

## TECHNICAL DATA AND PROCESS SHEET

### 30% CARBON FIBER REINFORCED POLYPOLYPHENYLENE SULFIDE

#### INELEC PPSCF30

#### TYPICAL PROPERTIES

| <u>PROPERTY</u>             | <u>VALUE</u>    | <u>UNIT</u> | <u>METHOD</u> |
|-----------------------------|-----------------|-------------|---------------|
| <b>PHYSICAL</b>             |                 |             |               |
| SPECIFIC GRAVITY            | 1.45            | -           | ASTM D792     |
| WATER ABSORPTION            | 0.04            | %           | ASTM D570     |
| MOLD SHRINKAGE, FLOW 0.125" | 0.1-0.2         | %           | ASTM D955     |
| <b>MECHANICAL</b>           |                 |             |               |
| TENSILE STRENGTH, BRK       | 28,000          | psi         | ASTM D638     |
| TENSILE ELONGATION          | 1-2             | %           | ASTM D638     |
| FLEXURAL MODULUS            | 3,500,000       | psi         | ASTM D790     |
| IZOD IMPACT, NOTCHED        | 1.3             | ft-lb/in    | ASTM D256     |
| IZOD IMPACT, UNNOTCHED      | 6-8             | ft-lb/in    | ASTM D4812    |
| <b>THERMAL</b>              |                 |             |               |
| HDTUL @ 264 PSI             | 515             | °F          | ASTM D648     |
| <b>ELECTRICAL</b>           |                 |             |               |
| SURFACE RESISTIVITY         | $10^2$ - $10^4$ | Ohm/Sq      | ASTM D257     |
| <b>PROCESSING</b>           |                 |             |               |
| 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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