

Generic ABS - Carbon Fiber

Acrylonitrile Butadiene Styrene

Generic

Message:

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This information is provided for comparative purposes only.

General Information			
Filler / Reinforcement	Carbon fiber reinforced material		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.07 - 1.30	g/cm ³	ASTM D792
23°C	1.08 - 1.16	g/cm ³	ISO 1183
Molding Shrinkage			
Flow: 23°C	0.095 - 0.31	%	ASTM D955
23°C	0.20 - 0.30	%	ISO 294-4
Water Absorption (23°C, 24 hr)	0.14 - 0.21	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (23°C)	108 - 110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
23°C	4460 - 23800	MPa	ASTM D638
23°C	5760 - 10400	MPa	ISO 527-2
Tensile Strength			
Yield, 23°C	21.4 - 131	MPa	ASTM D638
Fracture, 23°C	76.1 - 125	MPa	ASTM D638
Fracture, 23°C	59.6 - 90.5	MPa	ISO 527-2
23°C	74.3 - 126	MPa	ASTM D638
Tensile Elongation			
Yield, 23°C	1.3 - 1.5	%	ASTM D638
Fracture, 23°C	0.90 - 2.9	%	ASTM D638
Fracture, 23°C	0.95 - 1.0	%	ISO 527-2
Flexural Modulus			
23°C	1050 - 19700	MPa	ASTM D790
23°C	5290 - 6950	MPa	ISO 178
Flexural Strength			
23°C	41.4 - 193	MPa	ASTM D790
23°C	45.0 - 216	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	46 - 55	J/m	ASTM D256

Unnotched Izod Impact (23°C)	150 - 330	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	102 - 118	°C	ASTM D648
1.8 MPa, not annealed	85.4 - 113	°C	ASTM D648
1.8 MPa, not annealed	95.6 - 102	°C	ISO 75-2/A
CLTE - Flow	1.8E-5 - 7.9E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	2.5 - 1.3E+10	ohms	ASTM D257
Volume Resistivity (23°C)	5.0 - 1.3E+9	ohms·cm	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	82.1 - 82.5	°C	
Drying Time	2.0 - 9.0	hr	
Suggested Max Moisture	0.075 - 0.10	%	
Rear Temperature	209 - 247	°C	
Middle Temperature	214 - 246	°C	
Front Temperature	215 - 271	°C	
Nozzle Temperature	210 - 235	°C	
Processing (Melt) Temp	220 - 260	°C	
Mold Temperature	59.8 - 80.6	°C	
Injection Pressure	85.9 - 103	MPa	
Back Pressure	0.258 - 0.556	MPa	
Screw Speed	45 - 71	rpm	
Injection instructions			

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