

TECHNICAL DATA AND PROCESS SHEET

30% GLASS FIBER REINFORCED PPA

INSTRUC PPAGF30

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.44		1.44	
SPECIFIC VOLUME		19.2	in ³ /lb	0.694	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	0.2	%	0.20	%
MOLD SHRINKAGE	D955	0.2-0.3	%	0.2-0.3	%
MECHANICAL					
TENSILE STRENGTH	D638	30,000	psi	207	MPa
ELONGATION, YIELD	D638	1-3	%	1-3	%
FLEXURAL STRENGTH	D790	40,000	psi	276	MPa
FLEXURAL MODULUS	D790	1,600,000	psi	11,032	MPa
SHEAR STRENGTH	D732		psi		MPa
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1.5	ft.lb./in.	80	J/m
UNNOTCHED 1/8"		12	ft.lb./in.	640	J/m
ROCKWELL HARDNESS		R125	M Scale	R125	M Scale
THERMAL					
HDTUL @ 264 PSI	D648	540	°F	282	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	1.3	in./in. F x10 ⁻⁵	2.34	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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