

Xyron® PROPERTIES (ASTM) –Reinforced–

Property		Units	Test method	Test Condition	Grade	Standard, Glass Fiber			Flame Retardant, Glass Fiber			High-Flow Chassis	
						G701H	G702H	G703H	G701V	G702V	G703V	X1561	X1762
Physical	Specific gravity		ASTM D 792	23°C		1.13	1.20	1.30	1.15	1.22	1.30	1.16	1.22
	Moisture Absorption	%	ASTM D 570	23°C 50%RH 24Hr.		0.06	0.06	0.06	0.06	0.06	0.06	0.06	0.06
Thermal	Heat Deflection Temperature	°C	ASTM D 648	1.82MPa		130	140	140	130	140	140	100	120
	Coefficient Linear Thermal Expansion	mm/mm/°C	ASTM D 696	-30°C ~65°C		5.0x10 ⁻⁵	3.5x10 ⁻⁵	3.0x10 ⁻⁵	5.0x10 ⁻⁵	3.5x10 ⁻⁵	3.0x10 ⁻⁵	5.5x10 ⁻⁵	5.0x10 ⁻⁵
	Moulding shrinkage	%	ASTM D 955			0.3~0.5	0.2~0.4	0.2~0.3	0.3~0.5	0.2~0.4	0.1~0.3	0.3~0.5	0.25~0.50
	Flammability			UL 94	1.6mm	HB	HB	HB	V-1	V-1	V-1	V-0	V-0
3.2mm					HB	HB	HB	V-1 *	V-1	V-1	V-0	V-0	
Electrical	Dielectric Constant		ASTM D 150	23°C 50%RH 60Hz	2.9	3.1	3.3	3.0	3.2	3.4	3.1	3.2	
				23°C 50%RH 10 ⁶ Hz	2.9	3.1	3.3	3.0	3.2	3.4	3.0	3.1	
	Dissipation Factor		ASTM D 150	23°C 50%RH 60Hz	0.0004	0.0006	0.0009	0.002	0.003	0.005	0.003	0.004	
				23°C 50%RH 10 ⁶ Hz	0.0008	0.0011	0.0015	0.003	0.005	0.008	0.005	0.006	
	Volume Resistivity	Ω • cm	ASTM D 257	23°C 50% RH	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶
	Surface Resistivity	Ω	ASTM D 257	23°C 50% RH	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶
	Dielectric Strength	kV/mm	ASTM D 149	Short time, 2mm	41	43	44	41	43	40	-	-	
	Arc Resistance	sec	ASTM D 495	Tungsten	70	70	70	70	70	70	-	-	
Mechanical	Tensile Strength	MPa	ASTM D 638	23°C 50% RH	75	94	110	78	94	110	73	81	
	Elongation at Break	%	ASTM D 638	23°C 50% RH	5	5	5	5	5	5	5	5	
	Flexural Strength	MPa	ASTM D 790	23°C 50% RH	118	137	147	127	137	147	95	115	
	Flexural Modulus	MPa	ASTM D 790	23°C 50% RH	3720	5000	6660	3920	5000	6660	4030	5290	
	Izod Impact Strength (notched)	J/m	ASTM D 256	6.4mm 23°C	98	78	78	98	78	78	39	39	
3.2mm 23°C				118	98	98	118	98	98	49	49		
Molding Conditions	Resin Temperature	°C			250~290	260~290	260~300	260~300	260~300	260~300	240~280	250~300	
	Mold Temperature	°C			80~120	80~120	80~120	80~120	80~120	80~120	60~90	70~90	
	Pre-Drying Temperature	°C			90~100	90~100	90~100	90~100	90~100	90~100	100	100	
	Drying Time	Hr			2~4	2~4	2~4	2~4	2~4	2~4	2~4	2~4	
					GF10%	GF20%	GF30%	GF10% *2.4mm5VA	GF20%	GF30%	Filler10%	Filler20%	

