PPLCF5

P801B LCF

Product Description	Applications
5% long carbon fiber reinforced PP	Injection molding
Excellent conductivity	Excellent mechanical properties

Properties	Test Method	Test Condition	Unit	Typical Values
Physical properties				
Specific Gravity	ISO 1183	23	g/cm³	0.93
Ash	ISO 3451	800 ,30min	%	5
Mechanical properties				
Tensile Strength	ISO 527	5mm/min	MPa	80
Tensile Modulus	ISO 527	1mm/min	MPa	5230
Flexural Strength	ISO 178	2mm/min	MPa	107
Flexural Modulus	ISO 178	2mm/min	MPa	4240
Unnotched Charpy Impact Strength	ISO 179-1/1eU	23	kJ/m²	19
		-30		23
Notched Charpy Impact Strength	ISO 179-1/1eA	23	kJ/m²	5.6
		-30		5.7
Thermal properties				
Heat Deflection Temp.	ISO 75	1.80MPa		160
		0.45MPa		165
Others properties				
Surface resistance	ESD STM11.11		Ω	$< 10^5$
Mold Shrinkage (1)	internal test method	flow direction	%	TBD
		cross flow direction	%	TBD
Flammability	ISO 3795	—	mm/min	50

Note: Above data is typical value, not guarantee value. The data will vary with tool design such as gate type , gate location, gate number, injection molding process and part thickness. The data will vary with different color as well. Prior to use the material, please consult with Sunway polymer.

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	Processing Conditions (2)	Range (2)
Melt Temp.		210-230℃
Barrel Zone Temp.	Rear	210-240℃
	Center	210--220℃
	Front	215--235℃
Mold Temp.		30-50℃
Pre-Dry needed		90-110°C,2-4h

(1) 210*140*2.8mm

(2)

Note: (1) The dimension of shrinkage plaque is 210*140*2.8mm. The part's shrinkage will have deviation due to part thickness, number of gate and type of gate; It is better to do mold trial on similar tool before cutting a new tool.

(2) The above process condition is only for reference. The actual process should be adjusted according to different type of machine, mold design and product design.

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