

# Product Comparison

## Technical Data

| Product Description |                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                   |                     |                     |
|---------------------|-------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------|---------------------|---------------------|
| Tritan™<br>TX1001   |                   | Eastman Tritan™ TX1001 is an amorphous copolyester with excellent appearance and clarity. EastmanTritan™ TX1001 contains a mold release derived from vegetable based sources. Its most outstanding features are excellent toughness, hydrolytic stability, and heat and chemical resistance. This new-generation copolyester can also be molded into various applications without incorporating high levels of residual stress. Combined with Tritan™ copolyester's outstanding chemical resistance and hydrolytic stability, these features give molded products enhanced durability in the dishwasher environment, which can expose products to high heat, humidity and aggressive cleaning detergents. Tritan™ TX1001 copolyester may be used in repeated use food contact articles under United States Food and Drug Administration (FDA) regulations. Tritan™ TX1001 copolyester is certified to NSF/ANSI Standard 51 for Food Equipment Materials and is also certified to NSF/ANSI Standard 61 - Drinking Water System Components-Health Effects. |                   |                     |                     |
| Tritan™<br>TX1501HF |                   | Eastman Tritan™ copolyester TX1501HF is a high flow grade of Eastman Tritan™. Eastman Tritan™ copolyester TX1501HF has viscosity reductions of 40-50% relative to Eastman Tritan™ copolyester TX1001. Eastman Tritan™ copolyester TX1501HF contains a mold release derived from vegetable based sources. Other outstanding features include good toughness, hydrolytic stability, and heat and chemical resistance. Eastman Tritan™ copolyester TX1501HF may be used in repeated use food contact articles under United States Food and Drug Administration (FDA) regulations. Eastman Tritan™ copolyester TX1501HF is certified to NSF/ANSI Standard 51 for Food Equipment Materials and is also certified to NSF/ANSI Standard 61 - Drinking Water System Components-Health Effects.                                                                                                                                                                                                                                                                   |                   |                     |                     |
| Tritan™<br>TX2001   |                   | Eastman Tritan™ TX2001 is an amorphous copolyester with excellent appearance and clarity. Tritan™ TX2001 contains a mold release derived from vegetable based sources. Its most outstanding features are excellent toughness, hydrolytic stability, and heat and chemical resistance. This new-generation copolyester can also be molded into various applications without incorporating high levels of residual stress. Combined with Tritan™ copolyester's outstanding chemical resistance and hydrolytic stability, these features give molded products enhanced durability in the dishwasher environment, which can expose products to high heat, humidity, and aggressive cleaning agents. Tritan™ TX2001 copolyester may be used in repeated use food contact articles under United States Food and Drug Administration (FDA) regulations. Tritan™ TX2001 copolyester is certified to NSF/ANSI Standard 51 for Food Equipment Materials and is also certified to NSF/ANSI Standard 61 - Drinking Water System Components-Health Effects.           |                   |                     |                     |
| Ultrason® P<br>3010 |                   | Ultrason P 3010 is an unreinforced, flame retardant, higher viscosity injection molding PPSU grade, with improved chemical resistance.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                   |                     |                     |
| Ultrason® S<br>3010 |                   | Ultrason S 3010 is medium viscosity injection molding grade with improved toughness and chemical resistance (stress crack resistance).                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                   |                     |                     |
|                     |                   | Applications<br>Typical applications include laboratory accessories and household parts.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                   |                     |                     |
| General             | Tritan™<br>TX1001 | Tritan™<br>TX1501HF                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Tritan™<br>TX2001 | Ultrason® P<br>3010 | Ultrason® S<br>3010 |