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Property		Units	Test method	Test Condition	Grade	High-Flow Chassis			Low-Gas, High-Flow Chassis			
						X1763	X1774	X1784	L542V	L543V	L544V	L564V
Physical	Specific gravity		ASTM D 792	23°C		1.32	1.43	1.43	1.22	1.32	1.43	1.43
	Moisture Absorption	%	ASTM D 570	23°C 50%RH 24Hr.		0.06	0.06	0.06	0.06	0.06	0.06	0.06
Thermal	Heat Deflection Temperature	°C	ASTM D 648	1.82MPa		120	120	120	120	120	120	120
	Coefficient Linear Thermal Expansion	mm/mm/°C	ASTM D 696	-30°C ~65°C		4.0x10 ⁻⁵	3.5x10 ⁻⁵	3.5x10 ⁻⁵	5.0x10 ⁻⁵	4.0x10 ⁻⁵	3.5x10 ⁻⁵	3.5x10 ⁻⁵
	Moulding shrinkage	%	ASTM D 955			0.20~0.45	0.11~0.39	0.12~0.32	0.25~0.50	0.20~0.45	0.10~0.40	0.10~0.40
	Flammability			UL 94	1.6mm		V-0	V-0	V-0	V-1	V-1	V-1
3.2mm						V-0	-	-	(V-1)	(V-1)	(V-1)	(V-1)
Electrical	Dielectric Constant		ASTM D 150	23°C 50%RH 60Hz		3.3	3.4	3.4	3.2	3.3	3.4	3.4
				23°C 50%RH 10 ⁶ Hz		3.2	3.3	3.3	3.1	3.2	3.3	3.3
	Dissipation Factor		ASTM D 150	23°C 50%RH 60Hz		0.006	0.0070	0.0070	0.004	0.006	0.007	0.007
				23°C 50%RH 10 ⁶ Hz		0.008	0.0090	0.0090	0.006	0.008	0.009	0.009
	Volume Resistivity	Ω • cm	ASTM D 257	23°C 50% RH		10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶
	Surface Resistivity	Ω	ASTM D 257	23°C 50% RH		10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶
	Dielectric Strength	kV/mm	ASTM D 149	Short time, 2mm		-	-	-	-	-	-	-
	Arc Resistance	sec	ASTM D 495	Tungsten		-	-	-	-	-	-	-
Mechanical	Tensile Strength	MPa	ASTM D 638	23°C 50% RH		93	79	78	87	90	92	68
	Elongation at Break	%	ASTM D 638	23°C 50% RH		5	3	3	4	4	3	3
	Flexural Strength	MPa	ASTM D 790	23°C 50% RH		127	119	118	122	128	131	104
	Flexural Modulus	MPa	ASTM D 790	23°C 50% RH		7110	8250	8620	5570	7250	9060	8710
	Izod Impact Strength (notched)	J/m	ASTM D 256	6.4mm 23°C		39	29	29	42	42	43	29
3.2mm 23°C					49	-	-	-	-	-	-	
Molding Conditions	Resin Temperature	°C				250~300	250~310	250~310	250~300	250~300	250~300	250~300
	Mold Temperature	°C				70~90	60~100	60~100	70~90	70~90	70~90	70~90
	Pre-Drying Temperature	°C				100	100	100	100	100	100	100
	Drying Time	Hr				2~4	2~4	2~4	2~4	2~4	2~4	2~4
						Filler30%	Filler40%	Filler40%	Filler20% ()3.0mm	Filler30% ()3.0mm	Filler40% ()3.0mm	Filler40% ()3.0mm

