

NOVALLOY A series

PA/ABS resin

Technical Information

TI-05289

Properties

A2706

Glass fiber-reinforced PA/ABS resin (GF30%)

Properties	Test methods	Test conditions	Units	Dry	1.1% moist.
Mold shrinkage	Our standard	-	%	0.1-0.5	-
Tensile strength	ISO 527	-	MPa	120	93
Flexural strength	ISO 178	-	MPa	190	150
Flexural modulus	ISO 178	-	MPa	7400	5100
Notched Charpy impact strength	ISO 179/1eA	23 deg C	kJ/m ²	14	16
Notched Charpy impact strength	ISO 179/1eA	-30 deg C	kJ/m ²	9	-
Notched Izod impact strength	ASTM D256	23 deg C/6.4mm	J/m	140	160
Notched Izod impact strength	ASTM D256	-30 deg C/6.4mm	J/m	90	-
Rockwell hardness	ISO 2039	-	-	R117	R115
Deflection temperature under load	ISO 75	1.80MPa	deg C	190	180
Deflection temperature under load	ASTM D648	1.82MPa/6.4mm	deg C	200	195
Deflection temperature under load	ISO 75	0.45MPa	deg C	220	210
Deflection temperature under load	ASTM D648	0.46MPa/6.4mm	deg C	220	215
Coefficient of linear thermal expansion	ISO 11359	MD	X1E-5/deg C	3	-
Coefficient of linear thermal expansion	ISO 11359	TD	X1E-5/deg C	10	-
Water absorption	ISO 62	-	%	0.7	-
Density	ISO 1183	-	g/cm ³	1.31	-

Note

- Test methods such as ISO standards are fully or almost compliant with the standards.
- Values are typical, not quality assured.

Typical settings for processing

Preliminary drying	Barrel temperature(deg C)				Screw rotation (rpm)	Back pressure (MPa)	Mold temperature (deg C)
	Nozzle	Front	Middle	Back			
4-5hrs 90-100deg C	230-250	240-260	230-250	180-210	50-80	10-20	70-90