

Properties**A2604**

Glass fiber-reinforced PA/ABS resin (GF20%, UL94 HB)

Properties	Test methods	Test conditions	Units	Dry	1.1% moist.
Mold shrinkage	ASTM D955	-	%	0.2-0.5	-
Tensile strength	ISO 527	-	MPa	94	71
Flexural strength	ISO 178	-	MPa	150	115
Flexural modulus	ISO 178	-	MPa	5300	3600
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m ²	15	16
Notched Charpy impact strength	ISO 179/1eA	-30 deg C	kJ/m ²	10	-
Notched Izod impact strength	ASTM D256	23 deg C/6.4mm	J/m	150	180
Notched Izod impact strength	ASTM D256	-30 deg C/6.4mm	J/m	100	-
Rockwell hardness	ISO 2039	-	-	R116	R115
Deflection temperature under load	ISO 75	1.80MPa	deg C	170	155
Deflection temperature under load	ASTM D648	1.82MPa/6.4mm	deg C	180	165
Deflection temperature under load	ISO 75	0.45MPa	deg C	210	205
Deflection temperature under load	ASTM D648	0.46MPa/6.4mm	deg C	210	205
Coefficient of linear thermal expansion	ISO 11359	MD	X1E-5/deg C	5	-
Coefficient of linear thermal expansion	ISO 11359	TD	X1E-5/deg C	10	-
Flammability	UL94	-	-	HB	-
Dielectric strength	ASTM D149	1.5mm	MV/m	14	-
Arc resistance	ASTM D495	3.0mm	sec(PLC)	92(6)	-
Water absorption	ISO 62	-	%	0.7	-
Density	ISO 1183	-	g/cm ³	1.23	-

Note

- Values are typical, not quality assured.
- UL recognition File No. of Daicel Polymer is E47773.

Typical settings for processing

Preliminary drying	Barrel temperature(deg C)				Screw rotation (rpm)	Back pressure (MPa)	Mold temperature (deg C)
	Nozzle	Front	Middle	Back			
4-5hrs 90-100deg C	230-250	240-260	230-250	180-210	50-80	10-20	70-90