

TECHNICAL DATA AND PROCESS SHEET

10% GLASS FIBER REINFORCED POLYSULFONE

INSTRUC PSUGF10

TYPICAL PROPERTIES

<u>PROPERTY</u>	<u>VALUE</u>	<u>UNIT</u>	<u>METHOD</u>
PHYSICAL			
SPECIFIC GRAVITY	1.32	-	ASTM D792
WATER ABSORPTION	0.20	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	0.3-0.5	%	
MECHANICAL			
TENSILE STRENGTH, BRK	11,000	psi	ASTM D638
TENSILE ELONGATION	2-4	%	ASTM D638
FLEXURAL MODULUS	600,000 psi		ASTM D790
IZOD IMPACT, NOTCHED	1.2	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	9-11	ft-lb/in	ASTM D256
THERMAL			
HDTUL @ 264 PSI	355	°F	ASTM D648
ELECTRICAL			
VOLUME RESISTIVITY	>10exp13	Ohm-cm	ASTM D257
PROCESSING			
DRYING TEMPERATURE	275	°F	
DRYING TIME	3-4	hrs	
CYLINDER TEMPERATURE	570-620	°F	
MELT TEMPERATURE	640	°F	
MOLD TEMPERATURE	300	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.0015-0.003	in	

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