

## TECHNICAL DATA AND PROCESS SHEET

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### 10% FIBERGLASS REINFORCED TPU 60D HARDNESS

#### INSTRUC TPUGF10 60D

#### TYPICAL PROPERTIES

PROPERTY	VALUE	UNIT	METHOD
<b>PHYSICAL</b>			
SPECIFIC GRAVITY	1.27		ASTM D792
MOLD SHRINKAGE, FLOW 0.125"	0.2-0.4		
SHORE HARDNESS	60D		ASTM D2240
<b>MECHANICAL</b>			
TENSILE STRENGTH, BRK	5,900	psi.	ASTM D638
TENSILE ELONGATION	>40	%	ASTM D638
FLEXURAL MODULUS	60,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	15	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	NB	ft-lb/in	ASTM D256
<b>ELECTRICAL</b>			
SURFACE RESISTIVITY	>10EXP17	Ohm/Sq	ASTM D257
<b>PROCESSING</b>			
DRYING TEMPERATURE	200	°F	
DRYING TIME	4	hrs	
CYLINDER TEMPERATURE	370-415	°F	
MELT TEMPERATURE	410	°F	
MOLD TEMPERATURE	60-100	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.001-0.002	in	

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