1. Typical property and the certifications of the regulations

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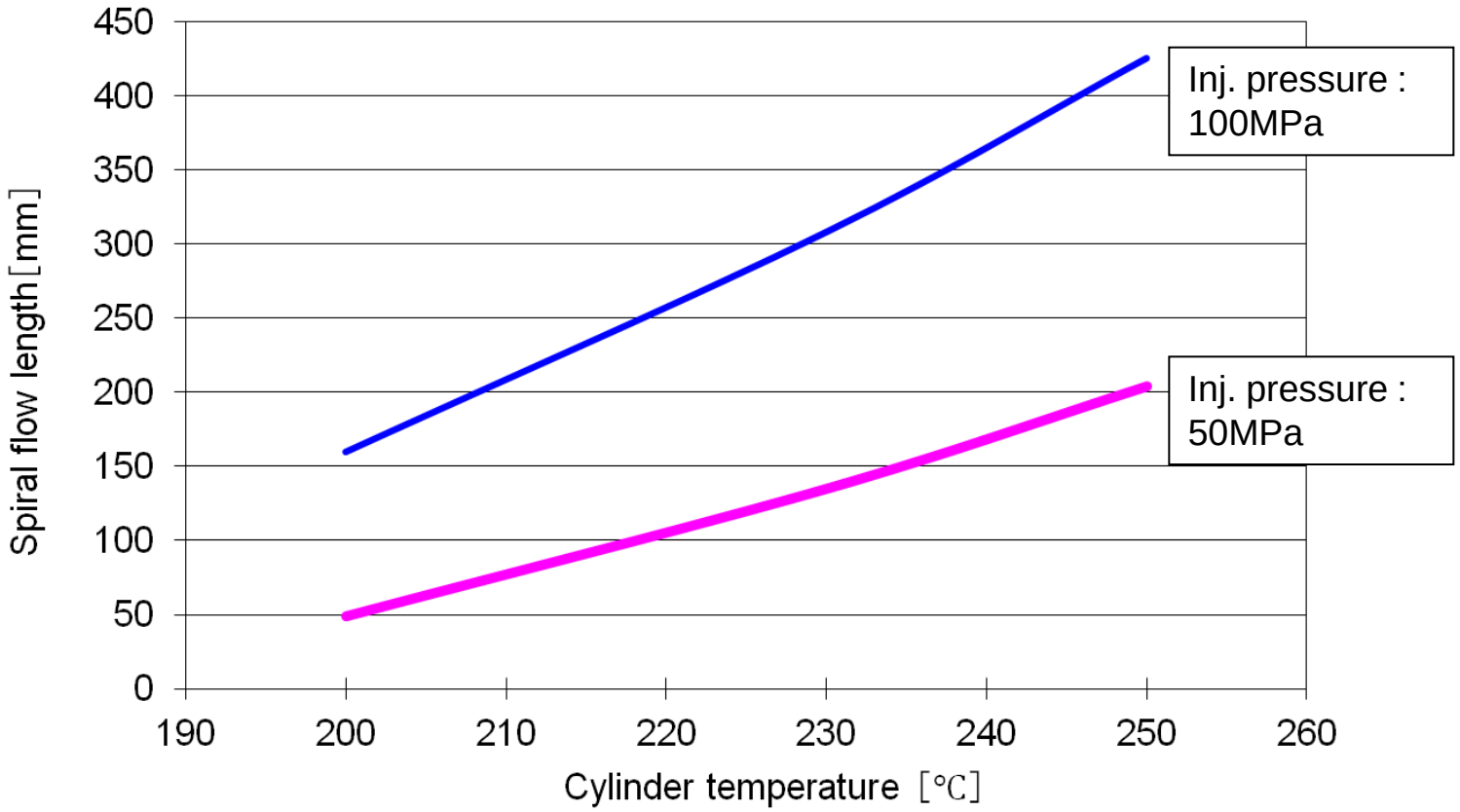
Property	Test Method	Test Condition	Unit	***950 ME1***
Tensile Strength	ISO 527	23℃ / 50%RH	MPa	50
Tensile Elongation at Break	ISO 527	23℃ / 50%RH	%	14
Flexural Strength	ISO 178	23℃ / 50%RH	MPa	71
Flexural Modulus	ISO 178	23℃ / 50%RH	MPa	2180
Charpy Impact Strength	ISO 179	23℃ / 50%RH	kJ/m^2	14
Melt Flow Rate	ISO 1133	220℃ / 98N	g/10min	18
Temp. of Deflection Under Load	ISO 75	1.8MPa	℃	75
Density	ISO 1183	23℃	kg/m^3	1090
Light Transmission	ISO 13468	23℃ / 50%RH 3mmt	%	86
Haze	ISO 14782	23℃ / 50%RH 3mmt	%	3
Flammability	UL94 File No.E41797			HB
Mold shrinkage	—		%	0.4 - 0.6

Note; These values are typical data for this product under specific test conditions and not intended for use as limiting specifications.

2. Spiral Flow Length



<Molding Condition>
Injection molding machine : NISSEI PS60E－12A
Mpld temperature : 60 ºC
Injection pressure : Filling is carried out with controlled at 49MPa, 98MPa.
Mold dimension : 10 w x 2 mmt spiral

3. Molding Condition

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〈Setting〉	〈Item〉		〈Condition〉
Material Pre-drying *1	Temperature / Duration Hot air ventilated oven		80℃ / 3 ～ 5 hr
			90℃ / 2 ～ 3 hr
Molding Temperature *2	Cylinder Temperature	Rear	195 ～ 235℃
		Center ～ Front	200 ～ 260℃
	Nozzle Temperature	Cold Runner	195 ～ 260℃
		Hot Runner	230 ～ 260℃
Mold Temperature *3	General Injection Molding	Core / Cavity	40 ～ 80℃
	Runnerless Molding	Manifold Temperature	230 ～ 260℃
		Band Heater Temperature	230 ～ 260℃
		Hot Runner Nozzle Temperature	230 ～ 260℃
		Core / Cavity	40 ～ 80℃

*1 Depending on the molded part shape, pellet pre-drying might be also necessary even with vented type injection molding machine.

*2 Molded part becomes yellowish when molding at high temperature, long molding cycle and etc. as a result of material retention inside the cyclinder.

*3 The influence to molded part appearance is significant, thus precaution is necessary when aesthetic appearance is desired.

Molded part apperance is improved by applying higher mold temperature, but too high mold temperature will cause long cycle time and possible to induce sink mark defect.