## Product Comparison

| General                   | Tritan™<br>TX1001                                                                                                                                                                                                                                                                                                                                                                                                                                            | Tritan™<br>TX1501HF                                                                                                                                                                                                                                                                                                                                                                                                                            | Tritan™<br>TX2001                                                                                                                                                                                                                                                                                                                                                                                                                                            | Ultrason® P<br>3010                                                                                                         | Ultrason® S<br>3010                                                                                                                                                    |
|---------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Search for UL Yellow Card | <ul style="list-style-type: none"> <li>•</li> <li>•</li> </ul>                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                             |                                                                                                                                                                        |
| Availability              | <ul style="list-style-type: none"> <li>• Africa &amp; Middle East</li> <li>• Asia Pacific</li> <li>• Europe</li> <li>• Latin America</li> <li>• North America</li> </ul>                                                                                                                                                                                                                                                                                     | <ul style="list-style-type: none"> <li>• Africa &amp; Middle East</li> <li>• Asia Pacific</li> <li>• Europe</li> <li>• Latin America</li> <li>• North America</li> </ul>                                                                                                                                                                                                                                                                       | <ul style="list-style-type: none"> <li>• Africa &amp; Middle East</li> <li>• Asia Pacific</li> <li>• Europe</li> <li>• Latin America</li> <li>• North America</li> </ul>                                                                                                                                                                                                                                                                                     | <ul style="list-style-type: none"> <li>• North America</li> </ul>                                                           | <ul style="list-style-type: none"> <li>• Asia Pacific</li> <li>• Europe</li> <li>• North America</li> </ul>                                                            |
| Additive                  | <ul style="list-style-type: none"> <li>• Mold Release</li> </ul>                                                                                                                                                                                                                                                                                                                                                                                             | <ul style="list-style-type: none"> <li>• Mold Release</li> </ul>                                                                                                                                                                                                                                                                                                                                                                               | <ul style="list-style-type: none"> <li>• Mold Release</li> </ul>                                                                                                                                                                                                                                                                                                                                                                                             | --                                                                                                                          | --                                                                                                                                                                     |
