

**General Information**

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Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Test Standards Available	<ul style="list-style-type: none"> <li>ASTM</li> </ul>
Additive	<ul style="list-style-type: none"> <li>Heat Stabilizer</li> <li>Lubricant</li> <li>UV Stabilizer</li> </ul>
Features	<ul style="list-style-type: none"> <li>Heat Stabilized</li> <li>Lubricated</li> <li>UV Resistance, Good</li> </ul>
Forms	<ul style="list-style-type: none"> <li>Pellets</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

**ASTM and ISO Properties <sup>1</sup>**

Physical	Nominal Value Unit	Test Method
Density -Specific Gravity	1.14 sp gr 23/23°C	ASTM D792
Mold Shrink, Linear-Flow	0.013 to 0.015 in/in	ASTM D955
Mechanical	Nominal Value Unit	Test Method
Tensile Strength,Ultimate <sup>2</sup>	11500 psi	ASTM D638
Flexural Modulus (2.00 in Span ) <sup>3</sup>	360000 psi	ASTM D790
Impact	Nominal Value Unit	Test Method
Notched Izod Impact (73 °F, 0.125 in ) <sup>4</sup>	0.800 ft-lb/in	ASTM D256
Thermal	Nominal Value Unit	Test Method
DTUL @264psi - Unannealed (0.250 in )	170 °F	ASTM D648
Melting Point	480 °F	

**Processing Information**

Injection	Nominal Value Unit
Drying Temperature	180 °F
Drying Time	2.0 hr
Drying Time, Maximum	8.0 hr
Suggested Shot Size	40 to 80 %
Rear Temperature	480 to 540 °F
Middle Temperature	500 to 550 °F
Front Temperature	520 to 580 °F
Nozzle Temperature	520 to 580 °F
Processing (Melt) Temp	520 to 580 °F
Mold Temperature	150 to 230 °F
Back Pressure	25.0 to 150 psi
Screw Speed	50 to 150 rpm



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The information presented on this data sheet was acquired by IDES from various sources, including the producer of the material and recognized testing agencies. In some cases, material updates have been integrated directly into the IDES Plastics Database by the material producer utilizing the Data Maintenance Tool IDES makes substantial efforts to assure the accuracy of this data. However, IDES assumes no responsibility for the data values and urges that upon final material selection, data points are validated with the manufacturer.

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Notes

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<sup>1</sup> Typical properties: these are not to be construed as specifications.

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<sup>2</sup> 2.0 in/min, 0.125 in

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<sup>3</sup> 0.050 in/min, 0.125 in

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<sup>4</sup> Method A

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