

TECHNICAL DATA AND PROCESS SHEET

30% FIBERGLASS REINFORCED TPU

INSTRUC TPUGF30-70D

TYPICAL PROPERTIES

<u>PROPERTY</u>	<u>VALUE</u>	<u>UNIT</u>	<u>METHOD</u>
PHYSICAL			
SPECIFIC GRAVITY	1.50		ASTM D792
MOLD SHRINKAGE, FLOW 0.125"	0.2-0.4		
SHORE HARDNESS	70D		ASTM D2240
MECHANICAL			
TENSILE STRENGTH, BRK	10,200	psi.	ASTM D638
FLEXURAL MODULUS	480,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	3.0	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	20-22	ft-lb/in	ASTM D4812
ELECTRICAL			
SURFACE RESISTIVITY	>10EXP17	Ohm/Sq	ASTM D257
PROCESSING			
DRYING TEMPERATURE	200	°F	
DRYING TIME	4	hrs	
CYLINDER TEMPERATURE	370-415	°F	
MELT TEMPERATURE	410	°F	
MOLD TEMPERATURE	60-100	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.001-0.002	in	

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