

TECHNICAL DATA AND PROCESS SHEET

10% GLASS FIBER REINFORCED PPA

INSTRUC PPAGF10

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.27		1.27	
SPECIFIC VOLUME		21.8	in ³ /lb	0.787	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	0.3	%	0.30	%
MOLD SHRINKAGE	D955	0.6	%	0.6	%
MECHANICAL					
TENSILE STRENGTH	D638	13,500	psi	93	MPa
ELONGATION, YIELD	D638	2-4	%	2-4	%
FLEXURAL STRENGTH	D790	20,500	psi	141	MPa
FLEXURAL MODULUS	D790	800,000	psi	5,516	MPa
SHEAR STRENGTH	D732		psi		MPa
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		0.8	ft.lb./in.	43	J/m
UNNOTCHED 1/8"		6	ft.lb./in.	320	J/m
ROCKWELL HARDNESS			M Scale		M Scale
THERMAL					
HDTUL @ 264 PSI	D648	420	°F	216	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696		in./in. F x10 ⁻⁵	0	mm/mm C 10 ⁻⁶
FLAMMABILITY ¹	U.L.Subj 94	HB@1/16	in	HB@1.5	mm
ELECTRICAL					
SURFACE RESISTIVITY		10e ¹⁶	ohms/sq	10e ¹⁶	ohms/sq
PROCESSING					
DRYING TEMPERATURE		275	°F	135	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		625	°F	330	°C
MOLD TEMPERATURE		275	°F	135	°C
BACK PRESSURE		50-100	psi	0.3 - 0.7	MPa
SCREW SPEED		40-70	rpm	40-70	rpm
VENT DEPTH		0.0005-0.001	in	0.0125-0.0251	mm

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