

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	1.9	%	ISO 294-4, 2577
Molding shrinkage, normal	1.9	%	ISO 294-4, 2577
ASTM Data			
Mold Shrinkage, MD	0.022	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Strength	55	MPa	ISO 527
Flexural modulus, 23°C	2410	MPa	ISO 178
Charpy notched impact strength, +23°C	3.2	kJ/m ²	ISO 179/1eA
Rockwell hardness	R 118	-	ISO 2039-2
ASTM Data			
Tensile Strength	60	MPa	ASTM D 638
Flexural Modulus	2628	MPa	ASTM D 790
Flexural Strength	98	MPa	ASTM D 790
Rockwell Hardness	R 118	-	ASTM D 785
Izod Impact notched, 1/8 in	35	J/m	ASTM D 256
Thermal properties			
ISO Data			
Melting temperature, 10°C/min	223	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	55	°C	ISO 75-1/-2
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	0.8	mm	-
Coefficient of Thermal Expansion, MD	70	E-6/K	ASTM D 696
DTUL @ 66 psi	165	°C	ASTM D 648
DTUL @ 264 psi	55	°C	ASTM D 648
Melting Temperature	224	°C	ASTM D 3418
Electrical properties			
ASTM Data			
Dielectric Strength, Short Time	25	kV/mm	ASTM D 149
Dielectric Constant, 1 MHz	3.2	-	ASTM D 150
Arc Resistance	85	s	ASTM D 495
Other properties			
Density	1420	kg/m ³	ISO 1183
Density	1420	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	100 - 120	°C	-
Pre-drying - Time	3 - 5	h	-
Processing humidity	≤0.05	%	-
Mold temperature	60 - 80	°C	-
Zone 1	240	°C	-
Zone 2	245	°C	-
Zone 3	250	°C	-
Nozzle temperature	250	°C	-

Characteristics

Processing

Injection Molding

Regional Availability

North America, Asia Pacific

Special Characteristics

Flame retardant