

**VLF 84009**

PPA-GF50

RTP Company

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Mold Shrinkage, MD	<b>0.002</b>	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Modulus	<b>17930</b>	MPa	ASTM D 638
Tensile Strength	<b>269</b>	MPa	ASTM D 638
Flexural Modulus	<b>18620</b>	MPa	ASTM D 790
Flexural Strength	<b>386</b>	MPa	ASTM D 790
Izod Impact notched, 1/8 in	<b>347</b>	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
UL 94 Flame rating	<b>HB</b>	-	UL 94
Thickness tested	<b>1.59</b>	mm	-
DTUL @ 264 psi	<b>277</b>	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	<b>1650</b>	kg/m <sup>3</sup>	ASTM D 792
Moisture Content	<b>0.05</b>	%	-

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>121</b>	°C	-
Pre-drying - Time	<b>4</b>	h	-
Melt temperature	<b>304 - 329</b>	°C	-
Mold temperature	<b>135 - 163</b>	°C	-
Injection pressure	<b>68.9 - 124</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific

**Special Characteristics**

Heat stabilized or stable to heat