

TECHNICAL DATA AND PROCESS SHEET

15% GLASS FIBER REINFORCED POLYSTYRENE

INSTRUC PSGF20

TYPICAL PROPERTIES

PROPERTY	VALUE	UNIT	METHOD
PHYSICAL			
SPECIFIC GRAVITY	1.18	-	ASTM D792
MOLD SHRINKAGE, FLOW 0.125"	0.1-0.3	%	
MECHANICAL			
TENSILE STRENGTH, BRK	10,600	psi	ASTM D638
FLEXURAL STRENGTH	16,200	psi	ASTM D790
FLEXURAL MODULUS	1,000,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	0.9	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	3-4	ft-lb/in	ASTM D256
ELECTRICAL			
SURFACE RESISTIVITY	10exp17	Ohms/Sq	ASTM D257
PROCESSING			
DRYING TEMPERATURE	170	°F	
DRYING TIME (not required)	2-4	hrs	
MELT TEMPERATURE	410-480	°F	
MOLD TEMPERATURE	100-150	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	

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