| Features                  | <ul style="list-style-type: none"> <li>• Amorphous</li> <li>• Chemical Resistant</li> <li>• Copolymer</li> <li>• Durable</li> <li>• Fast Molding Cycle</li> <li>• Food Contact Acceptable</li> <li>• Good Mold Release</li> <li>• Good Processability</li> <li>• Good Toughness</li> <li>• High Clarity</li> <li>• High Heat Resistance</li> <li>• High Impact Resistance</li> <li>• Hydrolytically Stable</li> <li>• Pleasing Surface Appearance</li> </ul> | <ul style="list-style-type: none"> <li>• Amorphous</li> <li>• Chemical Resistant</li> <li>• Durable</li> <li>• Fast Molding Cycle</li> <li>• Food Contact Acceptable</li> <li>• Good Mold Release</li> <li>• Good Processability</li> <li>• Good Toughness</li> <li>• High Clarity</li> <li>• High Flow</li> <li>• High Heat Resistance</li> <li>• High Impact Resistance</li> <li>• Hydrolytically Stable</li> <li>• Low Viscosity</li> </ul> | <ul style="list-style-type: none"> <li>• Amorphous</li> <li>• Chemical Resistant</li> <li>• Copolymer</li> <li>• Durable</li> <li>• Fast Molding Cycle</li> <li>• Food Contact Acceptable</li> <li>• Good Mold Release</li> <li>• Good Processability</li> <li>• Good Toughness</li> <li>• High Clarity</li> <li>• High Heat Resistance</li> <li>• High Impact Resistance</li> <li>• Hydrolytically Stable</li> <li>• Pleasing Surface Appearance</li> </ul> | <ul style="list-style-type: none"> <li>• Chemical Resistant</li> <li>• Flame Retardant</li> <li>• High Viscosity</li> </ul> | <ul style="list-style-type: none"> <li>• Chemical Resistant</li> <li>• Good ESCR (Stress Crack Resist.)</li> <li>• Good Toughness</li> <li>• High Viscosity</li> </ul> |
| Uses                      | <ul style="list-style-type: none"> <li>• Appliances</li> <li>• Consumer Applications</li> <li>• Household Goods</li> <li>• White Goods &amp; Small Appliances</li> </ul>                                                                                                                                                                                                                                                                                     | <ul style="list-style-type: none"> <li>• Appliances</li> <li>• Consumer Applications</li> <li>• Household Goods</li> </ul>                                                                                                                                                                                                                                                                                                                     | <ul style="list-style-type: none"> <li>• Appliances</li> <li>• Consumer Applications</li> <li>• Household Goods</li> <li>• White Goods &amp; Small Appliances</li> </ul>                                                                                                                                                                                                                                                                                     | --                                                                                                                          | <ul style="list-style-type: none"> <li>• Household Goods</li> <li>• Labware</li> </ul>                                                                                 |
| Agency Ratings            | <ul style="list-style-type: none"> <li>• FDA Food Contact, Unspecified Rating</li> <li>• NSF STD-51</li> <li>• NSF STD-61</li> </ul>                                                                                                                                                                                                                                                                                                                         | <ul style="list-style-type: none"> <li>• FDA Food Contact, Unspecified Rating</li> <li>• NSF STD-51</li> <li>• NSF STD-61</li> </ul>                                                                                                                                                                                                                                                                                                           | <ul style="list-style-type: none"> <li>• FDA Food Contact, Unspecified Rating</li> <li>• NSF STD-51</li> <li>• NSF STD-61</li> </ul>                                                                                                                                                                                                                                                                                                                         | <ul style="list-style-type: none"> <li>• EC 1907/2006 (REACH)</li> </ul>                                                    | <ul style="list-style-type: none"> <li>• EC 1907/2006 (REACH)</li> </ul>                                                                                               |
