

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.1 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.4 / *	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Tensile Modulus	22800 / 21800	MPa	ISO 527
Stress at break	260 / 240	MPa	ISO 527
Strain at break	1.9 / 2	%	ISO 527
Charpy impact strength, +23°C	95 / 100	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	20 / 21	kJ/m ²	ISO 179/1eA
Thermal properties			
ISO Data			
Melting temperature, 10°C/min	265 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	235 / *	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.6 / *	mm	-
Other properties			
ISO Data			
Water absorption	3.7 / *	%	Sim. to ISO 62
Humidity absorption	1.3 / *	%	Sim. to ISO 62
Density	1680 / -	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 12	h	-
Processing humidity	≤0.08	%	-
Mold temperature	90 - 120	°C	-
Feed temperature	80	°C	-
Zone 1	285	°C	-
Zone 2	290	°C	-
Zone 3	295	°C	-
Zone 4	300	°C	-
Zone 5	295	°C	-

Characteristics

Processing

Injection Molding

Delivery form

Pellets, Natural Color

Special Characteristics

Heat stabilized or stable to heat

Certifications

RoHS compliant

Regional Availability

Europe