

| Processing/Physical Characteristics | Value | Unit    | Test Standard |
|-------------------------------------|-------|---------|---------------|
| <b>ASTM Data</b>                    |       |         |               |
| Melt Flow Index, MFI                | 32    | g/10min | ASTM D 1238   |
| Temperature                         | 300   | °C      | -             |
| Load                                | 1.2   | kg      | -             |
| Mold Shrinkage, MD                  | 0.005 | mm/mm   | ASTM D 955    |

| Mechanical properties       | Value | Unit | Test Standard |
|-----------------------------|-------|------|---------------|
| <b>ASTM Data</b>            |       |      |               |
| Tensile Strength at Yield   | 72.6  | MPa  | ASTM D 638    |
| Elongation at Break         | 50    | %    | ASTM D 638    |
| Flexural Modulus            | 2649  | MPa  | ASTM D 790    |
| Flexural Strength           | 118   | MPa  | ASTM D 790    |
| Izod Impact notched, 1/8 in | 40.5  | J/m  | ASTM D 256    |

| Thermal properties | Value | Unit | Test Standard |
|--------------------|-------|------|---------------|
| <b>ASTM Data</b>   |       |      |               |
| UL 94 Flame rating | HB    | -    | UL 94         |
| Thickness tested   | 1.5   | mm   | -             |
| DTUL @ 66 psi      | 105   | °C   | ASTM D 648    |

| Optical properties  | Value | Unit | Test Standard |
|---------------------|-------|------|---------------|
| <b>ASTM Data</b>    |       |      |               |
| Light Transmittance | 89    | %    | ASTM D 1003   |

| Other properties | Value | Unit              | Test Standard |
|------------------|-------|-------------------|---------------|
| Density          | 1210  | kg/m <sup>3</sup> | ASTM D 792    |

| Processing Recommendation Injection Molding | Value     | Unit | Test Standard |
|---|-----------|------|---------------|
| Pre-drying - Temperature                    | 75 - 85   | °C   | -             |
| Pre-drying - Time                           | 3 - 5     | h    | -             |
| Processing humidity                         | ≤0.02     | %    | -             |
| Melt temperature                            | 235 - 265 | °C   | -             |
| Mold temperature                            | 50 - 80   | °C   | -             |
| Zone 1                                      | 220 - 240 | °C   | -             |
| Zone 2                                      | 235 - 255 | °C   | -             |
| Zone 3                                      | 250 - 265 | °C   | -             |
| Nozzle temperature                          | 250 - 265 | °C   | -             |
| Screw speed                                 | 40 - 70   | rpm  | -             |
| Back pressure                               | 1 - 4     | MPa  | -             |

**Characteristics**

**Processing**

Injection Molding

**Applications**

IT / Business Machine, Electrical and Electronical

**Special Characteristics**

Transparent

**Regional Availability**

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