

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Tensile Modulus	8000 / 4600	MPa	ISO 527
Stress at break	110 / 60	MPa	ISO 527
Strain at break	2.8 / 6.5	%	ISO 527
Flexural modulus, 23°C	7700 / 4600	MPa	ISO 178
Flexural strength	175 / 120	MPa	ISO 178
Charpy impact strength, +23°C	48 / 50	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	10 / 10	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	10 / 10	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	45 / 45	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	10 / 12	kJ/m ²	ISO 180/1A
Thermal properties			
ISO Data			
Melting temperature, 10°C/min	222 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	200 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	218 / *	°C	ISO 75-1/-2
Vicat softening temperature, B	205 / *	°C	ISO 306
Coeff. of linear therm. expansion, parallel	30 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	90 / *	E-6/K	ISO 11359-1/-2
Burning behav. at 1.5 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	-
Burning behav. at thickness h	V-0 / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	-
Burning behav. 5V at thickness h	5VA / *	class	IEC 60695-11-20
Thickness tested	3.0 / *	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
GWFI - thickness tested (1)	0.75	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
GWFI - thickness tested (2)	1.5	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
GWFI - thickness tested (3)	3	mm	-
Glow Wire Ignition Temperature (GWIT)	750	°C	IEC 60695-2-13
GWIT - thickness tested (1)	0.75	mm	-
Glow Wire Ignition Temperature (GWIT)	750	°C	IEC 60695-2-13
GWIT - thickness tested (2)	1.5	mm	-
Glow Wire Ignition Temperature (GWIT)	750	°C	IEC 60695-2-13
GWIT - thickness tested (3)	3	mm	-
Electrical properties			
ISO Data			
Electric strength	31 / -	kV/mm	IEC 60243-1
Comparative tracking index	500 / -	-	IEC 60112
Other properties			
ISO Data			
Water absorption	5 / *	%	Sim. to ISO 62
Humidity absorption	1.5 / *	%	Sim. to ISO 62
Density	1380 / -	kg/m ³	ISO 1183
Test specimen production			
ISO Data			
Injection Molding, melt temperature	260	°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	≤0.07	%	-
Melt temperature	250 - 270	°C	-
Mold temperature	80 - 100	°C	-

Characteristics**Processing**

Injection Molding

Special Characteristics

Flame retardant, Halogen-free