| RoHS Compliance           | --                                                                                                                                                                                                                                                                                                                                                                                                                                                           | --                                                                                                                                                                                                                                                                                                                                                                                                                                             | --                                                                                                                                                                                                                                                                                                                                                                                                                                                           | <ul style="list-style-type: none"> <li>• RoHS Compliant</li> </ul>                                                          | <ul style="list-style-type: none"> <li>• RoHS Compliant</li> </ul>                                                                                                     |
| Forms                     | --                                                                                                                                                                                                                                                                                                                                                                                                                                                           | --                                                                                                                                                                                                                                                                                                                                                                                                                                             | --                                                                                                                                                                                                                                                                                                                                                                                                                                                           | <ul style="list-style-type: none"> <li>• Pellets</li> </ul>                                                                 | <ul style="list-style-type: none"> <li>• Pellets</li> </ul>                                                                                                            |
| Processing Method         | <ul style="list-style-type: none"> <li>• Injection Molding</li> </ul>                                                                                                                                                                                                                                                                                                                                                                                        | <ul style="list-style-type: none"> <li>• Injection Molding</li> </ul>                                                                                                                                                                                                                                                                                                                                                                          | <ul style="list-style-type: none"> <li>• Injection Molding</li> </ul>                                                                                                                                                                                                                                                                                                                                                                                        | <ul style="list-style-type: none"> <li>• Injection Molding</li> </ul>                                                       | <ul style="list-style-type: none"> <li>• Injection Molding</li> </ul>                                                                                                  |

Product Comparison

| General                                     | Tritan™<br>TX1001 | Tritan™<br>TX1501HF | Tritan™<br>TX2001 | Ultrason® P<br>3010 | Ultrason® S<br>3010 |           |                                                                                                                                                                                                       |
|---------------------------------------------|-------------------|---------------------|-------------------|---------------------|---------------------|-----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Multi-Point Data                            | --                | --                  | --                | --                  | --                  |           | <ul style="list-style-type: none"><li>• Shear Modulus vs. Temperature (ISO 11403-1)</li><li>• Specific Volume vs Temperature (ISO 11403-2)</li><li>• Viscosity vs. Shear Rate (ISO 11403-2)</li></ul> |
