

| Processing/Physical Characteristics | Value  | Unit                   | Test Standard |
|-------------------------------------|--------|------------------------|---------------|
| <b>ISO Data</b>                     |        |                        |               |
| Melt volume-flow rate, MVR          | 15     | cm <sup>3</sup> /10min | ISO 1133      |
| Temperature                         | 220    | °C                     | -             |
| Load                                | 10     | kg                     | -             |
| <b>ASTM Data</b>                    |        |                        |               |
| Melt Flow Index, MFI                | 3.7    | g/10min                | ASTM D 1238   |
| Temperature                         | 230    | °C                     | -             |
| Load                                | 3.8    | kg                     | -             |
| Mold Shrinkage, MD                  | 0.0065 | mm/mm                  | ASTM D 955    |

| Mechanical properties       | Value | Unit | Test Standard |
|-----------------------------|-------|------|---------------|
| <b>ASTM Data</b>            |       |      |               |
| Tensile Modulus             | 2070  | MPa  | ASTM D 638    |
| Tensile Strength at Yield   | 41.4  | MPa  | ASTM D 638    |
| Tensile Strength at Break   | 31.7  | MPa  | ASTM D 638    |
| Elongation at Yield         | 2.1   | %    | ASTM D 638    |
| Elongation at Break         | 26    | %    | ASTM D 638    |
| Flexural Modulus            | 2140  | MPa  | ASTM D 790    |
| Flexural Strength           | 68.3  | MPa  | ASTM D 790    |
| Izod Impact notched, 1/8 in | 370   | J/m  | ASTM D 256    |

| Thermal properties | Value | Unit | Test Standard |
|--------------------|-------|------|---------------|
| <b>ASTM Data</b>   |       |      |               |
| DTUL @ 66 psi      | 97.2  | °C   | ASTM D 648    |
| DTUL @ 264 psi     | 82.2  | °C   | ASTM D 648    |
| Vicat Temperature  | 98.9  | °C   | ASTM D 1525   |

| Other properties | Value | Unit              | Test Standard |
|------------------|-------|-------------------|---------------|
| Density          | 1050  | kg/m <sup>3</sup> | ASTM D 792    |

| Processing Recommendation Injection Molding | Value         | Unit | Test Standard |
|---------------------------------------------|---------------|------|---------------|
| Pre-drying - Temperature                    | 82 - 93       | °C   | -             |
| Pre-drying - Time                           | 2 - 4         | h    | -             |
| Processing humidity                         | ≤0.1          | %    | -             |
| Mold temperature                            | 49 - 71       | °C   | -             |
| Zone 1                                      | 188 - 210     | °C   | -             |
| Zone 2                                      | 204 - 227     | °C   | -             |
| Zone 3                                      | 216 - 238     | °C   | -             |
| Nozzle temperature                          | 218 - 260     | °C   | -             |
| Back pressure                               | 0.345 - 0.689 | MPa  | -             |

## Characteristics

### Processing

Injection Molding

### Delivery form

Pellets, Natural Color

### Special Characteristics

High impact or impact modified

### Regional Availability

North America