

ISOPAK® 525GF20

Acrylonitrile Butadiene Styrene

Great Eastern Resins Industrial Co., Ltd. (GRECO)

Message:

Surface Modified, Good Flow

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Features	Good liquidity		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.15	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	6.5 - 7.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.20 - 0.30	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	107		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	5690	MPa	ASTM D638
Tensile Strength ²	76.5	MPa	ASTM D638
Tensile Elongation ³ (Break)	1.9	%	ASTM D638
Flexural Modulus	4410	MPa	ASTM D790
Flexural Strength	98.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (25°C, 3.20 mm)	64 - 74	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	90.0	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	80	°C	
Drying Time	2.0 - 3.0	hr	
Processing (Melt) Temp	200 - 230	°C	
Mold Temperature	80 - 100	°C	
NOTE			
1.	5.0 mm/min		
2.	5.0 mm/min		
3.	5.0 mm/min		

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