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					Low-Wrap Chassis						
Property	Units	Test method	Test Condition	Grade	X332V	X332Z	X333V	X333Z	X532V	X532Z	X533V
					Physical	Specific gravity		ASTM D 792	23°C	1.20	1.20
Moisture Absorption	%	ASTM D 570	23°C 50%RH 24Hr.	0.06		0.06	0.06	0.06	0.06	0.06	0.06
Thermal	Heat Deflection Temperature	°C	ASTM D 648	1.82MPa	100	100	100	100	120	120	120
	Coefficient Linear Thermal Expansion	mm/mm/°C	ASTM D 696	-30°C ~65°C	5.0x10 ⁻⁵	5.0x10 ⁻⁵	4.0x10 ⁻⁵	4.0x10 ⁻⁵	5.0x10 ⁻⁵	5.0x10 ⁻⁵	4.0x10 ⁻⁵
	Moulding shrinkage	%	ASTM D 955		0.30~0.50	0.30~0.50	0.15~0.35	0.15~0.35	0.25~0.50	0.20~0.45	0.20~0.45
	Flammability		UL 94	1.6mm	V-1	V-0	V-1	V-0	V-1	V-0	V-1
3.2mm				V-1	V-0*	V-1	V-0*	V-1	V-0*	V-1	
Electrical	Dielectric Constant		ASTM D 150	23°C 50%RH 60Hz	3.2	3.2	3.3	3.3	3.2	3.2	3.3
				23°C 50%RH 10 ⁶ Hz	3.1	3.1	3.2	3.2	3.1	3.1	3.2
	Dissipation Factor		ASTM D 150	23°C 50%RH 60Hz	0.004	0.004	0.006	0.006	0.004	0.004	0.006
				23°C 50%RH 10 ⁶ Hz	0.006	0.006	0.008	0.008	0.006	0.006	0.008
	Volume Resistivity	Ω • cm	ASTM D 257	23°C 50% RH	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶
	Surface Resistivity	Ω	ASTM D 257	23°C 50% RH	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶
	Dielectric Strength	kV/mm	ASTM D 149	Short time, 2mm	–	–	–	–	–	–	–
	Arc Resistance	sec	ASTM D 495	Tungsten	–	–	–	–	–	–	–
Mechanical	Tensile Strength	MPa	ASTM D 638	23°C 50% RH	73	74	84	84	86	86	108
	Elongation at Break	%	ASTM D 638	23°C 50% RH	5	5	5	5	5	5	5
	Flexural Strength	MPa	ASTM D 790	23°C 50% RH	113	113	129	129	123	123	137
	Flexural Modulus	MPa	ASTM D 790	23°C 50% RH	4900	4900	7740	7740	5290	5290	7840
	Izod Impact Strength (notched)	J/m	ASTM D 256	6.4mm 23°C	49	49	39	39	39	39	39
				3.2mm 23°C	59	59	49	49	49	49	49
Molding Conditions	Resin Temperature	°C			260~300	260~300	260~300	260~300	270~310	270~300	270~300
	Mold Temperature	°C			50~80	50~80	50~80	50~80	70~100	70~100	70~100
	Pre-Drying Temperature	°C			80~100	80~100	80~100	80~100	100	100	100
	Drying Time	Hr			2~4	2~4	2~4	2~4	2~4	2~4	2~4
					Filler20%	Filler20% *2.5mm5VA	Filler30%	Filler30% *2.5mm5VA	Filler20%	Filler20% *2.5mm5VA	Filler30%

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Property		Units	Test method	Test Condition	Grade	Low-Wrap Chassis			Precision Chassis			
						X533Z	X534Z	X643V	X1519	X1511	X1711	X304H
Physical	Specific gravity		ASTM D 792	23°C		1.30	1.42	1.30	1.30	1.42	1.42	1.38
	Moisture Absorption	%	ASTM D 570	23°C 50%RH 24Hr.		0.06	0.06	0.06	0.05	0.05	0.05	0.05
Thermal	Heat Deflection Temperature	°C	ASTM D 648	1.82MPa		120	120	130	100	100	110	100
	Coefficient Linear Thermal Expansion	mm/mm/°C	ASTM D 696	-30°C ~65°C		4.0x10 ⁻⁵	3.5x10 ⁻⁵	3.5x10 ⁻⁵	3.5x10 ⁻⁵	3.0x10 ⁻⁵	3.0x10 ⁻⁵	3.5x10 ⁻⁵
	Moulding shrinkage	%	ASTM D 955			0.20~0.45	0.10~0.40	0.20~0.50	0.20~0.35	0.15~0.30	0.15~0.30	0.10~0.40
	Flammability			UL 94	1.6mm		V-0	V-0	V-1	V-1	V-0	V-0
3.2mm						V-0*	V-0	V-1	V-1	V-0	V-0	HB
Electrical	Dielectric Constant		ASTM D 150	23°C 50%RH 60Hz		3.3	3.4	3.3	3.3	3.4	3.4	3.4
				23°C 50%RH 10 ⁶ Hz		3.2	3.3	3.2	3.2	3.3	3.3	3.3
	Dissipation Factor		ASTM D 150	23°C 50%RH 60Hz		0.006	0.007	0.007	0.005	0.006	0.006	0.007
				23°C 50%RH 10 ⁶ Hz		0.008	0.009	0.009	0.008	0.009	0.009	0.009
	Volume Resistivity	Ω • cm	ASTM D 257	23°C 50% RH		10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶
	Surface Resistivity	Ω	ASTM D 257	23°C 50% RH		10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶
	Dielectric Strength	kV/mm	ASTM D 149	Short time, 2mm		–	–	–	–	–	–	–
	Arc Resistance	sec	ASTM D 495	Tungsten		–	–	–	–	–	–	–
Mechanical	Tensile Strength	MPa	ASTM D 638	23°C 50% RH		108	123	84	72	78	83	62
	Elongation at Break	%	ASTM D 638	23°C 50% RH		5	5	3	4	3	3	4
	Flexural Strength	MPa	ASTM D 790	23°C 50% RH		137	152	143	110	118	118	92
	Flexural Modulus	MPa	ASTM D 790	23°C 50% RH		7840	8820	7440	6470	8330	8040	7330
	Izod Impact Strength (notched)	J/m	ASTM D 256	6.4mm 23°C		39	39	39	29	29	29	43
3.2mm 23°C					49	49	49	39	39	39	–	
Molding Conditions	Resin Temperature	°C				270~300	280~320	280~320	260~300	260~300	270~310	250~300
	Mold Temperature	°C				70~100	70~100	70~100	50~80	50~80	60~90	60~90
	Pre-Drying Temperature	°C				100	100	100	100	100	100	100
	Drying Time	Hr				2~4	2~4	2~4	2~4	2~4	2~4	2~4
						Filler30% *2.5mm5VA	Filler40%	Filler30%	Filler30%	Filler40%	Filler40%	Filler40%

