

Product Texts

long fiber reinforced

Mechanical properties

	Value	Unit	Test Standard
ASTM Data			
Tensile Modulus	39990	MPa	ASTM D 638
Tensile Strength	310	MPa	ASTM D 638
Elongation at Yield	1	%	ASTM D 638
Flexural Modulus	29300	MPa	ASTM D 790
Flexural Strength	496	MPa	ASTM D 790
Izod Impact notched, 1/8 in	181	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	721	J/m	ASTM D 256

Thermal properties

	Value	Unit	Test Standard
ASTM Data			
DTUL @ 264 psi	252	°C	ASTM D 648

Other properties

	Value	Unit	Test Standard
Density	1370	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding

	Value	Unit	Test Standard
Pre-drying - Temperature	85	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.18	%	-
Melt temperature	293 - 310	°C	-
Mold temperature	93	°C	-
Zone 1	282 - 299	°C	-
Zone 2	288 - 305	°C	-
Zone 3	293 - 310	°C	-
Nozzle temperature	288 - 305	°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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