



Phone: (517) 295-4196 Fax: (517) 295-4918

Technical Data Sheet

LCA® PPE/PA 830 Type

30% Glass Reinforced Polyamide, Polyphenylene Ether Modified.

Typical Compound Properties	Value / Measure		Test Methods
Physical Properties			
	English Units (ISO)	Metric Units	
Melt Flow Rate	g/10 min		ASTM D-1238
Density	1.33 g/cm ³	1.33 g/cm ³	ASTM D-792
Linear Mold Shrinkage	0.002 - 0.003 in/in	0.002 - 0.003 mm/mm	ASTM D-5630 ASTM D-955
Mechanical Properties			
Izod Impact - Notched	2 ft-lb/in (kJ/m ²)	107 J/m	
Gardner Impact	in-lbs		ASTM D-256
Tensile Strength @ Yield	22,000 psi (Mpa)	152 MPa	ASTM D-638
Tensile Strength @ Break	psi (Mpa)	0 MPa	ASTM D-638
Tensile Elongation @ Yield	%	0 %	ASTM D-638
Tensile Elongation @ Break	7 %	7 %	ASTM D-638
Flexural Strength @ Yield	36,000 psi (Mpa)	248 MPa	ASTM D-790
Flexural Stress @ Break	psi (Mpa)	0 MPa	ASTM D-790
Flexural Stress @ 5% Strain	psi (Mpa)	0 MPa	ASTM D-790
Flexural Modulus	1,200,000 psi (Mpa)	8,280 MPa	ASTM D-790
Thermal Properties			
DTUL @ 66 psi (455 kPa)	490 Deg. F	254 Deg. C	ASTM D-648
@ 264 psi (1820 kPa)	465 Deg. F	241 Deg. C	ASTM D-648
Vicat Softening Temperature	Deg. F	Deg. C	ASTM D-1525

All tests are performed on dry as molded ASTM (ISO) test bars.

General Product Type Information

The property values listed above have been obtained using laboratory controlled test methods. They are offered without guarantee since conditions under which the product is used are beyond our control. Therefore, Uniplas, Inc. disclaims any liability for loss or damage incurred in connection with the use of this product.

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Typical Processing Conditions

Process Variable	Description	Values
Temperatures		F C
Barrel	Rear	510 - 580
	Center	520 - 580
	Front	530 - 590
	Nozzle	540 - 580
	Melt Temp	540 - 580
	Mold Temperature	170 - 250

Drying

Type	Dehumidifier
Temperature	200 - 225°F
Time	3 - 4 hours
Suggested Maximum Moisture	0.02%

Special Requirements

Optimum processing conditions will depend on such factors as machine size, screw design, part dimension, mold design, runner and gate design, and material residence time. These recommendations are intended only as a guide to achieve stable processing and good part quality.

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