

TECHNICAL DATA AND PROCESS SHEET

20% GLASS FIBER REINFORCED SAN

INSTRUC SANGF20

TYPICAL PROPERTIES

PROPERTY	VALUE	UNIT	METHOD
PHYSICAL			
SPECIFIC GRAVITY	1.22		ASTM D792
WATER ABSORPTION	0.15	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	0.1-0.2	%	
MECHANICAL			
TENSILE STRENGTH, BRK	15,800	psi	ASTM D638
TENSILE ELONGATION	2-3	%	ASTM D638
FLEXURAL STRENGTH	19,800	psi	ASTM D790
FLEXURAL MODULUS	1,100	kpsi	ASTM D790
IZOD IMPACT, NOTCHED	1.0	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	3-4	ft-lb/in	ASTM D256
THERMAL			
HEAT DEFLECTION 264psi	220	Deg F	
PROCESSING			
DRYING TEMPERATURE	180	°F	
DRYING TIME	4-6	hrs	
MELT TEMPERATURE	480-510	°F	
MOLD TEMPERATURE	150-180	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	

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