg/m <sup>3</sup> | ASTM D 792     |
| <b>Processing Recommendation Injection Molding</b> |          |                   |                |
| Pre-drying - Temperature                           | 80 - 100 | °C                | -              |
| Pre-drying - Time                                  | 4 - 5    | h                 | -              |
| Processing humidity                                | ≤0.05    | %                 | -              |
| Mold temperature                                   | 60 - 80  | °C                | -              |
| Zone 1   | 230      | °C                | -              |
| Zone 2   | 240      | °C                | -              |
| Zone 3   | 245      | °C                | -              |
| Nozzle temperature                                 | 250      | °C                | -              |

## Characteristics

### Processing

Injection Molding

### Regional Availability

North America, Asia Pacific

### Delivery form

Black