Product Data Sheet & General Processing Conditions

ESD A 204 H
Impact-Modified Nylon 6/6 (PA)
Glass Fiber
ESD Protection
Static Dissipative

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

<table>
<thead>
<tr>
<th>PERMANENCE</th>
<th>English</th>
<th>SI Metric</th>
<th>ASTM TEST</th>
</tr>
</thead>
<tbody>
<tr>
<td>Primary Additive</td>
<td>25 %</td>
<td>25 %</td>
<td></td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>1.32</td>
<td>1.32</td>
<td>D 792</td>
</tr>
<tr>
<td>Molding Shrinkage</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1/8 in (3.2 mm) section</td>
<td>0.0030 - 0.0050 in/in</td>
<td>0.30 - 0.50 %</td>
<td>D 955</td>
</tr>
</tbody>
</table>

MECHANICAL

Impact Strength, Izod
- notched 1/8 in (3.2 mm) section 2.5 ft-lbs/in 133 J/m D 256
- unnotched 1/8 in (3.2 mm) section 15.0 ft-lbs/in 801 J/m D 4812

Tensile Strength 15000 psi 103 MPa D 638

Tensile Elongation 2.0 - 4.0 % 2.0 - 4.0 % D 638

Tensile Modulus 1.10 x 10^6 psi 7584 MPa D 638

Flexural Strength 24000 psi 165 MPa D 790

Flexural Modulus 0.95 x 10^6 psi 6550 MPa D 790

ELECTRICAL

Volume Resistivity 1000 - 9.9E+09 ohm.cm 1000 - 9.9E+09 ohm.cm D 257

Surface Resistivity 1.0E+5 - 9.9E+11 ohm/sq 1.0E+5 - 9.9E+11 ohm/sq D 257

Surface Resistance 1.0E+4 - 9.9E+10 ohm 1.0E+4 - 9.9E+10 ohm ESD STM11.11

Static Decay
- MIL-PRF-81705D, 5kV to 50 V, 12% RH < 2.00 s FTMS101C 4046.1

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

GENERAL PROCESSING FOR INJECTION MOLDING

<table>
<thead>
<tr>
<th>English</th>
<th>SI Metric</th>
</tr>
</thead>
<tbody>
<tr>
<td>Injection Pressure 10000 - 18000 psi</td>
<td>69 - 124 MPa</td>
</tr>
<tr>
<td>Melt Temperature 530 - 570 °F</td>
<td>277 - 299 °C</td>
</tr>
<tr>
<td>Mold Temperature 150 - 225 °F</td>
<td>66 - 107 °C</td>
</tr>
<tr>
<td>Drying 4 hrs @ 175 °F</td>
<td>4 hrs @ 79 °C</td>
</tr>
<tr>
<td>Moisture Content 0.20 %</td>
<td>0.20 %</td>
</tr>
<tr>
<td>Dew Point 0 °F</td>
<td>-18 °C</td>
</tr>
</tbody>
</table>

PROCESSING NOTES

Desiccant Type Dryer Required.

http://www.upmold.com
13 Nov 2007 LLM
This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a “trial and error” basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

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