



2079 Center Square Road
 Logan Township, NJ 08085
 Phone: 856-467-3030

TECHNICAL DATA AND PROCESS SHEET

20% GLASS FIBER REINFORCED PPA

INSTRUC PPAGF20

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.35		1.35	
SPECIFIC VOLUME		20.5	in ³ /lb	0.741	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	0.25	%	0.25	%
MOLD SHRINKAGE	D955	0.4	%	0.4	%
MECHANICAL					
TENSILE STRENGTH	D638	18,000	psi	124	MPa
ELONGATION, YIELD	D638	1-3	%	1-3	%
FLEXURAL STRENGTH	D790	26,200	psi	181	MPa
FLEXURAL MODULUS	D790	1,000,000	psi	6,895	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1.2	ft.lb./in.	64	J/m
UNNOTCHED 1/8"		10	ft.lb./in.	533	J/m
ROCKWELL HARDNESS					
THERMAL					
HDTUL @ 264 PSI	D648	480	°F	249	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696				
FLAMMABILITY ¹	U.L.Subj 94	HB@1/16	in	HB@1.5	mm
ELECTRICAL					
SURFACE RESISTIVITY		10e ¹⁶	ohms/sq	10e ¹⁶	ohms/sq
PROCESSING					
DRYING TEMPERATURE		180	°F	82	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		625	°F	330	°C
MOLD TEMPERATURE		275	°F	135	°C
BACK PRESSURE		50-100	psi	0.3 - 0.7	MPa
SCREW SPEED		40-70	rpm	40-70	rpm
VENT DEPTH		0.0005-0.001	in	0.0125-0.0251	mm

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