

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	11	g/10min	ASTM D 1238
Temperature	300	°C	-
Load	1.2	kg	-
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	63.4	MPa	ASTM D 638
Tensile Strength at Break	68.9	MPa	ASTM D 638
Elongation at Yield	6	%	ASTM D 638
Elongation at Break	100	%	ASTM D 638
Flexural Modulus	2310	MPa	ASTM D 790
Flexural Strength	93.1	MPa	ASTM D 790
Rockwell Hardness	M70	-	ASTM D 785
Izod Impact notched, 1/8 in	747	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	2.79	mm	-
DTUL @ 264 psi	132	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	0.15	%	ASTM D 570
Density	1200	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	104	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	293 - 316	°C	-
Mold temperature	71.1 - 93.3	°C	-
Zone 1	271 - 293	°C	-
Zone 2	282 - 304	°C	-
Zone 3	293 - 316	°C	-
Nozzle temperature	288 - 310	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.345 - 0.689	MPa	-

Characteristics

Processing

Injection Molding

Regional Availability

North America

Special Characteristics

Flame retardant, Halogen-free