

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	6	cm ³ /10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Tensile Modulus	11500	MPa	ISO 527
Stress at break	160	MPa	ISO 527
Strain at break	2.8	%	ISO 527
Charpy impact strength, +23°C	55	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	10	kJ/m ²	ISO 179/1eA
Ball indentation hardness	220	MPa	ISO 2039-1
Thermal properties			
ISO Data			
Melting temperature, 10°C/min	223	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	200	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	215	°C	ISO 75-1/-2
Temp. of deflection under load, 8.00 MPa	120	°C	ISO 75-1/-2
Vicat softening temperature, B	220	°C	ISO 306
Coeff. of linear therm. expansion, parallel	20	E-6/K	ISO 11359-1/-2
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
Electrical properties			
ISO Data			
Relative permittivity, 100Hz	4.2	-	IEC 62631-2-1
Relative permittivity, 1MHz	3.9	-	IEC 62631-2-1
Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
Surface resistivity	1E14	Ohm	IEC 62631-3-2
Comparative tracking index	250	-	IEC 60112
Other properties			
Water absorption	0.4	%	Sim. to ISO 62
Humidity absorption	0.15	%	Sim. to ISO 62
Density	1500	kg/m ³	ISO 1183
Processing Recommendation Injection Molding			
Pre-drying - Temperature	120 - 140	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	260 - 270	°C	-
Mold temperature	75 - 100	°C	-
Zone 1	250 - 265	°C	-
Nozzle temperature	260 - 270	°C	-
Screw speed	80	rpm	-
Injection pressure	60 - 100	MPa	-
Back pressure	1 - 3	MPa	-
Holding pressure	40 - 80	MPa	-
Maximum residence time	10	min	-

Characteristics

Processing

Injection Molding

Delivery form

Pellets, Natural Color

Special Characteristics

Heat stabilized or stable to heat

Features

Low Warpage

Regional Availability

Europe