

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.7 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	4500 / 2000	MPa	ISO 527
Stress at break	80 / 45	MPa	ISO 527
Strain at break	5 / 15	%	ISO 527
Flexural modulus, 23°C	4100 / 2100	MPa	ISO 178
Flexural strength	135 / 75	MPa	ISO 178
Charpy impact strength, +23°C	70 / 95	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	80 / 80	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	20 / 35	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	10 / 10	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact strength, +23°C	60 / 90	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C	20 / 35	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength Temperature	10 / 10 -30	kJ/m <sup>2</sup> °C	ISO 180/1A -

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
Melting temperature, 10°C/min	219 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	170 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	205 / *	°C	ISO 75-1/-2

Other properties	dry / cond	Unit	Test Standard
Density	1170 / -	kg/m <sup>3</sup>	ISO 1183
Bulk density	600	kg/m <sup>3</sup>	-

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.12	%	-
Melt temperature	260 - 290	°C	-
Mold temperature	80 - 100	°C	-

## Characteristics

### Processing

Injection Molding

### Special Characteristics

High impact or impact modified

### Features

Thermal Stability

### Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa