

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.4 / *	%	ISO 294-4, 2577

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Stress at break	188 / 121	MPa	ISO 527
Strain at break	2 / 5	%	ISO 527
Flexural modulus, 23°C	11000 / 8270	MPa	ISO 178
Flexural strength	296 / 205	MPa	ISO 178
Charpy notched impact strength, +23°C	10.1 / 14.1	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	10.1 / 14.1	kJ/m ²	ISO 180/1A

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	247 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	256 / *	°C	ISO 75-1/-2

Other properties	Value	Unit	Test Standard
Density	1490	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	71.1	°C	-
Pre-drying - Time	4	h	-
Melt temperature	271 - 293	°C	-
Mold temperature	26.7 - 93.3	°C	-
Zone 1	254	°C	-
Zone 2	268	°C	-
Zone 3	285	°C	-
Nozzle temperature	266 - 282	°C	-
Screw speed	30 - 60	rpm	-
Injection pressure	68.9	MPa	-
Back pressure	0.0689 - 0.689	MPa	-

Characteristics

Processing

Injection Molding

Delivery form

Pellets, Black

Additives

Lubricants

Special Characteristics

Heat stabilized or stable to heat

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa