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## TECHNICAL DATA AND PROCESS SHEET

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### 20% CARBON FIBER REINFORCED NYLON 12

#### INSTRUC PA12CF20

#### TYPICAL PROPERTIES

<u>PROPERTY</u>	<u>VALUE</u>	<u>UNIT</u>	<u>METHOD</u>
<b>PHYSICAL</b>			
SPECIFIC GRAVITY	1.10	-	ASTM D792
WATER ABSORPTION	0.08	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	0.1 – 0.3	%	
<b>MECHANICAL</b>			
TENSILE STRENGTH, BRK	16,300	psi	ASTM D638
TENSILE ELONGATION	2-3	%	ASTM D638
FLEXURAL MODULUS	1,250,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	1.5	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	10-12	ft-lb/in	ASTM D256
<b>THERMAL</b>			
HDTUL @ 264 PSI	325	°F	ASTM D648
<b>ELECTRICAL</b>			
SURFACE RESISTIVITY	>10EXP17	Ohm/Sq	ASTM D257
<b>PROCESSING</b>			
DRYING TEMPERATURE	180	°F	
DRYING TIME	4	hrs	
MELT TEMPERATURE	440-460	°F	
MOLD TEMPERATURE	160-180	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.0005-0.001	in	

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