

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	6	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Stress at break	65	MPa	ISO 527
Strain at break	4	%	ISO 527
Flexural modulus, 23°C	5000	MPa	ISO 178
Izod notched impact strength, +23°C	8	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	3	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	98	°C	ISO 75-1/-2
Vicat softening temperature, A	110	°C	ISO 306
Vicat softening temperature, B	101	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.6	mm	-
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	3.2	mm	-
Burning rate, FMVSS, Thickness 1 mm	28	mm/min	ISO 3795 (FMVSS 302)
Glow Wire Flammability Index (GWFI)	650	°C	IEC 60695-2-12
GWFI - thickness tested (1)	2	mm	-

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Volume resistivity	1E12	Ohm*m	IEC 62631-3-1
Surface resistivity	1E15	Ohm	IEC 62631-3-2
Electric strength	33	kV/mm	IEC 60243-1
Comparative tracking index	575	-	IEC 60112

Other properties	Value	Unit	Test Standard
Density	1170	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.1	%	-
Melt temperature	230 - 260	°C	-
Mold temperature	40 - 70	°C	-
Zone 1	220 - 230	°C	-
Zone 2	230 - 240	°C	-
Zone 3	240 - 250	°C	-
Nozzle temperature	240 - 250	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	0.3 - 0.8	MPa	-
Holding pressure	5 - 7	MPa	-

**Characteristics**

**Processing**

Injection Molding

**Regional Availability**

Europe