

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	12.5	g/10min	ISO 1133
Temperature	250	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	12.5	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0045	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0045	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	3500	MPa	ISO 527
Yield stress	60	MPa	ISO 527
Stress at break	60	MPa	ISO 527
Strain at break	6	%	ISO 527
Flexural modulus, 23°C	3500	MPa	ISO 178
Flexural strength	90	MPa	ISO 178
Charpy notched impact strength, +23°C	10	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	10	kJ/m ²	ISO 180/1A
Rockwell hardness	R 115	-	ISO 2039-2
ASTM Data			
Tensile Modulus	3400	MPa	ASTM D 638
Tensile Strength at Yield	54	MPa	ASTM D 638
Tensile Strength at Break	54	MPa	ASTM D 638
Elongation at Break	6	%	ASTM D 638
Flexural Modulus	3400	MPa	ASTM D 790
Flexural Strength	98	MPa	ASTM D 790
Rockwell Hardness	R 115	-	ASTM D 785
Izod Impact notched, 1/8 in	98	J/m	ASTM D 256
Izod Impact notched, 1/4 in	79	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	137	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	136	°C	ISO 75-1/-2
Vicat softening temperature, B	142	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Burning behav. at thickness h	V-1	class	IEC 60695-11-10
Thickness tested	1.2	mm	-
Burning behav. 5V at thickness h	5VB	class	IEC 60695-11-20
Thickness tested	2.5	mm	-
Glow Wire Flammability Index (GWFI)	960	°C	IEC 60695-2-12
GWFI - thickness tested (1)	1.5	mm	-
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	0.75	mm	-
DTUL @ 66 psi	139	°C	ASTM D 648
DTUL @ 264 psi	140	°C	ASTM D 648

Electrical properties	Value	Unit	Test Standard
ISO Data			
Comparative tracking index	210	-	IEC 60112

Other properties	Value	Unit	Test Standard
Density	1280	kg/m ³	ISO 1183
Density	1270	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	300 - 310	°C	-
Mold temperature	80 - 90	°C	-
Zone 1	280 - 290	°C	-
Zone 2	290 - 300	°C	-
Zone 3	300 - 310	°C	-
Nozzle temperature	310	°C	-
Screw speed	50 - 100	rpm	-
Injection pressure	69	MPa	-
Back pressure	69 - 78	MPa	-

Characteristics

Processing

Injection Molding

Special Characteristics

U.V. stabilized or stable to weather

Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific