



2079 Center Square Road
Logan Township, NJ 08085

TECHNICAL DATA AND PROCESS SHEET

30% CARBON FIBER REINFORCED NYLON 6/12

INELEC PA612CF30

TYPICAL PROPERTIES

<u>PROPERTY</u>	<u>VALUE</u>	<u>UNIT</u>	<u>METHOD</u>
PHYSICAL			
SPECIFIC GRAVITY	1.21	-	ASTM D792
WATER ABSORPTION, 24 Hrs	0.15	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	0.1 - 0.3	%	ASTM D955
MECHANICAL			
TENSILE STRENGTH, BRK	29,000	psi	ASTM D638
TENSILE ELONGATION	2 - 3	%	ASTM D638
TENSILE MODULUS	2,800,000	psi	ASTM D638
FLEXURAL STRENGTH	48,000	psi	ASTM D790
FLEXURAL MODULUS	2,500,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	1.8	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	16	ft-lb/in	ASTM D4812
THERMAL			
HDTUL @ 264 PSI	425	°F	ASTM D648
FLAMMABILITY	HB @ 1.5 mm		
ELECTRICAL			
SURFACE RESISTIVITY	10 ² - 10 ⁶	Ohm/Sq	ASTM D257
PROCESSING			
DRYING TEMPERATURE	175	°F	
DRYING TIME	4	hrs	
MELT TEMPERATURE	510-530	°F	
MOLD TEMPERATURE	200	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.0005-0.001	in	

12/8/10 DJV

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