

Physical	Method	Typical Value	Units
Density (23°C)	ISO 1183A	1.08	g/cm ³
Mass Flow Rate (280°C / 2.16kg)	ISO 1133	3.5	g/10 min
Mass Flow Rate (280°C / 5.0kg)	ISO 1133	9.0	g/10 min
Mold Shrinkage (3.2 mm, w/flow)	CPPT Method	1.2	%
Mold Shrinkage (3.2 mm, x/flow)	CPPT Method	1.1	%
Moisture Absorption (23°C, 50% RH, equilibrium)	CPPT Method	1.0	%
Water Absorption (23°C, immersed, equilibrium)	CPPT Method	3.6	%
Impact			
Izod Impact Strength (4 mm, notched, 23°C)	ISO 180/A	9.0	kJ/m ²
Izod Impact Strength (4 mm, notched, -30°C)	ISO 180/A	6.0	kJ/m ²
Charpy Impact Strength (4 mm, notched, 23°C)	ISO 179/1eA	8.0	kJ/m ²
Charpy Impact Strength (4 mm, notched, -30°C)	ISO 179/1eA	5.0	kJ/m ²
Mechanical			
Tensile Strength (50 mm/min, yield)	ISO 527-2	55.0	MPa
Tensile Elongation (50 mm/min, yield)	ISO 527-2	7.0	%
Tensile Strength (50 mm/min, break)	ISO 527-2	50.0	MPa
Tensile Elongation (50 mm/min, break)	ISO 527-2	70.0	%
Tensile Modulus (1 mm/min)	ISO 527-2	2200	MPa
Flexural Strength (2 mm/min)	ISO 178A	75.0	MPa
Flexural Modulus (2 mm/min)	ISO 178A	2000	MPa
Thermal			
Heat Deflection Temperature (455 kPa)	ISO 75-2	148.0	°C
Heat Deflection Temperature (1820 kPa)	ISO 75-2	102.0	°C
Vicat Softening Temperature (Method B50)	ISO 306	158.0	°C

Information provided is based on typical values from reliable procedures. Values are based on natural or black materials unless otherwise noted. No guarantees or warranties of any kind are expressed or implied. Users are responsible for determining the suitability of the product for their intended application.

Recommended Processing Parameters

Drying Temperature	95°C	200°F
Drying Time, (do not over-dry)	2.0 - 6.0 hrs	2.0 - 6.0 hrs
Minimum Moisture Content	0.02%	0.02%
Maximum Moisture Content	0.08%	0.08%
Rear Temperature	260 - 270°C	500 - 520°F
Middle Temperature	265 - 280°C	510 - 535°F
Front Temperature	275 - 290°C	530 - 560°F
Nozzle Temperature	280 - 295°C	535 - 565°F
Processing (Melt) Temperature	275 - 300°C	530 - 570°F
Mold Temperature	50 - 95°C	120 - 210°F

CPPT recommended processing parameters are meant to serve as guidelines only and are not intended to be used for specification purposes. Conditions should be adjusted to optimize material performance with the equipment part design and tooling.