

TECHNICAL DATA AND PROCESS SHEET

10% GLASS BEAD FILLED, HIGH FLOW POLYPROPYLENE

INSTRUC PPGB10HF

TYPICAL PROPERTIES

<u>PROPERTY</u>	<u>VALUE</u>	<u>UNIT</u>	<u>METHOD</u>
PHYSICAL			
SPECIFIC GRAVITY	0.97	-	ASTM D792
MOLD SHRINKAGE, FLOW 0.125"	1.4-1.9	%	ASTM D955
MECHANICAL			
TENSILE STRENGTH, BRK	4,000	psi	ASTM D638
TENSILE ELONGATION	>10	%	ASTM D638
FLEXURAL MODULUS	200,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	0.8	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	13	ft-lb/in	ASTM D4812
THERMAL			
HDTUL @ 264 PSI	135	°F	ASTM D648
ELECTRICAL			
SURFACE RESISTIVITY	>10 ¹⁷	Ohms/Sq	ASTM D257
PROCESSING			
DRYING TEMPERATURE	170	°F	
DRYING TIME (not required)	2	hrs	
MELT TEMPERATURE	440	°F	
MOLD TEMPERATURE	100	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.0005-0.001	in	

2/1/12 DJV

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