

## TECHNICAL DATA AND PROCESS SHEET

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### 15% GLASS FIBER REINFORCED POLYPROPYLENE BASED ON FDA COMPLIANT RAW MATERIALS

#### INSTRUC PPGF15FC

#### TYPICAL PROPERTIES

<b>PROPERTY</b>	<b>VALUE</b>	<b>UNIT</b>	<b>METHOD</b>
<b>PHYSICAL</b>			
SPECIFIC GRAVITY	1.01	-	ASTM D792
WATER ABSORPTION	0.03	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	0.3-0.7	%	
<b>MECHANICAL</b>			
TENSILE STRENGTH, BRK	6,600	psi	ASTM D638
FLEXURAL STRENGTH	10,500	psi	ASTM D790
FLEXURAL MODULUS	450,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	1.0	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	7.5	ft-lb/in	ASTM D256
<b>THERMAL</b>			
HDTUL @ 264 PSI	230	°F	ASTM D648
<b>ELECTRICAL</b>			
SURFACE RESISTIVITY	10exp17 Ohms/Sq		ASTM D257
<b>PROCESSING</b>			
DRYING TEMPERATURE	170	°F	
DRYING TIME (not required)	2-4	hrs	
MELT TEMPERATURE	380-440	°F	
MOLD TEMPERATURE	100-150	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	

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