

Makrolon® GF8002

Glass fiber (Normal fiber) reinforced grades / 15 % Glass fiber reinforced MVR (300 °C/1.2 kg) 10 cm³/10 min; 15 % glass fiber reinforced; medium viscosity; easy release; injection molding - melt temperature 310 - 330 °C; available in opaque colors only

ISO Shortname

ISO 7391-PC,MR,(,,-)09-9,GF15

Property	Test Condition	Unit	Standard	typical Value
Rheological properties				
C Melt volume-flow rate	300 °C/ 1.2 kg	cm³/10 min	ISO 1133	9
C Molding shrinkage, parallel	60x60x2 mm	%	ISO 294-4	0,40
C Molding shrinkage, normal	60x60x2 mm	%	ISO 294-4	0,42
C Melt mass-flow rate	300 °C/ 1.2 kg	g/10 min	ISO 1133	10.5
Mechanical properties (23 °C/50 % r. h.)				
C Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	4600
C Yield stress	5 mm/min	MPa	ISO 527-1,-2	63
C Yield strain	5 mm/min	%	ISO 527-1,-2	4.4
C Stress at break	5 mm/min	MPa	ISO 527-1,-2	45
C Strain at break	5 mm/min	%	ISO 527-1,-2	10
C Flexural modulus	2 mm/min	MPa	ISO 178	4500
C Flexural strength	2 mm/min	MPa	ISO 178	105
C Flexural strain at flexural strength	2 mm/min	%	ISO 178	5.3
C Flexural stress at 3.5 % strain	2 mm/min	MPa	ISO 178	95
C Charpy impact strength	23 °C	kJ/m²	ISO 179-1eU	105C
C Puncture maximum force	23 °C	N	ISO 6603-2	3400
C Puncture maximum force	-30 °C	N	ISO 6603-2	2000
C Puncture energy	23 °C	J	ISO 6603-2	18
C Puncture energy	-30 °C	J	ISO 6603-2	6
Thermal properties				
C Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2	134
C Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	140
C Vicat softening temperature	50 N; 50 °C/h	°C	ISO 306	141
C Coefficient of linear thermal expansion, parallel	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0,35
C Coefficient of linear thermal expansion, transverse	23 to 55 °C	10 ⁻⁴ /K	ISO 11359-1,-2	0,64
C Oxygen index	Method A	%	ISO 4589-2	31
C Glow wire test (GWFI)	1.5 mm	°C	IEC 60695-2-12	960
C Glow wire test (GWFI)	3.0 mm	°C	IEC 60695-2-12	960
Electrical properties (23 °C/50 % r. h.)				
C Relative permittivity	100 Hz	-	IEC 60250	3.2
C Relative permittivity	1 MHz	-	IEC 60250	3.2
C Dissipation factor	100 Hz	10 ⁻⁴	IEC 60250	10
C Dissipation factor	1 MHz	10 ⁻⁴	IEC 60250	90
C Volume resistivity		Ohm·m	IEC 60093	1E14
C Surface resistivity		Ohm	IEC 60093	1E16
C Electrical strength	1 mm	kV/mm	IEC 60243-1	39
C Comparative tracking index CTI	Solution A	Rating	IEC 60112	175
C Comparative tracking index CTI M	Solution B	Rating	IEC 60112	125
Other properties (23 °C)				
C Water absorption (saturation value)	Water at 23 °C	%	ISO 62	0.28
C Water absorption (equilibrium value)	23 °C; 50 % r. h.	%	ISO 62	0.1
C Density		kg/m³	ISO 1183-1	1290
C Glass fiber content	Method A	%	b.o. ISO 3451-1	15
C Bulk density	Pellets	kg/m³	ISO 60	640

Makrolon® GF8002

Property	Test Condition	Unit	Standard	typical Value
Processing conditions for test specimens				
C Injection molding-Melt temperature		°C	ISO 294	300
C Injection molding-Mold temperature		°C	ISO 294	110
C Injection molding-Injection velocity		mm/s	ISO 294	200
Recommended Processing and Drying Conditions				
Melt Temperatures		°C	-	280 - 320
Standard Melt Temperature		°C	-	300
Barrel Temperatures - Rear		°C	-	250 - 260
Barrel Temperatures - Middle		°C	-	270 - 280
Barrel Temperatures - Front		°C	-	280 - 290
Barrel Temperatures - Nozzle		°C	-	290 - 300
Mold Temperatures		°C	-	80 - 120
Hold Pressure (% of injection pressure)		%	-	50 - 75
Plastic Back Pressure (specific)		bar	-	50 - 150
Peripheral Screw Speed		m/s	-	0.05 - 0.2
Shot-to-Cylinder Size		%	-	30 - 70
Dry Air Drying Temperature		°C	-	120
Dry Air Drying Time		h	-	2-3
Moisture Content max. (%)		%	-	<= 0,02
Vent Depth		mm	-	0.025 - 0.075

C These property characteristics are taken from the CAMPUS plastics data bank and are based on the international catalogue of basic data for plastics according to ISO 10350.

Impact properties: N = non-break, P = partial break, C = complete break