

TECHNICAL DATA AND PROCESS SHEET

10% CARBON FIBER REINFORCED POLYPHENYLENE SULFIDE

INELEC PPSCF10

TYPICAL PROPERTIES

PROPERTY	VALUE	UNIT	METHOD
PHYSICAL			
SPECIFIC GRAVITY	1.37	-	ASTM D792
WATER ABSORPTION	0.04	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	0.3-0.4	%	
MECHANICAL			
TENSILE STRENGTH, BRK	15,000	psi	ASTM D638
TENSILE ELONGATION	1-2	%	ASTM D638
FLEXURAL MODULUS	1,600,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	1.0	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	4.0	ft-lb/in	ASTM D256
THERMAL			
HDTUL @ 264 PSI	485	°F	ASTM D648
ELECTRICAL			
SURFACE RESISTIVITY	10exp2-6	Ohm/Sq	ASTM D257
PROCESSING			
DRYING TEMPERATURE	300	°F	
DRYING TIME	4	hrs	
MELT TEMPERATURE	610-630	°F	
MOLD TEMPERATURE	275-350	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.0003-0.0005	in	

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