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Xyron® PROPERTIES (ASTM) –Reinforced–

5/7

					Precision Chassis	Good Appearance, low-warp					
					X404H	X251V	X251Z	X351V	X351Z	X352V	X551V
Property	Units	Test method	Test Condition	Grade							
Physical	Specific gravity		ASTM D 792	23°C	1.38	1.19	1.19	1.15	1.15	1.22	1.15
	Moisture Absorption	%	ASTM D 570	23°C 50%RH 24Hr.	0.05	0.06	0.06	0.06	0.06	0.05	0.06
Thermal	Heat Deflection Temperature	°C	ASTM D 648	1.82MPa	110	90	90	100	100	100	100
	Coefficient Linear Thermal Expansion	mm/mm/°C	ASTM D 696	-30°C ~65°C	3.5x10 ⁻⁵	5.5x10 ⁻⁵	5.5x10 ⁻⁵	5.5x10 ⁻⁵	5.5x10 ⁻⁵	4.5x10 ⁻⁵	5.5x10 ⁻⁵
	Moulding shrinkage	%	ASTM D 955		0.10~0.40	0.35~0.50	0.35~0.50	0.35~0.50	0.35~0.50	0.25~0.40	0.40~0.55
	Flammability		UL 94	1.6mm	HB	V-1	V-0	V-1	V-0	V-1	V-1
3.2mm				HB	–	–	V-1	V-0	V-1	V-1	
Electrical	Dielectric Constant		ASTM D 150	23°C 50%RH 60Hz	3.4	3.1	3.1	3.1	3.1	3.1	3.1
				23°C 50%RH 10 ⁶ Hz	3.3	3.0	3.0	3.0	3.0	3.0	3.0
	Dissipation Factor		ASTM D 150	23°C 50%RH 60Hz	0.007	0.003	0.003	0.003	0.003	0.003	0.003
				23°C 50%RH 10 ⁶ Hz	0.009	0.006	0.006	0.005	0.005	0.005	0.005
	Volume Resistivity	Ω • cm	ASTM D 257	23°C 50% RH	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶
	Surface Resistivity	Ω	ASTM D 257	23°C 50% RH	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶	10 ¹⁶
	Dielectric Strength	kV/mm	ASTM D 149	Short time, 2mm	–	–	–	–	–	–	–
Arc Resistance	sec	ASTM D 495	Tungsten	–	–	–	–	–	–	–	
Mechanical	Tensile Strength	MPa	ASTM D 638	23°C 50% RH	64	48	53	55	54	52	65
	Elongation at Break	%	ASTM D 638	23°C 50% RH	3	20	15	15	15	10	10
	Flexural Strength	MPa	ASTM D 790	23°C 50% RH	99	78	80	85	85	82	98
	Flexural Modulus	MPa	ASTM D 790	23°C 50% RH	9020	3970	3630	3580	3630	4560	3580
	Izod Impact Strength (notched)	J/m	ASTM D 256	6.4mm 23°C	29	39	39	39	39	39	39
3.2mm 23°C				–	49	49	49	49	49	49	
Molding Conditions	Resin Temperature	°C			250~300	240~270	240~270	240~280	240~280	240~280	250~310
	Mold Temperature	°C			60~90	40~70	40~70	50~80	50~80	50~80	60~100
	Pre-Drying Temperature	°C			100	60~90	60~90	90~100	90~100	90~100	100~110
	Drying Time	Hr			2~4	2~4	2~4	2~4	2~4	2~4	2~4
					Filler40%	Filler10%	Filler10%	Filler10%	Filler10%	Filler20%	Filler10%

