

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	1.1	%	ISO 294-4, 2577
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	5500	MPa	ISO 527
Stress at break	95	MPa	ISO 527
Strain at break	3.5	%	ISO 527
Izod notched impact strength, +23°C	8	kJ/m <sup>2</sup>	ISO 180/1A
<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	195	°C	ISO 75-1/-2
Vicat softening temperature, B	205	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.6	mm	-
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
<b>Electrical properties</b>			
<b>ISO Data</b>			
Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface resistivity	1E14	Ohm	IEC 62631-3-2
<b>Other properties</b>			
Density	1400	kg/m <sup>3</sup>	ISO 1183
Moisture Content	0.1	%	-
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	110 - 120	°C	-
Pre-drying - Time	4 - 8	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 270	°C	-
Mold temperature	80 - 100	°C	-
Zone 1	230 - 240	°C	-
Zone 2	230 - 250	°C	-
Zone 3	240 - 260	°C	-
Nozzle temperature	240 - 260	°C	-
Back pressure	3 - 10	MPa	-

## Characteristics

### Processing

Injection Molding

### Delivery form

Pellets, Natural Color

### Regional Availability

Europe, Near East/Africa