

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	30	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
Molding shrinkage, normal	0.2	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	30	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0022	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0025	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	4800	MPa	ISO 527
Yield stress	65	MPa	ISO 527
Stress at break	66	MPa	ISO 527
Strain at break	2.8	%	ISO 527
Flexural modulus, 23°C	6000	MPa	ISO 178
Flexural strength	110	MPa	ISO 178
Izod notched impact strength, +23°C	3.9	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Modulus	4700	MPa	ASTM D 638
Tensile Strength at Yield	64	MPa	ASTM D 638
Tensile Strength at Break	65	MPa	ASTM D 638
Elongation at Break	2.8	%	ASTM D 638
Flexural Modulus	5900	MPa	ASTM D 790
Flexural Strength	110	MPa	ASTM D 790
Izod Impact notched, 1/8 in	39	J/m	ASTM D 256
Izod Impact notched, 1/4 in	39	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	100	°C	ISO 75-1/-2
Vicat softening temperature, B	111	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	104	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1410	kg/m ³	ISO 1183
Density	1410	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	280	°C	-
Mold temperature	40 - 100	°C	-
Zone 1	220 - 230	°C	-
Zone 2	230 - 260	°C	-

Zone 3	240 - 280	°C	-
Nozzle temperature	250 - 280	°C	-
Screw speed	50 - 200	rpm	-
Injection pressure	49 - 250	MPa	-
Back pressure	0.5 - 2.9	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color