

Generic PP, Unspecified - Glass Fiber, Long

Polypropylene

Generic

Message:

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General Information			
Filler / Reinforcement	Long glass fiber		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	0.180 - 1.35	g/cm ³	ASTM D792
23°C	1.04 - 1.48	g/cm ³	ISO 1183
Molding Shrinkage			
Flow: 23°C	0.020 - 0.31	%	ASTM D955
Transverse flow: 23°C	0.29 - 0.61	%	ASTM D955
23°C	0.080 - 0.70	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.020 - 0.060	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (23°C)	105 - 121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
23°C	560 - 10900	MPa	ASTM D638
23°C	4280 - 14000	MPa	ISO 527-2
Tensile Strength			
Yield, 23°C	73.5 - 148	MPa	ASTM D638
Yield, 23°C	96.1 - 122	MPa	ISO 527-2
Fracture, 23°C	97.0 - 131	MPa	ASTM D638
Fracture, 23°C	82.6 - 151	MPa	ISO 527-2
23°C	5.00 - 126	MPa	ASTM D638
Tensile Elongation			
Fracture, 23°C	1.8 - 3.0	%	ASTM D638
Fracture, 23°C	1.7 - 2.6	%	ISO 527-2
Flexural Modulus			
23°C	3330 - 9450	MPa	ASTM D790
23°C	3810 - 11400	MPa	ISO 178
Flexural Strength			
23°C	150 - 190	MPa	ASTM D790
23°C	108 - 288	MPa	ISO 178
Coefficient of Friction	0.34 - 0.52		ASTM D1894

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	12 - 33	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	39 - 75	kJ/m ²	ISO 179
Notched Izod Impact			
23°C	150 - 300	J/m	ASTM D256
23°C	17 - 29	kJ/m ²	ISO 180
Unnotched Izod Impact			
23°C	740 - 770	J/m	ASTM D256
23°C	44 - 66	kJ/m ²	ISO 180
Instrumented Dart Impact			
23°C	1.50 - 16.3	J	ASTM D3763
23°C	5.59 - 13.1	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	158 - 165	°C	ASTM D648
0.45 MPa, not annealed	162 - 164	°C	ISO 75-2/B
1.8 MPa, not annealed	149 - 158	°C	ASTM D648
1.8 MPa, not annealed	155 - 161	°C	ISO 75-2/A
8.0 MPa, not annealed	122 - 138	°C	ISO 75-2/C
Vicat Softening Temperature	145 - 166	°C	ISO 306
Melting Temperature	165 - 166	°C	ISO 11357-3
Linear thermal expansion coefficient			
Flow	2.2E-5 - 6.8E-5	cm/cm/°C	ASTM D696
Flow	1.8E-5 - 4.7E-5	cm/cm/°C	ASTM E831
Flow	3.3E-5 - 4.6E-5	cm/cm/°C	ISO 11359-2
Lateral	4.5E-5 - 8.3E-5	cm/cm/°C	ASTM E831
Lateral	4.6E-5 - 8.3E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	79.8 - 95.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	225 - 260	°C	
Middle Temperature	224 - 265	°C	
Front Temperature	244 - 275	°C	
Nozzle Temperature	240 - 285	°C	
Processing (Melt) Temp	234 - 275	°C	
Mold Temperature	48.8 - 55.0	°C	
Injection Pressure	45.0 - 90.0	MPa	
Holding Pressure	59.6 - 60.0	MPa	
Back Pressure	0.250 - 1.52	MPa	
Screw Speed	45 - 90	rpm	
Injection instructions			

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