



2079 Center Square Road  
 Logan Township, NJ 08085  
 Phone: 856-467-3030

**TECHNICAL DATA AND PROCESS SHEET**

**20% CARBON FIBER REINFORCED POLYCARBONATE**

**INELEC PCCF20**

**TYPICAL PROPERTIES**

<b>PROPERTY</b>	<b>ASTM METHOD</b>	<b>English</b>	<b>UNITS</b>	<b>Metric SI</b>	<b>UNITS</b>
<b>GENERAL</b>					
SPECIFIC GRAVITY	D792	1.28		1.28	
SPECIFIC VOLUME		21.64	in <sup>3</sup> /lb	0.781	cm <sup>3</sup> /gm
WATER ABSORPTION (24 Hrs)	D570	0.09	%	0.09	%
MOLD SHRINKAGE	D955	0.05-0.2	%	0.05-0.2	%
<b>MECHANICAL</b>					
TENSILE STRENGTH	D638	20,000	psi	138	MPa
ELONGATION, YIELD	D638	2-3	%	2-3	%
FLEXURAL STRENGTH	D790	30,000	psi	207	MPa
FLEXURAL MODULUS	D790	1,600,000	psi	11,032	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		2	ft.lb./in.	107	J/m
UNNOTCHED 1/8"		12	ft.lb./in.	640	J/m
ROCKWELL HARDNESS					
<b>THERMAL</b>					
HDTUL @ 264 PSI	D648	290	°F	143	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	1.2	in./in. F x10 <sup>-5</sup>	2.16	mm/mm C 10 <sup>-6</sup>
FLAMMABILITY <sup>1</sup>	U.L.Subj 94	HB@1/16	in	HB@ 1.5	mm
<b>ELECTRICAL</b>					
SURFACE RESISTIVITY		10e2-10e4	ohms/sq	10e2-10e4	ohms/sq
<b>PROCESSING</b>					
DRYING TEMPERATURE		250	°F	121	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		540-630	°F	280- 330	°C
MOLD TEMPERATURE		200	°F	93	°C
BACK PRESSURE		50-100	psi	0.3 - 0.7	MPa
SCREW SPEED		40-70	rpm	40-70	rpm
VENT DEPTH		0.0015-0.003	in	0.038 - 0.075	mm

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