

| Processing/Physical Characteristics | Value         | Unit    | Test Standard |
|-------------------------------------|---------------|---------|---------------|
| <b>ASTM Data</b>                    |               |         |               |
| Melt Flow Index, MFI                | <b>30</b>     | g/10min | ASTM D 1238   |
| Temperature                         | <b>260</b>    | °C      | -             |
| Load                                | <b>5</b>      | kg      | -             |
| Mold Shrinkage, MD                  | <b>0.0065</b> | mm/mm   | ASTM D 955    |

| Mechanical properties       | Value       | Unit | Test Standard |
|-----------------------------|-------------|------|---------------|
| <b>ASTM Data</b>            |             |      |               |
| Tensile Strength at Yield   | <b>61.8</b> | MPa  | ASTM D 638    |
| Elongation at Break         | <b>100</b>  | %    | ASTM D 638    |
| Flexural Modulus            | <b>2305</b> | MPa  | ASTM D 790    |
| Flexural Strength           | <b>100</b>  | MPa  | ASTM D 790    |
| Izod Impact notched, 1/8 in | <b>707</b>  | J/m  | ASTM D 256    |

| Thermal properties | Value      | Unit | Test Standard |
|--------------------|------------|------|---------------|
| <b>ASTM Data</b>   |            |      |               |
| UL 94 Flame rating | <b>V-0</b> | -    | UL 94         |
| Thickness tested   | <b>1.5</b> | mm   | -             |
| DTUL @ 264 psi     | <b>119</b> | °C   | ASTM D 648    |
| Vicat Temperature  | <b>134</b> | °C   | ASTM D 1525   |

| 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>90 - 100</b>  | °C   | -             |
| Pre-drying - Time                           | <b>3 - 5</b>     | h    | -             |
| Processing humidity                         | <b>≤0.02</b>     | %    | -             |
| Melt temperature                            | <b>270 - 300</b> | °C   | -             |
| Mold temperature                            | <b>60 - 90</b>   | °C   | -             |
| Zone 1                                      | <b>260 - 300</b> | °C   | -             |
| Zone 2                                      | <b>250 - 290</b> | °C   | -             |
| Zone 3                                      | <b>250 - 270</b> | °C   | -             |
| Nozzle temperature                          | <b>260 - 290</b> | °C   | -             |
| Screw speed                                 | <b>40 - 70</b>   | rpm  | -             |
| Back pressure                               | <b>1 - 4</b>     | MPa  | -             |

## Characteristics

### Processing

Injection Molding

### Special Characteristics

Flame retardant, Halogen-free, Heat stabilized or stable to heat

### Applications

IT / Business Machine, Electrical and Electronical

### Regional Availability

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