

Properties	Test Method	Terms	Units	GF Reinforced type
				5010G15
				Standard
				GF15
<b>Physical properties</b>				
Density	ISO 1183	–	g/cm <sup>3</sup>	1.41
<b>Dimensional properties</b>				
Moulding shrinkage (2mmt)	–	MD TD	%	0.5 1.3
<b>Rheological properties</b>				
Melt Volume flow Rate	ISO 1133	–	cm <sup>3</sup> /10min –	65 250°C × 5kg
<b>Mechanical properties</b>				
Yield stress	ISO 527-1,2	–	MPa	–
Stress at break	ISO 527-1,2	–	MPa	110
Strain at break	–	–	%	3
Flexural strength	ISO 178	–	MPa	165
Flexural modulus	–	–	MPa	5,500
Charpy impact	ISO 179-1, 2	–	kJ/m <sup>2</sup> kJ/m <sup>2</sup>	24
		notched		7
<b>Thermal properties</b>				
Melting temperature	ISO 11357-3	–	°C	224
Temperature of deflection under load	ISO 75-1, 2	1.80MPa	°C	198
		0.45MPa		>200
Coefficient of Linear thermal expansion	ISO 11359-2	MD: -30~120°C	1E-5/°C	2.7
		MD: -30~35°C		3.0
		MD: 35~120°C		3.0
		TD: -30~120°C		11.8
		TD: -30~35°C		8.5
		TD: 35~120°C		14.3
Flammability	UL94	–	–	HB(0.84mmtBK,WT) HB(1.5mmtALL) HB(3mmtALL) HB(6mmtALL)
<b>Electrical properties</b>				
Volume resistivity	IEC 60093	–	Ω·m	>1E12
Surface resistivity	IEC 60093	–	Ω	>1E14
Electric strength	IEC 60243-1	1mmt	MV/m	24
		2mmt		21
		3mmt		–
CTI	UL746A	–	–	–
RTI(Elec)	UL746B	–	–	130(0.84mmt BK,WT),130(1.5mmt ALL)
RTI(Imp)	UL746B	–	–	120(1.5mmt ALL)
RTI(Str)	UL746B	–	–	140(0.84mmt BK,WT),140(1.5mmt ALL)
<b>Molding Conditions (Standard example)</b>				
Pre-drying Temperature	–	–	°C	120 / 140
Pre-drying Time	–	–	h	5-8 / 4-6
Cylinder temperature	–	–	°C	240-265
Mold temperature	–	–	°C	50-90
Injection speed	–	–	–	Middle-High
Injection pressure	–	–	MPa	20-150
Screw speed	–	–	rpm	80-150

The values described are typical values only.