

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	1.0	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Tensile Strength	120	MPa	ISO 527
Flexural modulus, 23°C	6420	MPa	ISO 178
Flexural strength	170	MPa	ISO 178
Thermal properties			
ISO Data			
Melting temperature, 10°C/min	220	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	195	°C	ISO 75-1/-2
Other properties			
Density	1280	kg/m ³	ISO 1183
Processing Recommendation Injection Molding			
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.15	%	-
Melt temperature	260 - 288	°C	-
Mold temperature	71 - 93	°C	-
Zone 1	249 - 288	°C	-
Zone 2	254 - 288	°C	-
Zone 3	260 - 288	°C	-
Nozzle temperature	243 - 288	°C	-
Screw speed	30 - 120	rpm	-
Injection pressure	34 - 138	MPa	-
Back pressure	0.34 - 1.03	MPa	-

Characteristics

Processing

Injection Molding

Regional Availability

North America

Certifications

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