

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Tensile Modulus	14700	MPa	ISO 527
Stress at break	195	MPa	ISO 527
Strain at break	1.9	%	ISO 527
Flexural modulus, 23°C	14500	MPa	ISO 178
Charpy impact strength, +23°C	53	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	10	kJ/m ²	ISO 179/1eA
Rockwell hardness	M100	-	ISO 2039-2
ASTM Data			
Taber Abrasion Resistance	50	mg/1000 cycles	ASTM D 1044
Thermal properties			
ISO Data			
Melting temperature, 10°C/min	280	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	90	°C	ISO 11357-1/-2
Temp. of deflection under load, 1.80 MPa	270	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.6	mm	-
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.4	mm	-
Oxygen index	47	%	ISO 4589-1/-2
Electrical properties			
ISO Data			
Relative permittivity, 1MHz	4.1	-	IEC 62631-2-1
Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
Electric strength	24	kV/mm	IEC 60243-1
Comparative tracking index	125	-	IEC 60112
Other properties			
Humidity absorption	0.02	%	Sim. to ISO 62
Density	1650	kg/m ³	ISO 1183
Processing Recommendation Injection Molding			
Pre-drying - Temperature	130 - 140	°C	-
Pre-drying - Time	3 - 4	h	-
Melt temperature	320 - 340	°C	-
Mold temperature	120 - 150	°C	-
Zone 1	300 - 340	°C	-
Nozzle temperature	320 - 340	°C	-
Screw speed	50 - 120	rpm	-
Injection pressure	50 - 100	MPa	-
Holding pressure	30 - 70	MPa	-
Maximum residence time	10	min	-

Characteristics

Processing

Injection Molding

Chemical Resistance

General Chemical Resistance

Delivery form

Natural Color

Regional Availability

Europe

Special Characteristics

Flame retardant, Heat stabilized or stable to heat