

Data Sheet of 3473

Typical properties	Value	Unit	Standard
Mechanical			
Tensile modulus @5mm/min	15900	MPa	ISO527
Tensile strength, break @5mm/min	146	MPa	ISO527
Tensile strain, break@5mm/min	1.65	%	ISO527
Flexural Modulus	14500	MPa	ISO178
Flexural strength	201	MPa	ISO178
Impact			
Izod impact, Notched, 23°C	6.5	KJ/m ²	ISO180
Izod impact, Un-notched, 23°C	17.3	KJ/m ²	ISO180
Thermal			
HDT, 0.45MPa	275	°C	ISO75
HDT, 1.8Ma	250	°C	ISO75
Physical			
CTE (-40-150°C, flow, Plaque)	19 E-6	1/°C	ISO11359-2
CTE (-40-150°C, x-flow, Plaque)	25 E-6	1/°C	ISO11359-2
Shrinkage (Parallel)	0.2-0.3	%	SABIC method
Shrinkage (perpendicular)	0.3-0.4	%	SABIC method
Density	1.68	g/cm ³	ISO1183
MVR (320C, 5kg)	5.5	cm ³ /10 min	ISO1133
Electrical			
Dielectric constant @1.9GHz	4.25		SABIC method
Dissipation factor@1.9GHz	0.0056		SABIC method
Relative Permittivity, 5GHz	4.2		SABIC method
Dissipation factor, 5GHz	0.0063		SABIC method

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Injection Molding Guidelines

Parameter Title	Typical Value	Unit
Drying Temperature	150	°C
Drying Time	4-6	Hrs
Melt Temperature	315-335	°C
Nozzle Temperature	300-335	°C
Front- Zone 3 Temperature	290-335	°C
Middle -Zone 2 Temperature	280-325	°C
Rear- Zone 1 Temperature	270-315	°C
Mold Temperature	120-180	°C

- 1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured at least after 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume rate are measured on injection molded samples. All samples are prepared according to ISO 294.
- 2) Only typical data for material selection purpose. Not to be used for part or tool design.

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