

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|--|----------|-------------------|-----------------|
| ISO Data | | | |
| Molding shrinkage, parallel | 0.5 | % | ISO 294-4, 2577 |
| Molding shrinkage, normal | 0.6 | % | ISO 294-4, 2577 |
| ASTM Data | | | |
| Mold Shrinkage, MD | 0.009 | mm/mm | ASTM D 955 |
| Mechanical properties | | | |
| ISO Data | | | |
| Tensile Strength | 130 | MPa | ISO 527 |
| Flexural modulus, 23°C | 5200 | MPa | ISO 178 |
| Charpy notched impact strength, +23°C | 8 | kJ/m ² | ISO 179/1eA |
| Rockwell hardness | R 118 | - | ISO 2039-2 |
| ASTM Data | | | |
| Tensile Strength | 123 | MPa | ASTM D 638 |
| Flexural Modulus | 5541 | MPa | ASTM D 790 |
| Flexural Strength | 196 | MPa | ASTM D 790 |
| Rockwell Hardness | R 120 | - | ASTM D 785 |
| Izod Impact notched, 1/8 in | 108 | J/m | ASTM D 256 |
| Thermal properties | | | |
| ISO Data | | | |
| Melting temperature, 10°C/min | 225 | °C | ISO 11357-1/-3 |
| Temp. of deflection under load, 1.80 MPa | 185 | °C | ISO 75-1/-2 |
| ASTM Data | | | |
| UL 94 Flame rating | HB | - | UL 94 |
| Thickness tested | 0.8 | mm | - |
| Coefficient of Thermal Expansion, MD | 40 | E-6/K | ASTM D 696 |
| DTUL @ 66 psi | 205 | °C | ASTM D 648 |
| DTUL @ 264 psi | 190 | °C | ASTM D 648 |
| Melting Temperature | 220 | °C | ASTM D 3418 |
| Electrical properties | | | |
| ASTM Data | | | |
| Dielectric Strength, Short Time | 21 | kV/mm | ASTM D 149 |
| Dielectric Constant, 1 MHz | 3.6 | - | ASTM D 150 |
| Arc Resistance | 130 | s | ASTM D 495 |
| Other properties | | | |
| Density | 1240 | kg/m ³ | ISO 1183 |
| Water Absorption, 24hr | 0.4 | % | ASTM D 570 |
| Density | 1250 | kg/m ³ | ASTM D 792 |
| Processing Recommendation Injection Molding | | | |
| Pre-drying - Temperature | 80 - 100 | °C | - |
| Pre-drying - Time | 4 - 5 | h | - |
| Processing humidity | ≤0.05 | % | - |
| Mold temperature | 60 - 80 | °C | - |
| Zone 1 | 230 | °C | - |
| Zone 2 | 240 | °C | - |
| Zone 3 | 245 | °C | - |
| Nozzle temperature | 250 | °C | - |

Characteristics

Processing

Injection Molding

Regional Availability

North America, Asia Pacific

Special Characteristics

Heat stabilized or stable to heat