

**Product Texts**

long fiber reinforced

**Mechanical properties**

	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Modulus	16200	MPa	ASTM D 638
Tensile Strength	234	MPa	ASTM D 638
Elongation at Yield	1.5	%	ASTM D 638
Flexural Modulus	13790	MPa	ASTM D 790
Flexural Strength	352	MPa	ASTM D 790
Izod Impact notched, 1/8 in	294	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	1310	J/m	ASTM D 256

**Thermal properties**

	Value	Unit	Test Standard
<b>ASTM Data</b>			
DTUL @ 264 psi	216	°C	ASTM D 648

**Processing Recommendation Injection Molding**

	Value	Unit	Test Standard
Pre-drying - Temperature	85	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.18	%	-
Melt temperature	271 - 288	°C	-
Mold temperature	93	°C	-
Zone 1	260 - 277	°C	-
Zone 2	266 - 282	°C	-
Zone 3	271 - 288	°C	-
Nozzle temperature	271 - 288	°C	-
Screw speed	30 - 50	rpm	-
Injection speed	51 - 76	mm/s	-
Back pressure	0.17 - 0.35	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific

**Features**

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