

272 CHOPPED STRANDS FOR THERMOPLASTIC REINFORCEMENT

I. Description

Fysol 272 chopped strands are obtained by assembling sized Boron-free E-glass continuous fibers with a nominal diameter of 10.0 or 13.0 microns and chopping them to a nominal length of 4.5 mm. To better meet customer specific needs, 272 chopped strands are offered in a pelletized (P) form to promote optimum glass handling and feeding characteristics.

II. Use

Fysol 272 chopped strands are designed for compatibility with PBT and PET. Also performs very well in PCT and PC. 272 exhibits superior processing performance in all commonly used glass feeding systems for short fiber compounding.

III. Available Products and their Properties

NOMENCLATURE	SIZING	NOMINAL DIAMETER (µm)	APPEARANCE (C/P)	CHOP LENGTH
272-10P	272	10.0µm	Pelletized	4.5mm
272-13P	272	13.0µm	Pelletized	4.5mm

IV. Significant Physical Characteristics

CHARACTERISTICS	METHOD OF MEASUREMENT	INDIVIDUAL VALUES			
		MINIMUM	NOMINAL	MAXIMUM	
Strand Solids (%)*	ISO 1887	0.65	0.80	0.95	
Moisture Content (%)* (as produced)	ISO 3344	–	–	0.06	
Strand Integrity (%)	MMCPF006 (10min)	–	–	8.0	
Bulk Density (g/cm ³)*	MMCPF004	"10P"	0.60	–	0.88
		"13P"	0.64	–	0.92
Long Fibers (%)	CS 06C-GC	–	–	1.20	

(*) Provided on certificate of analysis

Nominal Fiber diameter is controlled during the intermediate fiber forming step through process control. The specified tolerance for all nominal diameters is $\pm 1.0 \mu\text{m}$.

Chop Length is fixed in the process setup and therefore not routinely tested. Nominal chop length will not vary by more than $\pm 1 \text{ mm}$.

VISUAL PROPERTIES

Color	The product shall be white to off-white in color.
Contamination	Containers shall be free of the following : contamination caused by dirt, oil, grease, dye..., foreign matter, long fibers (see § 4) Product shall be free of fuzz balls or clumps of fuzz > 9 mm in diameter

CUSTOMER ACCEPTANCE STANDARD

V. Special Precautionary Note

In the event that Fysol or the customer has reason to suspect that a shipment may contain out of spec material, the party first suspecting such condition will notify the other, and Fysol will assume responsibility for initiating appropriate action. The use of the suspect material should be discontinued pending an investigation of the facts.

Note that Fysol must be notified of any quality issue within six months of receipt of Material to enable problem analysis and resolution.

VI. Preparation For Shipment

Packaging

Chopped strands shall be packed in polypropylene bags of sufficient strength to ensure adequate protection during transit and stores.

Products are packed as follows:

Standard:

- Bulk Bags 1100 kg (+ 1% / - 0%)

Speciality:

- Small Bags 20 kg (+ 1% / - 0%)

We recommend Bulk Bags not be stacked 1 / 1. Stacking of material is solely the responsibility of the User.

We recommend pallets not to be racked in an accumulation rack. Racking pallets is solely the responsibility of the User.

Labeling Requirements

Pallet identification:

Each container shall bear 2 labels giving the following information:

- Product reference
- Packaging and product code
- Production date
- Net and gross weights in kg
- Identification code of the palletized unit

Small Individual Package Identification:

The product reference and the nominal net weight in kg are printed on each small bag.

VII. Storage Conditions

272 Chopped Strands must be stored in a dry and temperate location. The product should remain in its original packaging, preferably closed, until just prior to use. When stored properly, there is no known shelf life to the product, but retesting is advised after three years from the initial production date to insure optimum performance.

Note: If the storage temperature is less than 59°F (15°C), it would be advisable to put the pallets in the processing area for a minimum of 24 hours before use. This is to avoid condensation.