

| Processing/Physical Characteristics | Value | Unit | Test Standard   |
|-------------------------------------|-------|------|-----------------|
| <b>ISO Data</b>                     |       |      |                 |
| Molding shrinkage, parallel         | 0.4   | %    | ISO 294-4, 2577 |
| Molding shrinkage, normal           | 1.0   | %    | ISO 294-4, 2577 |

| Mechanical properties  | Value | Unit | Test Standard |
|------------------------|-------|------|---------------|
| <b>ISO Data</b>        |       |      |               |
| Tensile Strength       | 145   | MPa  | ISO 527       |
| Flexural modulus, 23°C | 7300  | MPa  | ISO 178       |
| Flexural strength      | 205   | MPa  | ISO 178       |

| Thermal properties                       | Value | Unit | Test Standard  |
|--|-------|------|----------------|
| <b>ISO Data</b>                          |       |      |                |
| Melting temperature, 10°C/min            | 220   | °C   | ISO 11357-1/-3 |
| Temp. of deflection under load, 1.80 MPa | 205   | °C   | ISO 75-1/-2    |

| Other properties | Value | Unit              | Test Standard |
|------------------|-------|-------------------|---------------|
| Density          | 1320  | kg/m <sup>3</sup> | ISO 1183      |

| Processing Recommendation Injection Molding | Value       | Unit | Test Standard |
|---|-------------|------|---------------|
| 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

### Applications

Automotive