

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	8.5	g/10min	ISO 1133
Temperature	330	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	8.5	g/10min	ASTM D 1238
Temperature	330	°C	-
Load	2.16	kg	-
Mold Shrinkage, MD	0.003	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.003	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Yield stress	150	MPa	ISO 527
Stress at break	150	MPa	ISO 527
Strain at break	3	%	ISO 527
Flexural modulus, 23°C	13500	MPa	ISO 178
Flexural strength	240	MPa	ISO 178
Charpy notched impact strength, +23°C	6	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	6	kJ/m ²	ISO 180/1A
Rockwell hardness	R 128	-	ISO 2039-2
ASTM Data			
Tensile Strength at Yield	150	MPa	ASTM D 638
Tensile Strength at Break	150	MPa	ASTM D 638
Elongation at Break	3	%	ASTM D 638
Flexural Modulus	13000	MPa	ASTM D 790
Flexural Strength	240	MPa	ASTM D 790
Rockwell Hardness	R 125	-	ASTM D 785
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	285	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.4	mm	-
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	0.4	mm	-
DTUL @ 264 psi	285	°C	ASTM D 648
Electrical properties			
ISO Data			
Comparative tracking index	500	-	IEC 60112
Other properties			
Density	1580	kg/m ³	ISO 1183
Density	1450	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.2	%	-
Melt temperature	330	°C	-
Mold temperature	100 - 130	°C	-

Zone 1	320 - 330	°C	-
Zone 2	320 - 340	°C	-
Zone 3	320 - 330	°C	-
Nozzle temperature	330	°C	-
Screw speed	200 - 250	rpm	-
Injection pressure	69 - 150	MPa	-
Back pressure	0.5 - 1	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color