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6/7

Property \ Units \ Test method \ Test Condition \ Grade					Good Appearance, low-warp		Electroconductive		Acoustic Damping		
					X552V	X552H	X8400	X8600	VM502	VM303	VT302
Physical	Specific gravity		ASTM D 792	23°C	1.22	1.20	1.27	1.15	1.22	1.32	1.22
	Moisture Absorption	%	ASTM D 570	23°C 50%RH 24Hr.	0.06	0.05	0.06	0.06	0.06	0.06	0.06
Thermal	Heat Deflection Temperature	°C	ASTM D 648	1.82MPa	120	120	115	115	120	100	100
	Coefficient Linear Thermal Expansion	mm/mm/°C	ASTM D 696	-30°C ~65°C	4.5x10 ⁻⁵	4.5x10 ⁻⁵	3.0x10 ⁻⁵	3.5x10 ⁻⁵	5.0x10 ⁻⁵	4.5x10 ⁻⁵	5.0x10 ⁻⁵
	Moulding shrinkage	%	ASTM D 955		0.30~0.45	0.30~0.45	0.15~0.35	0.20~0.40	0.35~0.60	0.20~0.45	0.35~0.50
	Flammability		UL 94	1.6mm	V-1	HB	V-1	V-0	V-1	V-1	V-1
3.2mm				V-1	–	V-0*	V-0	V-1	V-1	V-1	
Electrical	Dielectric Constant		ASTM D 150	23°C 50%RH 60Hz	3.2	3.3	–	–	–	–	–
				23°C 50%RH 10 ⁶ Hz	3.1	3.2	–	–	–	–	–
	Dissipation Factor		ASTM D 150	23°C 50%RH 60Hz	0.003	0.0030	–	–	–	–	–
				23°C 50%RH 10 ⁶ Hz	0.005	0.0050	–	–	–	–	–
	Volume Resistivity	Ω • cm	ASTM D 257	23°C 50% RH	10 ¹⁶	10 ¹⁶	10 ³	10 ¹	10 ¹⁶	10 ¹⁶	10 ¹⁶
	Surface Resistivity	Ω	ASTM D 257	23°C 50% RH	10 ¹⁶	10 ¹⁶	10 ³	10 ¹	10 ¹⁶	10 ¹⁶	10 ¹⁶
	Dielectric Strength	kV/mm	ASTM D 149	Short time, 2mm	–	–	–	–	–	–	–
	Arc Resistance	sec	ASTM D 495	Tungsten	–	–	–	–	–	–	–
Mechanical	Tensile Strength	MPa	ASTM D 638	23°C 50% RH	64	58	113	108	53	57	42
	Elongation at Break	%	ASTM D 638	23°C 50% RH	10	7	–	–	5	5	40
	Flexural Strength	MPa	ASTM D 790	23°C 50% RH	98	88	142	142	102	99	76
	Flexural Modulus	MPa	ASTM D 790	23°C 50% RH	4750	4840	7300	8130	4120	5200	3350
	Izod Impact Strength (notched)	J/m	ASTM D 256	6.4mm 23°C	39	39	49	49	69	69	69
3.2mm 23°C				49	49	59	59	69	69	69	
Molding Conditions	Resin Temperature	°C			250~300	240~300	240~300	240~300	250~300	230~280	230~280
	Mold Temperature	°C			60~100	60~100	60~100	60~100	50~100	50~80	50~80
	Pre-Drying Temperature	°C			100~110	110	90~100	90~100	90~100	90~100	90~100
	Drying Time	Hr			2~4	2~4	2~4	2~4	2~4	2~4	2~4
					Filler20%	Filler20%	*2.5mm5VA				

