

PPLCF20

P802LCF



Product Description		Applications		
·20%	20% 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	1.01
Ash	ISO 3451	800 ,30min	%	20
Mechanical properties				
Tensile Strength	ISO 527	5mm/min	MPa	159
Tensile Modulus	ISO 527	1mm/min	MPa	14100
Flexural Strength	ISO 178	2mm/min	MPa	221
Flexural Modulus	ISO 178	2mm/min	MPa	12100
Unnotched Charpy Impact Strength	ISO 179-1/1eU	23	kJ/m²	42
		-30		38
Notched Charpy Impact Strength	ISO 179-1/1eA	23	kJ/m²	11
		-30		10
Thermal properties				
Heat Deflection Temp.	ISO 75	1.80MPa		162
		0.45MPa		166
Others properties				
Surface resistance	ESD STM11.11		Ω	< 10 ⁵
Mold Shrinkage	internal test method	flow direction	%	0.02-0.06
		cross flow direction	%	0.50-0.70
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.

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 ,2-4h

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.

version: 1, Jan. 2021