

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.6 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.3 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	5500 / 2500	MPa	ISO 527
Stress at break	115 / 60	MPa	ISO 527
Strain at break	6 / 12	%	ISO 527
Charpy impact strength, +23°C	50 / 95	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	45 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	6 / 12	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	5.5 / -	kJ/m ²	ISO 179/1eA

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	295 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	265 / *	°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	11.5 / *	%	Sim. to ISO 62
Humidity absorption	3.2 / *	%	Sim. to ISO 62
Density	1260 / -	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.08	%	-
Melt temperature	280 - 320	°C	-
Mold temperature	80 - 120	°C	-

Characteristics

Processing

Injection Molding

Applications

Electrical and Electronical

Delivery form

Black

Regional Availability

Europe

Special Characteristics

Heat stabilized or stable to heat