

General Information

Product Description

GF+Filler-reinforced(33%) / V-0(1.5mm) equiv. per in-house testing

General

Filler / Reinforcement	• Glass Milled\Glass Fiber, 33% Filler by Weight
Features	• Flame Retardant
Uses	• Automotive Applications • Automotive Electronics • Electrical/Electronic Applications • General Purpose

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.73	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/5.0 kg)	12	cm ³ /10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow : 2.00 mm	1.3	%	
Flow : 2.00 mm	0.80	%	
Water Absorption (Saturation, 23°C)	0.070	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	80.0	MPa	ISO 527-2/5
Tensile Strain (Break)	2.0	%	ISO 527-2/5
Flexural Modulus ²	10000	MPa	ISO 178
Flexural Stress ²	130	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.0	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Melting Temperature	224	°C	ISO 11357-3

Processing Information

Injection	Nominal Value	Unit
Drying Temperature - Hot Air Dryer	120	°C
Drying Time - Hot Air Dryer	5.0 to 8.0	hr
Rear Temperature	250 to 270	°C
Middle Temperature	250 to 270	°C
Front Temperature	250 to 270	°C
Nozzle Temperature	270	°C
Mold Temperature	60 to 100	°C
Injection Pressure	20.0 to 150	MPa
Injection Rate	Moderate-Fast	
Screw Speed	80 to 120	rpm

Notes

¹ Typical properties: these are not to be construed as specifications.

² 2.0 mm/min

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