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Xyron® PROPERTIES (ASTM) –Reinforced–

					(PPE/PA) Automotive, Glass Fiber		(PPE/PA) Oil Resistant, Glass Fiber			
Property	Units	Test method	Test Condition	Grade	AG511	AG512	G010H	G010Z	G020H	G020Z
					Physical	Specific gravity		ASTM D 792	23°C	1.16
Moisture Absorption	%	ASTM D 570	23°C 50%RH 24Hr.	0.10		0.10	0.30	0.30	0.30	0.30
Thermal	Heat Deflection Temperature	°C	ASTM D 648	1.82MPa	205 *	210*	180/225*	170/225*	220/265*	200/265*
	Coefficient Linear Thermal Expansion	mm/mm/°C	ASTM D 696	-30°C ~65°C	5x10 ⁻⁵	3x10 ⁻⁵	3.0x10 ⁻⁵	3.0x10 ⁻⁵	3.0x10 ⁻⁵	3.0x10 ⁻⁵
	Moulding shrinkage	%	ASTM D 955		0.5~0.7	0.4~0.7	0.30~0.60	0.30~0.60	0.30~0.70	0.30~0.40
	Flammability		UL 94	1.6mm	Eq. to HB	Eq. to HB	HB	V-0	HB	V-0
3.2mm				Eq. to HB	Eq. to HB	HB	V-0	HB	V-0	
Electrical	Dielectric Constant		ASTM D 150	23°C 50%RH 60Hz	-	-	3.6	3.8	3.5	3.8
				23°C 50%RH 10 ⁶ Hz	-	-	3.2	3.4	3.1	3.4
	Dissipation Factor		ASTM D 150	23°C 50%RH 60Hz	-	-	0.004	0.002	0.004	0.002
				23°C 50%RH 10 ⁶ Hz	-	-	0.010	0.007	0.010	0.007
	Volume Resistivity	Ω • cm	ASTM D 257	23°C 50% RH	-	-	10 ¹⁵	10 ¹⁵	10 ¹⁵	10 ¹⁵
	Surface Resistivity	Ω	ASTM D 257	23°C 50% RH	-	-	10 ¹⁵	10 ¹⁵	10 ¹⁵	10 ¹⁵
	Dielectric Strength	kV/mm	ASTM D 149	Short time, 2mm	-	-	35	35	35	35
	Arc Resistance	sec	ASTM D 495	Tungsten	-	-	-	-	-	-
Mechanical	Tensile Strength	MPa	ASTM D 638	23°C 50% RH	83	122	127	127	137	127
	Elongation at Break	%	ASTM D 638	23°C 50% RH	5	4	3	3	4	4
	Flexural Strength	MPa	ASTM D 790	23°C 50% RH	131	181	186	167	196	167
	Flexural Modulus	MPa	ASTM D 790	23°C 50% RH	3842	6125	7350	7350	7840	7350
	Izod Impact Strength (notched)	J/m	ASTM D 256	6.4mm 23°C	-	-	69	78	69	78
3.2mm 23°C				137	118	118	127	118	127	
Molding Conditions	Resin Temperature	°C			260~290	260~290	250~290	240~280	280~300	260~300
	Mold Temperature	°C			60~120	60~120	60~100	60~100	60~100	60~100
	Pre-Drying Temperature	°C			100~110	100~110	90~100	90~100	90~100	90~100
	Drying Time	Hr			3~4	3~4	3~4	3~4	3~4	3~4
					GF10%	GF20%	GF30%	GF30%	GF30%	GF30%
					* load:0.46 MPA		* load:0.46 MPA			

• Please note that all data and values are given as typical results for natural color resins obtained with the indicated test methods for purposes of basic reference in grade selection only, and not as any product specification or warranty of any nature, and are subject to change without notice.
 • Be sure to read the relevant MSDS before handling and use, and always follow the Important Precautions. (4)