| Physical                                    | Tritan™<br>TX1001 | Tritan™<br>TX1501HF | Tritan™<br>TX2001 | Ultrason® P<br>3010 | Ultrason® S<br>3010 | Unit      | Test Method                                                                                                                                                                                           |
| Density / Specific Gravity                  |                   |                     |                   |                     |                     |           |                                                                                                                                                                                                       |
| --                                          | 1.18              | 1.18                | 1.17              | --                  | --                  | g/cm³     | ASTM D792                                                                                                                                                                                             |
| --                                          | --                | --                  | --                | 1.29                | 1.23                | g/cm³     | ISO 1183                                                                                                                                                                                              |
| Melt Volume-Flow Rate (MVR) (360°C/10.0 kg) | --                | --                  | --                | 35                  | 40                  | cm³/10min | ISO 1133                                                                                                                                                                                              |
| Molding Shrinkage                           |                   |                     |                   |                     |                     |           |                                                                                                                                                                                                       |
| Flow                                        | 0.50 to 0.70      | 0.50 to 0.70        | 0.50 to 0.70      | --                  | --                  | %         | ASTM D955                                                                                                                                                                                             |
| Across Flow                                 | --                | --                  | --                | 1.0                 | 0.74                | %         | ISO 294-4                                                                                                                                                                                             |
| Flow                                        | --                | --                  | --                | 0.90                | 0.70                | %         | ISO 294-4                                                                                                                                                                                             |
| Water Absorption                            |                   |                     |                   |                     |                     |           | ISO 62                                                                                                                                                                                                |
| Saturation, 23°C                            | --                | --                  | --                | 1.2                 | 0.80                | %         |                                                                                                                                                                                                       |
| Equilibrium, 23°C, 50% RH                   | --                | --                  | --                | 0.60                | 0.30                | %         |                                                                                                                                                                                                       |
| Mechanical                                  | Tritan™<br>TX1001 | Tritan™<br>TX1501HF | Tritan™<br>TX2001 | Ultrason® P<br>3010 | Ultrason® S<br>3010 | Unit      | Test Method                                                                                                                                                                                           |
| Tensile Modulus                             |                   |                     |                   |                     |                     |           |                                                                                                                                                                                                       |
