

**TECHNICAL DATA AND PROCESS SHEET**

**10% CARBON FIBER REINFORCED ABS**

**INELEC ABSCF10**

**TYPICAL PROPERTIES**

PROPERTY	ASTM		UNITS	Metric SI	UNITS
	METHOD	English			
<b>GENERAL</b>					
SPECIFIC GRAVITY	D792	1.09		1.09	
SPECIFIC VOLUME		25.41	in <sup>3</sup> /lb	0.917	cm <sup>3</sup> /gm
WATER ABSORPTION (24 Hrs)	D570	0.15	%	0.15	%
MOLD SHRINKAGE	D955	0.25-0.35	%	0.25-0.35	%
<b>MECHANICAL</b>					
TENSILE STRENGTH	D638	10,000	psi	69	MPa
ELONGATION, YIELD	D638	3-4	%	3-4	%
FLEXURAL STRENGTH	D790	14,000	psi	97	MPa
FLEXURAL MODULUS	D790	800,000	psi	5,516	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1.4	ft.lb./in.	75	J/m
UNNOTCHED 1/8"		6.5	ft.lb./in.	346	J/m
ROCKWELL HARDNESS					
<b>THERMAL</b>					
HDTUL	D648	210	°F	99	°C
@ 264 PSI					
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696				
FLAMMABILITY <sup>1</sup>	U.L.Subj 94	HB@1/16	in	HB@ 1.5	mm
<b>ELECTRICAL</b>					
SURFACE RESISTIVITY		10e <sup>2</sup> -10e <sup>6</sup>	ohms/sq	10e <sup>2</sup> -10e <sup>6</sup>	ohms/sq
<b>PROCESSING</b>					
DRYING TEMPERATURE		170	°F	77	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		400-550	°F	205- 288	°C
MOLD TEMPERATURE		180	°F	82	°C
BACK PRESSURE		50-100	psi	0.3 - 0.7	MPa
SCREW SPEED		40-70	rpm	40-70	rpm
VENT DEPTH		0.0015-0.003	in	0.038 - 0.075	mm

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