

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.9 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.0 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	3500 / 3000	MPa	ISO 527
Stress at break	50 / 45	MPa	ISO 527
Strain at break	5 / 7	%	ISO 527
Charpy impact strength, +23°C	100 / 80	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	6 / 6	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	5 / 5	kJ/m <sup>2</sup>	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Melting temperature, 10°C/min	178 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	50 / *	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	-

Other properties	dry / cond	Unit	Test Standard
Water absorption	1.2 / *	%	Sim. to ISO 62
Humidity absorption	0.6 / *	%	Sim. to ISO 62
Density	1210 / -	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4 - 8	h	-
Processing humidity	≤0.08	%	-
Melt temperature	220 - 260	°C	-
Mold temperature	80 - 100	°C	-

**Characteristics**

**Processing**  
Injection Molding

**Chemical Resistance**  
General Chemical Resistance

**Delivery form**  
Black

**Regional Availability**  
Europe

**Special Characteristics**  
Heat stabilized or stable to heat