

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	44	g/10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	8.6	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	2.16	kg	-
Mold Shrinkage, MD	0.007	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.007	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	1900	MPa	ISO 527
Yield stress	51	MPa	ISO 527
Yield strain	4.9	%	ISO 527
Stress at break	45	MPa	ISO 527
Strain at break	120	%	ISO 527
Flexural modulus, 23°C	2030	MPa	ISO 178
Flexural strength	76	MPa	ISO 178
Charpy notched impact strength, +23°C	44^[1]	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	17^[1]	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	43^[1]	kJ/m ²	ISO 180/1A
Izod notched impact strength	11^[1]	kJ/m ²	ISO 180/1A
Temperature	-40	°C	-
Rockwell hardness	R 115	-	ISO 2039-2
ASTM Data			
Tensile Modulus	1950	MPa	ASTM D 638
Tensile Strength at Yield	53	MPa	ASTM D 638
Tensile Strength at Break	48	MPa	ASTM D 638
Elongation at Yield	4.9	%	ASTM D 638
Elongation at Break	120	%	ASTM D 638
Flexural Modulus	2007	MPa	ASTM D 790
Flexural Strength	85.8	MPa	ASTM D 790
Rockwell Hardness	R 115	-	ASTM D 785
Izod Impact notched, 1/8 in	471	J/m	ASTM D 256
Izod Impact notched, 1/4 in	226	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	128	J/m	ASTM D 256
Temperature	-30	°C	-

1: 4 mm

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	97^[2]	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	117^[2]	°C	ISO 75-1/-2
Vicat softening temperature, B	116	°C	ISO 306
Coeff. of linear therm. expansion, parallel	89	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	92	E-6/K	ISO 11359-1/-2
ASTM Data			
Coefficient of Thermal Expansion, MD	89	E-6/K	ASTM D 696
Coefficient of Thermal Expansion, TD	92	E-6/K	ASTM D 696
DTUL @ 66 psi	122	°C	ASTM D 648
DTUL @ 264 psi	103	°C	ASTM D 648
Vicat Temperature	116	°C	ASTM D 1525

2: 4 mm

Electrical properties	Value	Unit	Test Standard
ISO Data			
Volume resistivity	1E15	Ohm*m	IEC 62631-3-1
Surface resistivity	1E15	Ohm	IEC 62631-3-2
ASTM Data			
Dielectric Strength, Short Time	19	kV/mm	ASTM D 149
Surface Resistivity	1E17	Ohm	ASTM D 257
Volume Resistivity	1E15	Ohm*cm	ASTM D 257

Other properties	Value	Unit	Test Standard
Humidity absorption	0.2	%	Sim. to ISO 62
Density	1130	kg/m ³	ISO 1183
Density	1130	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 100	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 275	°C	-
Mold temperature	50 - 70	°C	-
Zone 1	240 - 270	°C	-
Zone 2	245 - 275	°C	-
Zone 3	245 - 275	°C	-
Nozzle temperature	245 - 275	°C	-

Characteristics

Processing

Injection Molding

Special Characteristics

U.V. stabilized or stable to weather

Applications

General Purpose

Regional Availability

North America, Europe, Asia Pacific, South and Central America