

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	1.8	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Stress at break	35	MPa	ISO 527
Strain at break	65	%	ISO 527
Flexural modulus, 23°C	600	MPa	ISO 178
Flexural strength	22	MPa	ISO 178
Charpy notched impact strength, +23°C	61	kJ/m ²	ISO 179/1eA
ASTM Data			
Izod Impact notched, 1/8 in	1550	J/m	ASTM D 256
Thermal properties			
ASTM Data			
DTUL @ 66 psi	174	°C	ASTM D 648
DTUL @ 264 psi	62.8	°C	ASTM D 648
Melting Temperature	216	°C	ASTM D 3418
Other properties			
Water Absorption, 24hr	1.1	%	ASTM D 570
Density	1070	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	82.2	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	232 - 271	°C	-
Mold temperature	21.1 - 93.3	°C	-
Zone 1	216	°C	-
Zone 2	227 - 254	°C	-
Zone 3	238 - 266	°C	-
Nozzle temperature	238 - 266	°C	-
Screw speed	40 - 80	rpm	-
Injection pressure	82.7 - 172	MPa	-
Back pressure	0 - 0.345	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