

## General Properties of GF330 BC3023

Items	unit	Test Method <sup>*)</sup>	GF30% Filled Grades/Black
			GF330 BC3023
			High viscosity
Melting Point	℃	ISO 11357-3	370
Glass transition temperature	℃	ISO 11357-2	155
Density	g/cm <sup>3</sup>	ISO 1183	1.53
MVR (400℃, 10kg)	ml/10min	ISO 1133	10
Tensile Strength	MPa	ISO 527-1,2	180
Tensile strain at break	%	ISO 527-1,2	2.0
Flexural Strength	MPa	ISO 178	260
Flexural Modulus	MPa	ISO 178	11,500
Charpy notched impact strength	kJ/m <sup>2</sup>	ISO 179/1eA	7
Deflection Temperature Under Load (1.82MPa)	℃	ISO 75-1,2	345
Mold Shrinkage (80×80×3mmt, Flow direction, Cavity Pressure 100MPa)	%	original method	0.8
Mold Shrinkage (80×80×3mmt, Transverse direction, Cavity Pressure 100MPa)	%	original method	1.1

<sup>\*)</sup> mainly compliant with ISO Standards or original method

## Standard molding conditions of GF330 BC3023

Preliminary drying	Cylinder temperature(℃)				Mold temperature (℃)	Injection speed (mm/s)	Holding pressure (MPa)
	Nozzle	Front section	Center section	Rear section			
140~160℃ more than 3hours	400~430	400~430	380~400	370~390	180~210	20~150	70~120

### [Alert Notes]

\*A cylinder of high temperature type is required. A nozzle diameter of standard size or larger is recommended.

\*The nozzle tends to solidify, hence retraction of the injection unit as well as temperature increase of nozzle and front section of the cylinder is recommended.

\*Please contact us for details.

## NOTES TO USERS

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- This brochure has been prepared based on our own experiences and laboratory test data, and therefore all data shown here are not always applicable to parts used under different conditions. We do not guarantee that these data are directly applicable to the application conditions of users and we ask each user to make his own decision on the application.
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