

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	47	g/10min	ISO 1133
Temperature	250	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	47	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0055	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0055	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2100	MPa	ISO 527
Yield stress	52	MPa	ISO 527
Stress at break	45	MPa	ISO 527
Strain at break	60	%	ISO 527
Flexural modulus, 23°C	2200	MPa	ISO 178
Flexural strength	80	MPa	ISO 178
Charpy notched impact strength, +23°C	51	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	46	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	32	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-
Rockwell hardness	R 113	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Modulus	2100	MPa	ASTM D 638
Tensile Strength at Yield	53	MPa	ASTM D 638
Tensile Strength at Break	44	MPa	ASTM D 638
Elongation at Break	80	%	ASTM D 638
Flexural Modulus	2100	MPa	ASTM D 790
Flexural Strength	76	MPa	ASTM D 790
Rockwell Hardness	R 113	-	ASTM D 785
Izod Impact notched, 1/8 in	590	J/m	ASTM D 256
Izod Impact notched, 1/4 in	420	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	390	J/m	ASTM D 256
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	107 <sup>[ann.]</sup>	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	126 <sup>[ann.]</sup>	°C	ISO 75-1/-2
Vicat softening temperature, B	126	°C	ISO 306
Coeff. of linear therm. expansion, parallel	81	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	83	E-6/K	ISO 11359-1/-2
<b>ASTM Data</b>			
Coefficient of Thermal Expansion, MD	81	E-6/K	ASTM D 696
Coefficient of Thermal Expansion, TD	83	E-6/K	ASTM D 696
DTUL @ 66 psi	130	°C	ASTM D 648
DTUL @ 264 psi	110	°C	ASTM D 648

ann.: annealed

Other properties	Value	Unit	Test Standard
Density	1130	kg/m <sup>3</sup>	ISO 1183
Density	1130	kg/m <sup>3</sup>	ASTM D 792

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>90 - 100</b>	°C	-
Pre-drying - Time	<b>2 - 4</b>	h	-
Processing humidity	<b>≤0.02</b>	%	-
Melt temperature	<b>250 - 280</b>	°C	-
Mold temperature	<b>60 - 90</b>	°C	-
Zone 1	<b>210 - 230</b>	°C	-
Zone 2	<b>230 - 250</b>	°C	-
Zone 3	<b>250 - 265</b>	°C	-
Nozzle temperature	<b>250 - 280</b>	°C	-
Screw speed	<b>50 - 80</b>	rpm	-
Injection pressure	<b>59</b>	MPa	-
Back pressure	<b>0.5 - 2.5</b>	MPa	-

**Characteristics**

**Processing**

Injection Molding

**Applications**

Automotive

**Delivery form**

Pellets, Natural Color

**Regional Availability**

North America, Europe, Asia Pacific