

## Properties

### A2602

Glass fiber-reinforced PA/ABS resin (GF10%)

Properties	Test methods	Test conditions	Units	Dry	1.5% moist.
Mold shrinkage	Daicel method	-	%	0.3-0.6	-
Tensile strength	ISO 527	-	MPa	69	51
Flexural strength	ISO 178	-	MPa	113	83
Flexural modulus	ISO 178	-	MPa	3400	2300
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m <sup>2</sup>	13	14
Notched Izod impact strength	ASTM D256	23 deg C/6.4mm	J/m	120	130
Rockwell hardness	ISO 2039	-	-	R115	R114
Deflection temperature under load	ISO 75	1.80MPa	deg C	100	92
Deflection temperature under load	ASTM D648	1.82MPa/6.4mm	deg C	110	102
Deflection temperature under load	ISO 75	0.45MPa	deg C	205	200
Deflection temperature under load	ASTM D648	0.46MPa/6.4mm	deg C	205	200
Coefficient of linear thermal expansion	ISO 11359	MD	X1E-5/deg C	6	-
Coefficient of linear thermal expansion	ISO 11359	TD	X1E-5/deg C	10	-
Water absorption	ISO 62	-	%	0.7	-
Density	ISO 1183	-	g/cm <sup>3</sup>	1.14	-

Note

- Test methods such as ISO standards are fully or almost compliant with the standards.
- Values are typical, not quality assured.

### 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