

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
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
ASTM Data			
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			
ISO Data			
Tensile Modulus	2000	MPa	ISO 527
Yield stress	55	MPa	ISO 527
Stress at break	52	MPa	ISO 527
Strain at break	40	%	ISO 527
Flexural modulus, 23°C	2180	MPa	ISO 178
Flexural strength	85	MPa	ISO 178
Charpy notched impact strength, +23°C	50	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	50	kJ/m ²	ISO 180/1A
Rockwell hardness	R 118	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2000	MPa	ASTM D 638
Tensile Strength at Yield	57	MPa	ASTM D 638
Tensile Strength at Break	49	MPa	ASTM D 638
Elongation at Break	50	%	ASTM D 638
Flexural Modulus	2000	MPa	ASTM D 790
Flexural Strength	77	MPa	ASTM D 790
Rockwell Hardness	R 118	-	ASTM D 785
Izod Impact notched, 1/8 in	490	J/m	ASTM D 256
Izod Impact notched, 1/4 in	290	J/m	ASTM D 256
Thermal properties			
ISO Data			
Vicat softening temperature, B	134	°C	ISO 306
Other properties			
Density	1190	kg/m ³	ISO 1183
Density	1190	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	90 - 110	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 280	°C	-
Mold temperature	60 - 90	°C	-
Zone 1	210 - 230	°C	-
Zone 2	230 - 250	°C	-
Zone 3	250 - 265	°C	-
Nozzle temperature	280	°C	-
Screw speed	50 - 100	rpm	-
Injection pressure	93	MPa	-
Back pressure	0.5 - 2.9	MPa	-

Characteristics**Processing**

Injection Molding

Applications

Automotive

Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific

Special Characteristics

Heat stabilized or stable to heat