

TECHNICAL DATA AND PROCESS SHEET

10% CARBON FIBER REINFORCED POLYCARBONATE/ABS ALLOY

INELEC PCABSCF10

TYPICAL PROPERTIES

<u>PROPERTY</u>	<u>VALUE</u>	<u>UNIT</u>	<u>METHOD</u>
PHYSICAL			
SPECIFIC GRAVITY	1.19	-	ASTM D792
MOLD SHRINKAGE, FLOW 0.125"	0.1-0.3	%	
MECHANICAL			
TENSILE STRENGTH, BRK	16,200	psi	ASTM D638
TENSILE ELONGATION	1-3	%	ASTM D638
FLEXURAL MODULUS	1,050,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	2.0	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	6-8	ft-lb/in	ASTM D256
THERMAL			
HDTUL @ 264 PSI	265	°F	ASTM D648
ELECTRICAL			
SURFACE RESISTIVITY	10 ² -10 ⁶	Ohm/sq	ASTMD257
PROCESSING			
DRYING TEMPERATURE	200	°F	
DRYING TIME	3-4	hrs	
MAX MOISTURE CONTENT	0.02	%	
MELT TEMPERATURE	475-510	°F	
MOLD TEMPERATURE	125-180	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.001-0.002	in	

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