

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	1.2	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.0085	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Strength	121	MPa	ISO 527
Flexural modulus, 23°C	8350	MPa	ISO 178
Charpy notched impact strength, +23°C	4.8	kJ/m <sup>2</sup>	ISO 179/1eA
Rockwell hardness	R 118	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Strength	132	MPa	ASTM D 638
Flexural Modulus	8826	MPa	ASTM D 790
Flexural Strength	206	MPa	ASTM D 790
Rockwell Hardness	R 120	-	ASTM D 785
Izod Impact notched, 1/8 in	78	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Melting temperature, 10°C/min	224	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	200	°C	ISO 75-1/-2
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
<b>ASTM Data</b>			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	0.8	mm	-
Coefficient of Thermal Expansion, MD	40	E-6/K	ASTM D 696
DTUL @ 66 psi	225	°C	ASTM D 648
DTUL @ 264 psi	200	°C	ASTM D 648
Melting Temperature	224	°C	ASTM D 3418

Electrical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Dielectric Strength, Short Time	27	kV/mm	ASTM D 149
Dielectric Constant, 1 MHz	3.7	-	ASTM D 150
Arc Resistance	110	s	ASTM D 495

Other properties	Value	Unit	Test Standard
Density	1630	kg/m <sup>3</sup>	ISO 1183
Density	1630	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
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

**Chemical Resistance**

Hydrolytically Stable

**Special Characteristics**

Flame retardant

**Regional Availability**

North America, Asia Pacific