

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	19	g/10min	ISO 1133
Temperature	190	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.9	%	ISO 294-4, 2577
Molding shrinkage, normal	1.2	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	19	g/10min	ASTM D 1238
Temperature	190	°C	-
Load	2.16	kg	-
Mold Shrinkage, MD	0.009	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Strength	100	MPa	ISO 527
Strain at break	4	%	ISO 527
Flexural modulus, 23°C	4800	MPa	ISO 178
Charpy notched impact strength, +23°C	5.5	kJ/m ²	ISO 179/1eA
Rockwell hardness	M 96	-	ISO 2039-2
ASTM Data			
Tensile Strength	93	MPa	ASTM D 638
Elongation at Break	7	%	ASTM D 638
Flexural Modulus	4500	MPa	ASTM D 790
Flexural Strength	140	MPa	ASTM D 790
Rockwell Hardness	M 85	-	ASTM D 785
Izod Impact notched, 1/8 in	45	J/m	ASTM D 256
Thermal properties			
ISO Data			
Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	155	°C	ISO 75-1/-2
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	0.8	mm	-
Coefficient of Thermal Expansion, MD	60	E-6/K	ASTM D 696
DTUL @ 66 psi	164	°C	ASTM D 648
DTUL @ 264 psi	160	°C	ASTM D 648
Melting Temperature	166	°C	ASTM D 3418
Electrical properties			
ISO Data			
Volume resistivity	1E12	Ohm*m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Electric strength	19	kV/mm	IEC 60243-1
ASTM Data			
Dielectric Strength, Short Time	19	kV/mm	ASTM D 149
Dissipation Factor, 1 MHz	0.006	-	ASTM D 150
Surface Resistivity	>1E15	Ohm	ASTM D 257
Volume Resistivity	1E14	Ohm*cm	ASTM D 257
Other properties			
Density	1490	kg/m ³	ISO 1183
Water Absorption, 24hr	0.2	%	ASTM D 570
Density	1490	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 90	°C	-
Pre-drying - Time	3	h	-
Melt temperature	≤220	°C	-
Mold temperature	70 - 120	°C	-
Zone 1	180	°C	-
Zone 2	200	°C	-
Zone 3	200	°C	-
Nozzle temperature	210	°C	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Asia Pacific