

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	6	g/10min	ASTM D 1238
Temperature	230	°C	-
Load	2.16	kg	-
Mold Shrinkage, MD	0.011	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Shore D hardness	68	-	ISO 7619-1
<b>ASTM Data</b>			
Tensile Strength	29	MPa	ASTM D 638
Elongation at Break	10	%	ASTM D 638
Flexural Modulus	3200	MPa	ASTM D 790
Flexural Strength	48	MPa	ASTM D 790
Izod Impact notched, 1/8 in	40	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	250	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.6	mm	-
Coefficient of Thermal Expansion, MD	60	E-6/K	ASTM D 696
DTUL @ 66 psi	137	°C	ASTM D 648
DTUL @ 264 psi	83	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1240	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	85 - 90	°C	-
Pre-drying - Time	2 - 4	h	-
Melt temperature	220 - 270	°C	-
Mold temperature	50 - 80	°C	-
Zone 1	195 - 215	°C	-
Zone 2	205 - 225	°C	-
Zone 3	215 - 235	°C	-
Screw speed	40 - 60	rpm	-
Injection pressure	60 - 140	MPa	-
Back pressure	0.1 - 0.5	MPa	-

**Characteristics**

**Processing**

Injection Molding

**Delivery form**

Pellets

**Special Characteristics**

Heat stabilized or stable to heat

**Features**

Homopolymer

**Regional Availability**

Asia Pacific