

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	1.9	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	1.5	g/10min	ASTM D 1238
Mold Shrinkage, MD	0.019	mm/mm	ASTM D 955
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Strength	50	MPa	ISO 527
Stress at break	15	MPa	ISO 527
Flexural modulus, 23°C	2250	MPa	ISO 178
Charpy notched impact strength, +23°C	8	kJ/m <sup>2</sup>	ISO 179/1eA
Rockwell hardness	M 80	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Strength	55	MPa	ASTM D 638
Elongation at Break	20	%	ASTM D 638
Flexural Modulus	2400	MPa	ASTM D 790
Flexural Strength	83	MPa	ASTM D 790
Rockwell Hardness	M 75	-	ASTM D 785
Izod Impact notched, 1/8 in	48	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>			
Melting temperature, 10°C/min	166	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	85	°C	ISO 75-1/-2
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	0.8	mm	-
Coefficient of Thermal Expansion, MD	130	E-6/K	ASTM D 696
DTUL @ 66 psi	152	°C	ASTM D 648
DTUL @ 264 psi	106	°C	ASTM D 648
Melting Temperature	166	°C	ASTM D 3418
<b>Electrical properties</b>			
<b>ISO Data</b>			
Volume resistivity	100	Ohm*m	IEC 62631-3-1
Surface resistivity	1000	Ohm	IEC 62631-3-2
<b>ASTM Data</b>			
Surface Resistivity	1000	Ohm	ASTM D 257
Volume Resistivity	100	Ohm*cm	ASTM D 257
<b>Other properties</b>			
Density	1400	kg/m <sup>3</sup>	ISO 1183
Water Absorption, 24hr	0.22	%	ASTM D 570
Density	1400	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	80 - 90	°C	-
Pre-drying - Time	3	h	-
Melt temperature	≤220	°C	-
Mold temperature	60 - 80	°C	-
Zone 1	180	°C	-
Zone 2	190	°C	-
Zone 3	190	°C	-
Nozzle temperature	200	°C	-

**Characteristics**

**Processing**

Injection Molding

**Special Characteristics**

Increased electrical conductivity

**Delivery form**

Black

**Regional Availability**

North America, Asia Pacific