

ASTM methods have been employed, however speeds and conditions have been standardized to facilitate accurate physical property comparisons. Please refer to the testing conditions listed below.

<u>TEST</u>	<u>METHOD (ASTM)</u>	<u>CONDITIONS</u>	<u>UNITS</u>
Melt Flow Rate	D-1238	230°C / 2160 grams	g/10 minutes
Reinforcement Content	D-2584	Ash contents of 5% or less are reported as Unfilled (0)	%
Specific Gravity	D-792	Measured at 23°C	23/23°C
Linear Mold Shrinkage	ISO 294	Average Shrinkage – Flow and Cross Flow Direction 60 x 60 x 2 mm Injection Molded Specimen Cured 24 hours at 23 +/- 2°C & 50 +/- 5% RH Note: Shrinkage is a function of various parameters including; Part Thickness Injection and Hold Pressures Mold and Cooling Times Mold and Cooling Temperatures Part and Gate Design <i>This value should be used only as a guideline.</i>	in/in mm/mm
Tensile Strength	D-638	Type 1 Injection Molded Specimens Cured 40 hours at 23 +/- 2°C & 50 +/- 5% RH Tested at 23°C, 2.0 in./min., Yield Value	psi MPa
Flexural Modulus	D-790	5" x 0.5" x 0.125" Injection Molded Specimen Cured 40 hours at 23 +/- 2°C & 50 +/- 5% RH Tested at 23°C, 0.05 in./min., Tangent Value	psi MPa
Notched Izod	D-256	Test Method A, 2.5" x 0.5" x 0.125" Injection Molded Specimen Cured 40 hours at 23 +/- 2°C & 50 +/- 5% RH VALUE OF 15= No Break	ft-lb/in J/m
Gardner Impact	D-5420	GC Test Configuration 0.125" Injection Molded Specimen Tested at 23°C VALUE OF 320 = No Failure at 320 in-lb	in-lb J
Hardness Shore "D"	D-2240	0.125" Injection Molded Specimen Tested at 23°C, Instantaneous	"D"
DTUL at 66 psi	D-648	5" x 0.5" x 0.125" Injection Molded Specimen Cured 40 hours at 23 +/- 2°C & 50 +/- 5% RH Unannealed	°F °C
DTUL at 264 psi	D-648	5" x 0.5" x 0.125" Injection Molded Specimen Cured 40 hours at 23 +/- 3.6°C & 50 +/- 5% RH Unannealed	°F °C

