

## Properties

### A2604

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

Properties	Test methods	Test conditions	Units	Dry	1.1% moist.
Mold shrinkage	Daicel method	-	%	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 <sup>2</sup>	15	16
Notched Charpy impact strength	ISO 179/1eA	-30 deg C	kJ/m <sup>2</sup>	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	-
Water absorption	ISO 62	-	%	0.7	-
Density	ISO 1183	-	g/cm <sup>3</sup>	1.23	-

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