

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	<b>18</b>	g/10min	ASTM D 1238
Temperature	<b>300</b>	°C	-
Load	<b>1.2</b>	kg	-
Mold Shrinkage, MD	<b>0.006</b>	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Strength at Yield	<b>59.8</b>	MPa	ASTM D 638
Elongation at Break	<b>100</b>	%	ASTM D 638
Flexural Modulus	<b>2354</b>	MPa	ASTM D 790
Flexural Strength	<b>91.2</b>	MPa	ASTM D 790
Izod Impact notched, 1/8 in	<b>785</b>	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
UL 94 Flame rating	<b>V-2</b>	-	UL 94
Thickness tested	<b>0.4</b>	mm	-
DTUL @ 264 psi	<b>101</b>	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	<b>1190</b>	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>85 - 95</b>	°C	-
Pre-drying - Time	<b>3 - 5</b>	h	-
Processing humidity	<b>≤0.04</b>	%	-
Melt temperature	<b>245 - 285</b>	°C	-
Mold temperature	<b>70 - 90</b>	°C	-
Zone 1	<b>245 - 260</b>	°C	-
Zone 2	<b>260 - 275</b>	°C	-
Zone 3	<b>265 - 280</b>	°C	-
Nozzle temperature	<b>270 - 285</b>	°C	-
Screw speed	<b>40 - 70</b>	rpm	-
Back pressure	<b>1 - 2</b>	MPa	-

**Characteristics**

**Processing**

Injection Molding

**Applications**

IT / Business Machine

**Special Characteristics**

Flame retardant, Halogen-free, High impact or impact modified

**Regional Availability**

North America, Europe, Asia Pacific, South and Central America