

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	10500 / -	MPa	ISO 527
Stress at break	170 / -	MPa	ISO 527
Strain at break	3 / -	%	ISO 527
Flexural modulus, 23°C	9500 / -	MPa	ISO 178
Flexural strength	250 / -	MPa	ISO 178
Charpy impact strength, +23°C	80 / -	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	65 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	12 / -	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	10 / -	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	70 / -	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	12 / -	kJ/m ²	ISO 180/1A
Izod notched impact strength	10 / -	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
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
Temp. of deflection under load, 0.45 MPa	220 / *	°C	ISO 75-1/-2
Vicat softening temperature, B	210 / *	°C	ISO 306
Coeff. of linear therm. expansion, parallel	20 / *	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	100 / *	E-6/K	ISO 11359-1/-2

Other properties	dry / cond	Unit	Test Standard
Density	1410 / -	kg/m ³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	270	°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	250 - 290	°C	-
Mold temperature	80 - 120	°C	-

Characteristics

Processing

Injection Molding

Special Characteristics

Heat stabilized or stable to heat