| 23°C                                        | 1550              | 1580                | 1590              | --                  | --                  | MPa       | ASTM D638                                                                                                                                                                                             |
| 23°C                                        | 1550              | 1600                | 1620              | 2270                | 2550                | MPa       | ISO 527-2                                                                                                                                                                                             |
| Tensile Strength                            |                   |                     |                   |                     |                     |           |                                                                                                                                                                                                       |
| Yield, 23°C                                 | 43.0              | 43.0                | 44.0              | --                  | --                  | MPa       | ASTM D638                                                                                                                                                                                             |
| Yield, 23°C                                 | 43.0              | 44.0                | 45.0              | 74.0                | 75.0                | MPa       | ISO 527-2                                                                                                                                                                                             |
| Break, 23°C                                 | 53.0              | 52.0                | 53.0              | --                  | --                  | MPa       | ASTM D638                                                                                                                                                                                             |
| Break, 23°C                                 | 58.0              | 49.0                | 49.0              | --                  | --                  | MPa       | ISO 527-2                                                                                                                                                                                             |
| Tensile Elongation                          |                   |                     |                   |                     |                     |           |                                                                                                                                                                                                       |
| Yield, 23°C                                 | 6.0               | 7.0                 | 7.0               | --                  | --                  | %         | ASTM D638                                                                                                                                                                                             |
| Yield, 23°C                                 | 7.0               | 7.0                 | 7.0               | 7.8                 | 6.0                 | %         | ISO 527-2                                                                                                                                                                                             |
| Break, 23°C                                 | 210               | 210                 | 140               | --                  | --                  | %         | ASTM D638                                                                                                                                                                                             |
| Break, 23°C                                 | 190               | 150                 | 130               | --                  | --                  | %         | ISO 527-2                                                                                                                                                                                             |

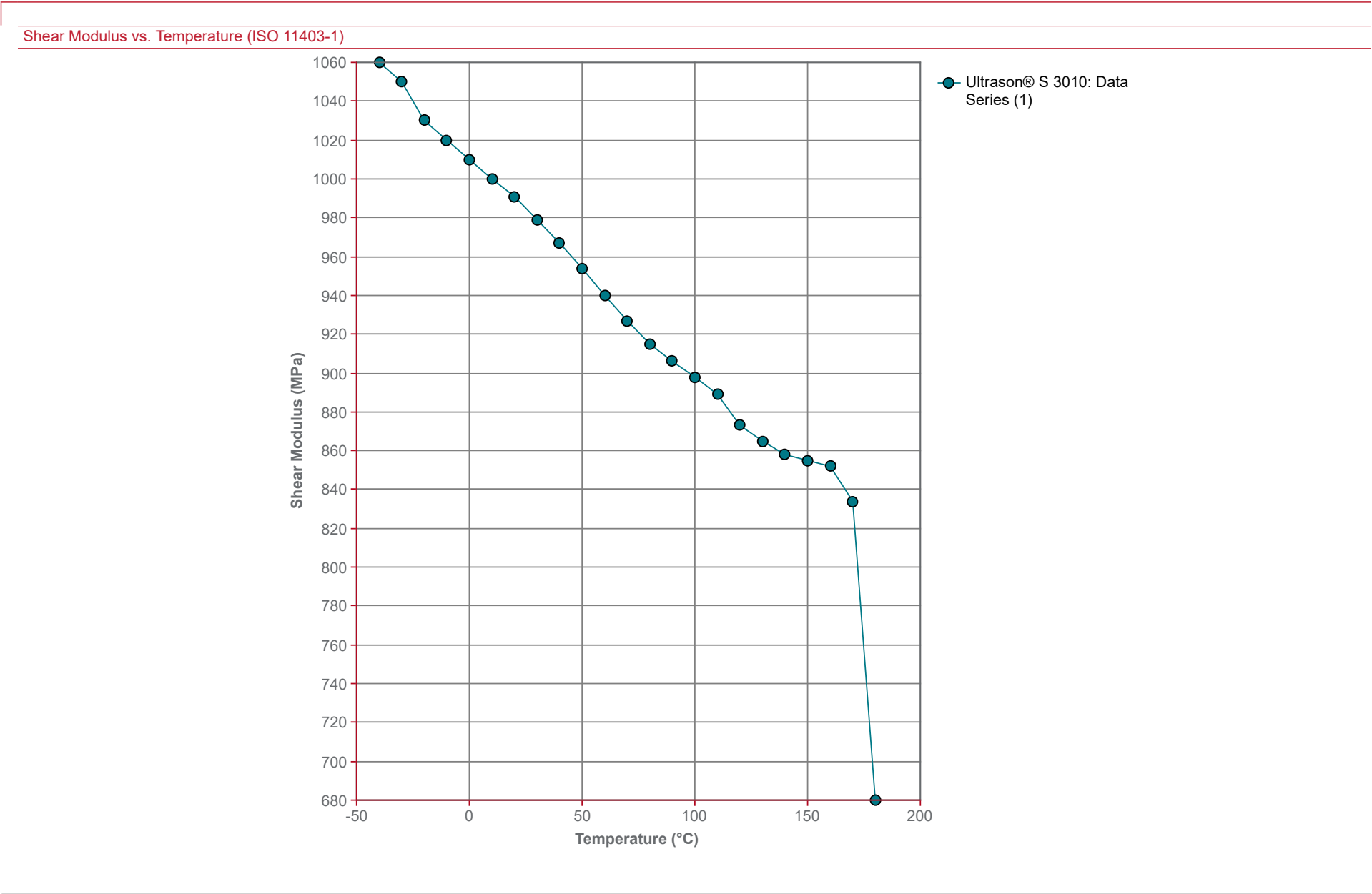
## Product Comparison

| Mechanical                        | Tritan™<br>TX1001 | Tritan™<br>TX1501HF | Tritan™<br>TX2001 | Ultrason® P<br>3010 | Ultrason® S<br>3010 | Unit     | Test Method |
|-----------------------------------|-------------------|---------------------|-------------------|---------------------|---------------------|----------|-------------|
| Flexural Modulus                  |                   |                     |                   |                     |                     |          |             |
| 23°C                              | 1550              | 1580                | 1590              | --                  | --                  | MPa      | ASTM D790   |
| 23°C                              | 1500              | 1500                | 1530              | --                  | --                  | MPa      | ISO 178     |
