

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	4000	MPa	ISO 527
Yield stress	98	MPa	ISO 527
Strain at break	45	%	ISO 527
Flexural modulus, 23°C	3800	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	6	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C	7	kJ/m <sup>2</sup>	ISO 180/1A
Shore D hardness	84.5	-	ISO 7619-1
<b>Other Standards<sup>[5]</sup></b>			
Compressive Strength	125	MPa	ISO 604

S: These properties are reported by the producer according standards that are different to our defaults.

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Melting temperature, 10°C/min	343	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	150	°C	ISO 11357-1/-2
Temp. of deflection under load, 1.80 MPa	152	°C	ISO 75-1/-2
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
GWFI - thickness tested (1)	2	mm	-
<b>Other Standards<sup>[5]</sup></b>			
Thermal Conductivity, solid state	0.29	W/(m K)	ISO 22007-4

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Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Electric strength	23	kV/mm	IEC 60243-1
Comparative tracking index	150	-	IEC 60112
<b>Other Standards<sup>[5]</sup></b>			
Dissipation factor, 1MHz	40	E-4	IEC 60250
Volume resistivity	1E14	Ohm*m	IEC 60093

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Other properties	Value	Unit	Test Standard
Water absorption	0.45	%	Sim. to ISO 62
Density	1300 <sup>[1]</sup>	kg/m <sup>3</sup>	ISO 1183

1: Crystalline

3D Data	Value	Unit	Test Standard
Tensile modulus, flat	3500 <sup>[2]</sup>	MPa	-
Tensile modulus, upright	3000 <sup>[3]</sup>	MPa	-
Yield stress, flat	70 <sup>[4]</sup>	MPa	-
Yield stress, upright	52 <sup>[5]</sup>	MPa	-

2: XY Orientation, Test method ISO 527-1 3: ZX Orientation, Test method ISO 527-1 4: XY Orientation, Test method ISO 527-2 5: ZX Orientation, Test method ISO 527-2

Processing Recommendation Extrusion	Value	Unit	Test Standard
Pre-drying - Temperature	120	°C	-
Pre-drying - Time	5	h	-
Processing humidity	≤0.02	%	-
Melt temperature	340 - 450	°C	-

## Characteristics

**Processing**

Injection Molding, Additive Manufacturing

**Delivery form**

Natural Color

**Special Characteristics**

Heat stabilized or stable to heat, Sterilizable

**Features**

Low Emission

**Chemical Resistance**

General Chemical Resistance

**Applications**

Filament for 3D Printing

**Regional Availability**

North America, Europe, Asia Pacific, South and Central America, Near East/Africa