

Properties

AC2604(Type P)

Carbon fiber-reinforced PA/ABS resin (CF20%)

Conductive

| Properties | Test methods | Test conditions | Units | |
|---|---------------|-----------------|-------------|---------|
| Mold shrinkage | ASTM D955 | - | % | 0.2-0.5 |
| Tensile strength | ISO 527 | - | MPa | 150 |
| Flexural strength | ISO 178 | - | MPa | 240 |
| Flexural modulus | ISO 178 | - | MPa | 13000 |
| Notched Charpy impact strength | ISO 179/1eA | 23 deg C | kJ/m2 | 10 |
| Deflection temperature under load | ISO 75 | 1.80MPa | deg C | 200 |
| Coefficient of linear thermal expansion | ISO 11359 | MD | X1E-5/deg C | 1 |
| Coefficient of linear thermal expansion | ISO 11359 | TD | X1E-5/deg C | 4 |
| Flammability | UL94 | - | - | HB |
| Volume resistivity | Daicel method | - | ohm*m | 2E-2 |
| Surface resistivity | Daicel method | - | ohm | 5E0 |
| Density | ISO 1183 | - | g/cm3 | 1.17 |

Note

•Values are typical, not quality assured.

Typical settings for processing

| Preliminary drying | Barrel temperature(deg C) | | | | Screw rotation (rpm) | Back pressure (MPa) | Mold temperature (deg C) |
|-----------------------|---------------------------|---------|---------|---------|----------------------|---------------------|--------------------------|
| | Nozzle | Front | Middle | Back | | | |
| 4-5hrs 90-100deg C | 230-250 | 240-260 | 230-250 | 180-210 | 50-80 | 10-20 | 70-90 |