

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	6	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	64.8	MPa	ASTM D 638
Tensile Strength at Break	70.3	MPa	ASTM D 638
Elongation at Yield	7	%	ASTM D 638
Elongation at Break	140	%	ASTM D 638
Flexural Modulus	2344	MPa	ASTM D 790
Flexural Strength	97.9	MPa	ASTM D 790
Rockwell Hardness	M70	-	ASTM D 785
Izod Impact notched, 1/8 in	907	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
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	121	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	310 - 332	°C	-
Mold temperature	82.2 - 116	°C	-
Zone 1	288 - 310	°C	-
Zone 2	299 - 321	°C	-
Zone 3	310 - 332	°C	-
Nozzle temperature	304 - 327	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.345 - 0.689	MPa	-

Characteristics

Processing

Injection Molding, Other Extrusion

Delivery form

Pellets

Features

Low Odor

Regional Availability

North America