



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

TECHNICAL DATA AND PROCESS SHEET

30% GLASS FIBER REINFORCED PPA

INSTRUC PPAGF30

TYPICAL PROPERTIES

PROPERTY	ASTM		English	UNITS	Metric SI	UNITS
	METHOD					
GENERAL						
SPECIFIC GRAVITY	D792		1.44		1.44	
SPECIFIC VOLUME			19.2	in ³ /lb	0.694	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570		0.2	%	0.20	%
MOLD SHRINKAGE	D955		0.2-0.3	%	0.2-0.3	%
MECHANICAL						
TENSILE STRENGTH	D638		30,000	psi	207	MPa
ELONGATION, YIELD	D638		1-3	%	1-3	%
FLEXURAL STRENGTH	D790		40,000	psi	276	MPa
FLEXURAL MODULUS	D790		1,600,000	psi	11,032	MPa
SHEAR STRENGTH	D732					
IZOD IMPACT STRENGTH	D256					
NOTCHED 1/8"			1.5	ft.lb./in.	80	J/m
UNNOTCHED 1/8"			12	ft.lb./in.	640	J/m
ROCKWELL HARDNESS			R125	M Scale	R125	M Scale
THERMAL						
HDTUL	D648		540	°F	282	°C
@ 264 PSI						
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696		1.3	in./in. F x10 ⁻⁵	2.34	mm/mm C 10 ⁻⁶
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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