

## TECHNICAL DATA AND PROCESS SHEET

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### 15% CARBON FIBER REINFORCED PVDF

#### INSTRUC PVDFCF15

#### TYPICAL PROPERTIES

<b>PROPERTY</b>	<b>VALUE</b>	<b>UNIT</b>	<b>METHOD</b>
<b>PHYSICAL</b>			
SPECIFIC GRAVITY	1.76	-	ASTM D792
MOLD SHRINKAGE, FLOW 0.125"	0.2-0.6	%	
<b>MECHANICAL</b>			
TENSILE STRENGTH, BRK	14,100	psi	ASTM D638
TENSILE ELONGATION	1-3	%	ASTMD638
FLEXURAL STRENGTH	19,500	psi	ASTM D790
FLEXURAL MODULUS	1,150,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	1.5	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	8-10	ft-lb/in	ASTM D256
<b>ELECTRICAL</b>			
SURFACE RESISTIVITY	10E2-10E6	Ohm/Sq.	ASTM D257
<b>PROCESSING</b>			
DRYING TEMPERATURE	250	°F	
DRYING TIME	4	hrs	
MELT TEMPERATURE	420-450	°F	
MOLD TEMPERATURE	150 - 200	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	

6/25/10 DJV

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