

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	1.8	%	ISO 294-4, 2577
Molding shrinkage, normal	2.0	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Strength	70	MPa	ISO 527
Flexural modulus, 23°C	2700	MPa	ISO 178
Flexural strength	90	MPa	ISO 178

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	260	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	65	°C	ISO 75-1/-2

Other properties	Value	Unit	Test Standard
Density	1140	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.15	%	-
Melt temperature	271 - 293	°C	-
Mold temperature	71 - 93	°C	-
Zone 1	260 - 293	°C	-
Zone 2	260 - 293	°C	-
Zone 3	266 - 293	°C	-
Nozzle temperature	254 - 293	°C	-
Screw speed	30 - 120	rpm	-
Injection pressure	34 - 138	MPa	-
Back pressure	0.34 - 1.03	MPa	-

Characteristics

Processing

Injection Molding

Regional Availability

North America