

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	3	g/10min	ASTM D 1238
Mold Shrinkage, MD	0.0175	mm/mm	ASTM D 955
Mechanical properties			
ASTM Data			
Tensile Strength at Yield	27.6	MPa	ASTM D 638
Tensile Strength at Break	14.5	MPa	ASTM D 638
Elongation at Break	90	%	ASTM D 638
Flexural Modulus	1276	MPa	ASTM D 790
Flexural Strength	37.9	MPa	ASTM D 790
Izod Impact notched, 1/8 in	32	J/m	ASTM D 256
Thermal properties			
ASTM Data			
UL 94 Flame rating	V-2	-	UL 94
Thickness tested	1.6	mm	-
DTUL @ 264 psi	51.7	°C	ASTM D 648
Other properties			
Water Absorption, 24hr	0.01	%	ASTM D 570
Density	930	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	48.9	°C	-
Pre-drying - Time	2 - 4	h	-
Melt temperature	199 - 227	°C	-
Mold temperature	10 - 37.8	°C	-
Zone 1	182 - 204	°C	-
Zone 2	188 - 210	°C	-
Zone 3	193 - 216	°C	-
Nozzle temperature	199 - 227	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.345 - 0.689	MPa	-

Characteristics

Processing

Injection Molding, Other Extrusion

Regional Availability

North America

Special Characteristics

Flame retardant