

**TECHNICAL DATA AND PROCESS SHEET**

**30% GLASS FIBER REINFORCED POLYCARBONATE**

**INSTRUC PCGF30**

**TYPICAL PROPERTIES**

<b>PROPERTY</b>	<b>ASTM METHOD</b>	<b>English</b>	<b>UNITS</b>	<b>Metric SI</b>	<b>UNITS</b>
<b>GENERAL</b>					
SPECIFIC GRAVITY	D792	1.43		1.43	
SPECIFIC VOLUME		19.37	in <sup>3</sup> /lb	0.699	cm <sup>3</sup> /gm
WATER ABSORPTION (24 Hrs)	D570	0.07	%	0.07	%
MOLD SHRINKAGE	D955	0.1-0.2	%	0.1-0.2	%
<b>MECHANICAL</b>					
TENSILE STRENGTH	D638	18,500	psi	128	MPa
ELONGATION, YIELD	D638	1-3	%	1-3	%
FLEXURAL STRENGTH	D790	28,000	psi	193	MPa
FLEXURAL MODULUS	D790	1,200,000	psi	8,274	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		3.2	ft.lb./in.	171	J/m
UNNOTCHED 1/8"		18	ft.lb./in.	959	J/m
ROCKWELL HARDNESS					
<b>THERMAL</b>					
HDTUL @ 264 PSI	D648	295	°F	146	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	1.3	in./in. F x 10 <sup>-5</sup>	2.34	mm/mm C 10 <sup>-6</sup>
FLAMMABILITY <sup>1</sup>	U.L.Subj 94	HB@1/16	in	HB@ 1.5	mm
<b>ELECTRICAL</b>					
SURFACE RESISTIVITY		10e <sup>16</sup>	ohms/sq	10e <sup>16</sup>	ohms/sq
<b>PROCESSING</b>					
DRYING TEMPERATURE		250	°F	121	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		540-630	°F	280- 330	°C
MOLD TEMPERATURE		200	°F	93	°C
BACK PRESSURE		50-100	psi	0.3 - 0.7	MPa
SCREW SPEED		40-70	rpm	40-70	rpm
VENT DEPTH		0.0015-0.003	in	0.038 - 0.075	mm

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