

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.003	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.004	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength	124	MPa	ASTM D 638
Flexural Modulus	5990	MPa	ASTM D 790
Flexural Strength	172	MPa	ASTM D 790
Rockwell Hardness	R 134	-	ASTM D 785
Izod Impact notched, 1/4 in	80	J/m	ASTM D 256
Izod Impact unnotched, 1/4 in	431	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	0.43	mm	-
Coefficient of Thermal Expansion, MD	26	E-6/K	ASTM D 696
Coefficient of Thermal Expansion, TD	48	E-6/K	ASTM D 696
DTUL @ 264 psi	210	°C	ASTM D 648
Thermal Conductivity, solid state	0.0317	W/(m K)	ASTM C 177

Electrical properties	Value	Unit	Test Standard
ASTM Data			
Volume Resistivity	>1E15	Ohm*cm	ASTM D 257
Arc Resistance	150	s	ASTM D 495

Other properties	Value	Unit	Test Standard
Density	1510	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	160 - 180	°C	-
Pre-drying - Time	5 - 24	h	-
Mold temperature	120 - 180	°C	-
Zone 1	300 - 340	°C	-
Zone 2	320 - 370	°C	-
Zone 3	330 - 380	°C	-
Nozzle temperature	330 - 380	°C	-
Screw speed	50 - 100	rpm	-
Injection pressure	100 - 200	MPa	-
Back pressure	5 - 10	MPa	-
Holding pressure	50 - 100	MPa	-

Characteristics

Processing

Injection Molding, Other Extrusion

Delivery form

Pellets

Special Characteristics

Heat stabilized or stable to heat

Features

Amorphous

Regional Availability

North America, Europe, Asia Pacific