| Flexural Stress                   |                   |                     |                   |                     |                     |          |             |
| 23°C                              | 59.0              | 60.0                | --                | --                  | --                  | MPa      | ISO 178     |
| Yield, 23°C                       | 62.0              | 64.0                | 66.0              | --                  | --                  | MPa      | ASTM D790   |
| Impact                            | Tritan™<br>TX1001 | Tritan™<br>TX1501HF | Tritan™<br>TX2001 | Ultrason® P<br>3010 | Ultrason® S<br>3010 | Unit     | Test Method |
| Charpy Notched Impact Strength    |                   |                     |                   |                     |                     |          | ISO 179     |
| -30°C                             | --                | --                  | --                | 25                  | 6.0                 | kJ/m²    |             |
| 23°C                              | --                | --                  | --                | 75                  | 5.5                 | kJ/m²    |             |
| Charpy Unnotched Impact Strength  |                   |                     |                   |                     |                     |          | ISO 179     |
| -30°C                             | --                | --                  | --                | No Break            | No Break            |          |             |
| 23°C                              | --                | --                  | --                | No Break            | No Break            |          |             |
| Notched Izod Impact               |                   |                     |                   |                     |                     |          |             |
| 23°C                              | 980               | 860                 | 650               | --                  | --                  | J/m      | ASTM D256   |
| -40°C                             | 20                | 11                  | 14                | --                  | --                  | kJ/m²    | ISO 180     |
| -30°C                             | --                | --                  | --                | 25                  | 6.0                 | kJ/m²    | ISO 180     |
| 23°C                              | 93                | 83                  | 66                | 55                  | 5.5                 | kJ/m²    | ISO 180     |
| Unnotched Izod Impact (23°C)      | No Break          | No Break            | No Break          | --                  | --                  |          | ASTM D4812  |
| Hardness                          | Tritan™<br>TX1001 | Tritan™<br>TX1501HF | Tritan™<br>TX2001 | Ultrason® P<br>3010 | Ultrason® S<br>3010 | Unit     | Test Method |
| Rockwell Hardness (R-Scale, 23°C) | 112               | 111                 | 115               | --                  | --                  |          | ASTM D785   |
| Ball Indentation Hardness         | --                | --                  | --                | 124                 | 135                 | MPa      | ISO 2039-1  |
| Thermal                           | Tritan™<br>TX1001 | Tritan™<br>TX1501HF | Tritan™<br>TX2001 | Ultrason® P<br>3010 | Ultrason® S<br>3010 | Unit     | Test Method |
| Deflection Temperature Under Load |                   |                     |                   |                     |                     |          |             |
| 0.45 MPa, Unannealed              | 99.0              | 94.0                | 109               | --                  | --                  | °C       | ASTM D648   |
| 1.8 MPa, Unannealed               | 85.0              | 81.0                | 92.0              | --                  | --                  | °C       | ASTM D648   |
| 1.8 MPa, Unannealed               | --                | --                  | --                | 198                 | 177                 | °C       | ISO 75-2/A  |
| CLTE - Flow                       | --                | --                  | --                | 5.5E-5              | 5.3E-5              | cm/cm/°C |             |
| RTI Elec                          |                   |                     |                   |                     |                     |          | UL 746      |
| 1.6 mm                            | --                | --                  | --                | --                  | 155                 | °C       |             |
| 3.0 mm                            | --                | --                  | --                | --                  | 155                 | °C       |             |
| RTI Imp                           |                   |                     |                   |                     |                     |          | UL 746      |
| 1.6 mm                            | --                | --                  | --                | --                  | 130                 | °C       |             |
| 3.0 mm                            | --                | --                  | --                | --                  | 130                 | °C       |             |

