

**SPECIFICATION SHEET GOVERNING
FIBRE GLASS REINFORCED MOULDING POWDER: IA 1330 APPENDIX 'D'**

Description :

This is a thermosetting moulding material based on Phenol formaldehyde resin and Chopped strand leached Glass fiber with a breaking load not below 120 gm with diameter of elementary fibers, 5-7 microns, coated with binder.

Moulding Conditions :

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| 1. Moulding Temp °C | : 145 - 165 |
| 2. Moulding pressure (kg / cm ²) | : 350 ± 50 |
| 3. Shrinkage | : Approximately - 0.15% |
| 4. Recommended Pre-curing | : 1 hour at 80° C (Optional)
½ hour at 90° C 15 minutes at 100° C |
| 5. Storage life | : 6 months when stored at temp of
less than 25° C |
| 6. Bulk factor | : 16-20 |

Tests :

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| 1. Tensile strength (kg /cm ²) not less than | : | 800 |
| 2. Flexural strength (kg / cm ²) not less than | : | 1200 |
| 3. Compressive strength (kg / cm ²) not less than | : | 1800 |
| 4. Impact strength (kg-cm) not less than | : | 30 |
| 5. Volatile matter (%) | : | 2 to 7 |
| 6. Binder content (%) | : | 38 ± 2 |
| 7. Water absorption % not more than | : | 0.20 |
| 8. Oil and benzene resistance change in weight % | : | ± 0.05 |
| 9. Acid resistance in % not more than | : | 0.1 |
| 10. Shrinkage in % not more than | : | 0.15 |
| 11. Density of moulded components in gms/cc | : | 1.7 to 1.9 |