

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	19	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	19	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0045	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0045	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2200	MPa	ISO 527
Yield stress	61	MPa	ISO 527
Stress at break	62	MPa	ISO 527
Strain at break	93	%	ISO 527
Flexural modulus, 23°C	2350	MPa	ISO 178
Flexural strength	90	MPa	ISO 178
Charpy notched impact strength, +23°C	67	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	64	kJ/m ²	ISO 180/1A
Rockwell hardness	R 119	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2400	MPa	ASTM D 638
Tensile Strength at Yield	61	MPa	ASTM D 638
Tensile Strength at Break	59	MPa	ASTM D 638
Elongation at Break	70	%	ASTM D 638
Flexural Modulus	2300	MPa	ASTM D 790
Flexural Strength	89	MPa	ASTM D 790
Rockwell Hardness	R 119	-	ASTM D 785
Izod Impact notched, 1/8 in	640	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	93	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	104	°C	ISO 75-1/-2
Vicat softening temperature, B	109	°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-2	class	IEC 60695-11-10
Thickness tested	0.4	mm	-
ASTM Data			
UL 94 Flame rating	V-2	-	UL 94
Thickness tested	0.4	mm	-

Other properties	Value	Unit	Test Standard
Density	1200	kg/m ³	ISO 1183
Density	1200	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	≤0.04	%	-
Melt temperature	280	°C	-
Mold temperature	50 - 80	°C	-

Zone 1	250 - 260	°C	-
Zone 2	260 - 270	°C	-
Zone 3	270 - 280	°C	-
Nozzle temperature	280	°C	-
Screw speed	30 - 50	rpm	-
Injection pressure	98	MPa	-
Back pressure	1 - 2.9	MPa	-

Characteristics**Processing**

Injection Molding

Delivery form

Pellets, Natural Color

Applications

Electrical and Electronical

Regional Availability

North America, Europe, Asia Pacific