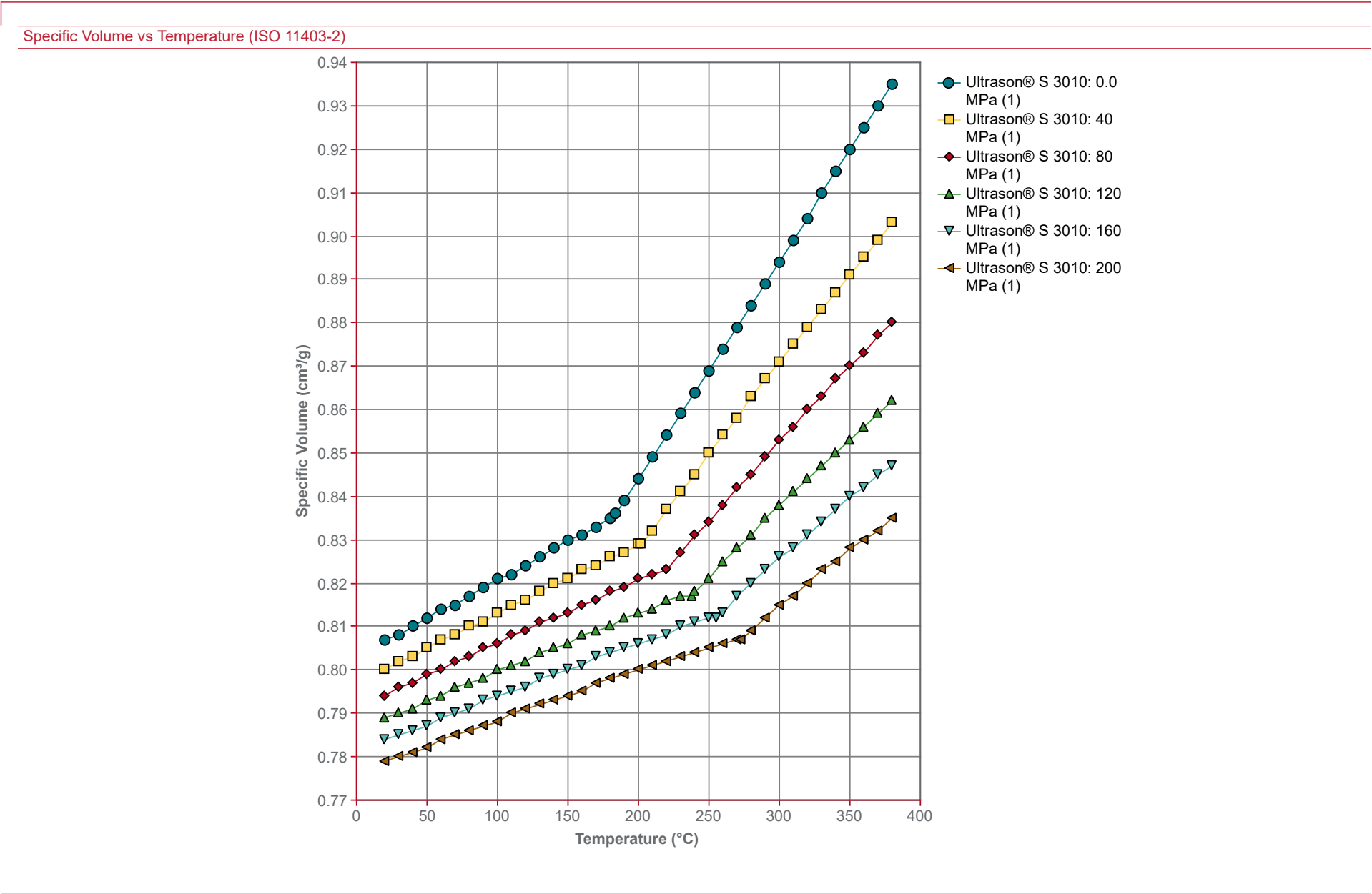
Product Comparison

| Thermal                     | Tritan™<br>TX1001 | Tritan™<br>TX1501HF | Tritan™<br>TX2001 | Ultrason® P<br>3010 | Ultrason® S<br>3010 | Unit    | Test Method |
|-----------------------------|-------------------|---------------------|-------------------|---------------------|---------------------|---------|-------------|
| RTI Str                     |                   |                     |                   |                     |                     |         | UL 746      |
| 1.6 mm                      | --                | --                  | --                | --                  | 155                 | °C      |             |
| 3.0 mm                      | --                | --                  | --                | --                  | 155                 | °C      |             |
| Electrical                  | Tritan™<br>TX1001 | Tritan™<br>TX1501HF | Tritan™<br>TX2001 | Ultrason® P<br>3010 | Ultrason® S<br>3010 | Unit    | Test Method |
| Surface Resistivity         | --                | --                  | --                | > 1.0E+15           | > 1.0E+15           | ohms    | IEC 60093   |
| Volume Resistivity          | --                | --                  | --                | > 1.0E+15           | > 1.0E+15           | ohms·cm | IEC 60093   |
| Electric Strength           | --                | --                  | --                | 44                  | 37                  | kV/mm   | IEC 60243-1 |
| Dielectric Constant         |                   |                     |                   |                     |                     |         | IEC 60250   |
| 100 Hz                      | --                | --                  | --                | 3.80                | 3.10                |         |             |
| 1 MHz                       | --                | --                  | --                | 3.70                | 3.10                |         |             |
| Dissipation Factor          |                   |                     |                   |                     |                     |         | IEC 60250   |
| 100 Hz                      | --                | --                  | --                | 1.7E-3              | 8.0E-4              |         |             |
| 1 MHz                       | --                | --                  | --                | 8.9E-3              | 6.4E-3              |         |             |
| Comparative Tracking Index  | --                | --                  | --                | 150                 | 125                 | V       | IEC 60112   |
| Flammability                | Tritan™<br>TX1001 | Tritan™<br>TX1501HF | Tritan™<br>TX2001 | Ultrason® P<br>3010 | Ultrason® S<br>3010 | Unit    | Test Method |
| Flame Rating                |                   |                     |                   |                     |                     |         | UL 94       |
| 1.6 mm                      | --                | --                  | --                | V-0                 | HB                  |         |             |
| 3.0 mm                      | --                | --                  | --                | V-0                 | HB                  |         |             |
| Optical                     | Tritan™<br>TX1001 | Tritan™<br>TX1501HF | Tritan™<br>TX2001 | Ultrason® P<br>3010 | Ultrason® S<br>3010 | Unit    | Test Method |
| Light Transmittance (Total) | 90.0              | 91.0                | 92.0              | --                  | --                  | %       | ASTM D1003  |
| Haze                        | < 1.00            | < 1.00              | < 1.00            | --                  | --                  | %       | ASTM D1003  |
| Injection                   | Tritan™<br>TX1001 | Tritan™<br>TX1501HF | Tritan™<br>TX2001 | Ultrason® P<br>3010 | Ultrason® S<br>3010 | Unit    |             |
| Drying Temperature          | 88                | 88                  | 88                | --                  | 130 to 150          | °C      |             |
| Drying Time                 | 4.0 to 6.0        | 4.0 to 6.0          | 4.0 to 6.0        | --                  | 4.0                 | hr      |             |
| Suggested Max Moisture      | --                | --                  | --                | --                  | 0.020               | %       |             |
| Processing (Melt) Temp      | 260 to 282        | 260 to 282          | 260 to 282        | --                  | 340 to 390          | °C      |             |
| Mold Temperature            | 38 to 66          | 38 to 66            | 38 to 66          | --                  | 140 to 180          | °C      |             |
| Injection Pressure          | --                | --                  | --                | --                  | 3.50 to 12.5        | MPa     |             |
| Injection Rate              | --                | --                  | --                | --                  | Fast                |         |             |

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Viscosity vs. Shear Rate (ISO 11403-2)

