

Starglas FF004

High Density Polyethylene
Eurostar Engineering Plastics

Message:

Starglas FF004 is a Glass Fiber Reinforced High Density Polyethylene Resin

General Information			
Filler / Reinforcement	Glass Fiber		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.10	g/cm ³	ISO 1183
Molding Shrinkage - Flow (4.00 mm)	1.4	%	Internal Method
Water Absorption (23°C, 24 hr)	0.010	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3500	MPa	ISO 527-2/1
Tensile Stress (Yield)	46.0	MPa	ISO 527-2/5
Tensile Strain (Yield)	5.0	%	ISO 527-2/5
Flexural Modulus ¹	3100	MPa	ISO 178
Flexural Stress	60.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	35	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴ (1.8 MPa, Unannealed, 64.0 mm Span)	88.0	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	4.5E-5	cm/cm/°C	
Transverse : 23 to 60°C	1.6E-4	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Rear Temperature	195 to 205	°C	
Middle Temperature	210 to 220	°C	
Front Temperature	220 to 230	°C	
Processing (Melt) Temp	230	°C	
Mold Temperature	40.0 to 55.0	°C	
NOTE			
1.	2.0 mm/min		
2.	80*10*4		

3.	80*10*4
4.	80*10*4

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