

Product Texts

Glass fibre reinforced and heat ageing resistance injection moulding grade, used e.g. for automobile manifolds and pedals.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	30 / *	cm ³ /10min	ISO 1133
Temperature	275 / *	°C	-
Load	5 / *	kg	-
^[C] Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	11100 / 6600	MPa	ISO 527
^[C] Stress at break	185 / 115	MPa	ISO 527
^[C] Strain at break	3.2 / 6	%	ISO 527
^[C] Charpy impact strength, +23°C	90 / 100	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	75 / -	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	13 / 20	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	10 / -	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	220 / *	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	208 / *	°C	ISO 75-1/-2

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	6.2 / *	%	Sim. to ISO 62
^[C] Humidity absorption	2 / *	%	Sim. to ISO 62
^[C] Density	1410 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Material specific properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Viscosity number	145 / *	cm ³ /g	ISO 307, 1157, 1628

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.15	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	80 - 90	°C	-

Characteristics

Processing

Injection Molding

Special Characteristics

Heat stabilized or stable to heat

Delivery form

Pellets, Black

Applications

Automotive

Additives

Lubricants, Release agent

Regional Availability

North America, Europe

Other text information**Injection molding**

PREPROCESSING

Pre/Post-processing, max. allowed water content: .15 %

Pre/Post-processing, Pre-drying, Temperature: 80 °C

Pre/Post-processing, Pre-drying, Time: 4 h

PROCESSING

injection molding, Melt temperature, range: 270 - 290 °C

injection molding, Melt temperature, recommended: 280 °C

injection molding, Mold temperature, range: 80 - 90 °C

injection molding, Mold temperature, recommended: 80 °C

injection molding, Dwell time, thermoplastics: 10 min