

**TECHNICAL DATA AND PROCESS SHEET**

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**20% FIBERGLASS REINFORCED POLYCARBONATE/ABS ALLOY**

**INSTRUC PCABSGF20**

**TYPICAL PROPERTIES**

<b>PROPERTY</b>	<b>VALUE</b>	<b>UNIT</b>	<b>METHOD</b>
<b>PHYSICAL</b>			
SPECIFIC GRAVITY	1.29	-	ASTM D792
MOLD SHRINKAGE, FLOW 0.125"	0.1-0.3	%	
<b>MECHANICAL</b>			
TENSILE STRENGTH, BRK	15,200	psi	ASTM D638
TENSILE ELONGATION	2-3	%	ASTM D638
FLEXURAL MODULUS	800,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	2.0	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	10-12	ft-lb/in	ASTM D256
<b>THERMAL</b>			
HDTUL @ 264 PSI	295	°F	ASTM D648
<b>ELECTRICAL</b>			
VOLUME RESISTIVITY	>1exp17	Ohm-cm	ASTM D257
<b>PROCESSING</b>			
DRYING TEMPERATURE	200	°F	
DRYING TIME	3-4	hrs	
MAX MOISTURE CONTENT	0.02	%	
MELT TEMPERATURE	475-510	°F	
MOLD TEMPERATURE	125-180	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.001-0.002	in	

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