



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

TECHNICAL DATA AND PROCESS SHEET

10% CARBON FIBER REINFORCED PPA

INELEC PPACF10

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.24		1.24	
SPECIFIC VOLUME		22.3	in ³ /lb	0.806	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	0.3	%	0.30	%
MOLD SHRINKAGE	D955	0.1-0.4	%	0.1-0.4	%
MECHANICAL					
TENSILE STRENGTH	D638	22,000	psi	152	MPa
ELONGATION, YIELD	D638	2-4	%	2-4	%
FLEXURAL STRENGTH	D790	31,000	psi	214	MPa
FLEXURAL MODULUS	D790	1,200,000	psi	8,274	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		0.9	ft.lb./in.	48	J/m
UNNOTCHED 1/8"		6	ft.lb./in.	320	J/m
ROCKWELL HARDNESS					
THERMAL					
HDTUL	D648	480	°F	249	°C
@ 264 PSI					
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696				
FLAMMABILITY ¹	U.L.Subj 94	HB@1/16	in	HB@1.5	mm
ELECTRICAL					
SURFACE RESISTIVITY		10e ² -10e ⁶	ohms/sq	10e ² -10e ⁶	ohms/sq
PROCESSING					
DRYING TEMPERATURE		180	°F	82	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		625	°F	330	°C
MOLD TEMPERATURE		275	°F	135	°C
BACK PRESSURE		50-100	psi	0.3 - 0.7	MPa
SCREW SPEED		40-70	rpm	40-70	rpm
VENT DEPTH		0.0005-0.001	in	0.0125-0.0251	mm

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