

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	5	g/10min	ASTM D 1238
Temperature	230	°C	-
Load	2.16	kg	-
Mold Shrinkage, MD	0.017	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength	22	MPa	ASTM D 638
Flexural Modulus	1000	MPa	ASTM D 790
Izod Impact notched, 1/8 in	600	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	90	J/m	ASTM D 256
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 66 psi	90	°C	ASTM D 648
DTUL @ 264 psi	52	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	900	kg/m ³	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 - 260	°C	-
Mold temperature	30 - 70	°C	-
Zone 1	180 - 240	°C	-
Zone 2	190 - 250	°C	-
Zone 3	210 - 260	°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

High impact or impact modified, U.V. stabilized or stable to weather

Regional Availability

Asia Pacific