

TECHNICAL DATA AND PROCESS SHEET

15% CARBON FIBER FILLED POLYSULFONE

INELEC PSUCF15

TYPICAL PROPERTIES

<u>PROPERTY</u>	<u>VALUE</u>	<u>UNIT</u>	<u>METHOD</u>
PHYSICAL			
SPECIFIC GRAVITY	1.30	-	ASTM D792
MOLD SHRINKAGE, FLOW 0.125"	0.1-0.3	%	ASTM D955
MECHANICAL			
TENSILE STRENGTH, BRK	16,000	psi	ASTM D638
TENSILE ELONGATION	2 - 3	%	ASTM D638
FLEXURAL MODULUS	1,200,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	1.5	ft-lb/in	ASTM D256
THERMAL			
HDTUL @ 264 PSI	360	°F	ASTM D648
ELECTRICAL			
SURFACE RESISTIVITY	10^2 - 10^6	Ohm/sq	ASTM D257
PROCESSING			
DRYING TEMPERATURE	275	°F	
DRYING TIME	3-4	hrs	
CYLINDER TEMPERATURE	620-700	°F	
MELT TEMPERATURE	640-660	°F	
MOLD TEMPERATURE	300	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.0015-0.003	in	

11/28/11 DJV

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