

TECHNICAL DATA AND PROCESS SHEET

30% GLASS FIBER REINFORCED, HIGH FLOW POLYSULFONE

INSTRUC PSUGF30HF

TYPICAL PROPERTIES

<u>PROPERTY</u>	<u>VALUE</u>	<u>UNIT</u>	<u>METHOD</u>
PHYSICAL			
SPECIFIC GRAVITY	1.47	-	ASTM D792
WATER ABSORPTION	0.20	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	0.1-0.3	%	ASTM D955
MECHANICAL			
TENSILE STRENGTH, BRK	20,300	psi	ASTM D638
TENSILE ELONGATION	1-3	%	ASTM D638
FLEXURAL MODULUS	1,100,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	2.1	ft-lb/in	ASTM D256
THERMAL			
HDTUL @ 264 PSI	365	°F	ASTM D648
FLAMMABILITY	V-0 @ 3.0 mm, V-1 @ 1.5 mm		
ELECTRICAL			
VOLUME RESISTIVITY	$>10^{15}$	Ohm-cm	ASTM D257
PROCESSING			
DRYING TEMPERATURE	275	°F	
DRYING TIME	3-4	hrs	
CYLINDER TEMPERATURE	620-700	°F	
MELT TEMPERATURE	660	°F	
MOLD TEMPERATURE	300	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.0015-0.003	in	

1/25/11 DJV

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