

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
Molding shrinkage, normal	1.1	%	ISO 294-4, 2577
ASTM Data			
Mold Shrinkage, MD	0.0025	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Strength	165	MPa	ISO 527
Flexural modulus, 23°C	13500	MPa	ISO 178
Charpy notched impact strength, +23°C	8	kJ/m ²	ISO 179/1eA
Rockwell hardness	R 120	-	ISO 2039-2
ASTM Data			
Flexural Modulus	13730	MPa	ASTM D 790
Flexural Strength	255	MPa	ASTM D 790
Rockwell Hardness	R 122	-	ASTM D 785
Izod Impact notched, 1/8 in	88	J/m	ASTM D 256
Thermal properties			
ISO Data			
Melting temperature, 10°C/min	285	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	265	°C	ISO 75-1/-2
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	0.8	mm	-
Coefficient of Thermal Expansion, MD	220	E-6/K	ASTM D 696
DTUL @ 264 psi	265	°C	ASTM D 648
Melting Temperature	285	°C	ASTM D 3418
Electrical properties			
ISO Data			
Volume resistivity	>1E13	Ohm*m	IEC 62631-3-1
Comparative tracking index	170	-	IEC 60112
ASTM Data			
Dielectric Strength, Short Time	16	kV/mm	ASTM D 149
Dielectric Constant, 1 MHz	4	-	ASTM D 150
Arc Resistance	120	s	ASTM D 495
Other properties			
Value			
Density	1650	kg/m ³	ISO 1183
Density	1650	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Value			
Pre-drying - Temperature	120 - 130	°C	-
Pre-drying - Time	3 - 5	h	-
Processing humidity	≤0.05	%	-
Mold temperature	120 - 140	°C	-
Zone 1	230 - 250	°C	-
Zone 2	290 - 310	°C	-
Zone 3	290 - 310	°C	-
Nozzle temperature	300 - 320	°C	-

Characteristics

Processing

Injection Molding

Regional Availability

North America, Asia Pacific

Special Characteristics

Heat stabilized or stable to heat