

## TECHNICAL DATA AND PROCESS SHEET

### 30% GLASS FIBER REINFORCED POLYSULFONE

#### INSTRUC PSUGF30

#### TYPICAL PROPERTIES

<u>PROPERTY</u>	<u>VALUE</u>	<u>UNIT</u>	<u>METHOD</u>
<b>PHYSICAL</b>			
SPECIFIC GRAVITY	1.46	-	ASTM D792
WATER ABSORPTION	0.20	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	0.1-0.3	%	ASTM D955
<b>MECHANICAL</b>			
TENSILE STRENGTH, BRK	16,000	psi	ASTM D638
TENSILE ELONGATION	1-3	%	ASTM D638
FLEXURAL MODULUS	1,100,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	1.3	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	7-9	ft-lb/in	ASTM D4812
<b>THERMAL</b>			
HDTUL @ 264 PSI	365	°F	ASTM D648
<b>ELECTRICAL</b>			
VOLUME RESISTIVITY	$>10^{15}$	Ohm-cm	ASTM D257
<b>PROCESSING</b>			
DRYING TEMPERATURE	275	°F	
DRYING TIME	3-4	hrs	
CYLINDER TEMPERATURE	620-700	°F	
MELT TEMPERATURE	660	°F	
MOLD TEMPERATURE	300	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.0015-0.003	in	

1/17/11 DJV

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