

ElectriPlast® EP-CF/PC

Polycarbonate

Integral Technologies, Inc.

Message:

ElectriPlast® EP-CF/PC is a polycarbonate (PC) product that contains nickel-plated carbon fiber. It can be processed by injection molding and is available in North America. The main characteristics are: flame retardant/rated flame.

General Information			
Filler / Reinforcement	Nickel plated carbon fiber		
Features	Self-extinguishing		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.26	g/cm ³	ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7730	MPa	ASTM D638
Tensile Strength (Break)	85.0	MPa	ASTM D638
Tensile Elongation (Break)	1.0	%	ASTM D638
Flexural Modulus	6730	MPa	ASTM D790
Flexural Strength	135	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	57	J/m	ASTM D256
Unnotched Izod Impact (23°C)	200	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	140	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.9E+2	ohms	ESD STM11.11
Volume Resistivity	43	ohms · cm	ASTM D257
Static Decay		msec	Internal method
Surface Resistance	18	ohms	ESD STM11.11
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
No Burn	HB		UL 94
t1 or t2 <10 sec.	V-2		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Rear Temperature	288	°C	
Middle Temperature	293	°C	
Front Temperature	293	°C	
Nozzle Temperature	288	°C	

Mold Temperature	93.3	°C
Back Pressure	2.07	MPa
Screw Speed	82	rpm

Injection instructions

Injection Speed: 1 in/sec1st Stage (injection): 2400 psi2nd Stage (molding): 1000 psiDecomposition: 0.5 inch

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