

Complet® LCF30-TPU

Engineering Thermoplastic Polyurethane

PlastiComp, Inc.

Message:

Complet® LCF30-TPU is an engineering thermoplastic polyurethane (ETPU) product, which contains 30% long carbon fiber as filler. It is available in North America, Europe or Asia Pacific. The main features are: Rohs certification.

General Information			
Filler / Reinforcement	Long carbon fiber, 30% filler by weight		
RoHS Compliance	RoHS compliance		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.31	g/cm ³	ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	24900	MPa	ASTM D638
Tensile Strength	269	MPa	ASTM D638
Tensile Elongation (Break)	1.0 - 2.0	%	ASTM D638
Flexural Modulus	17900	MPa	ASTM D790
Flexural Strength	389	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	190	J/m	ASTM D256
Unnotched Izod Impact	830	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	85.0	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	87.8	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Max Regrind	5	%	
Rear Temperature	204 - 227	°C	
Middle Temperature	210 - 232	°C	
Front Temperature	216 - 238	°C	
Nozzle Temperature	221 - 243	°C	
Processing (Melt) Temp	216 - 238	°C	
Mold Temperature	87.8	°C	
Back Pressure	0.172 - 0.345	MPa	
Screw Speed	30 - 50	rpm	
Cushion	6.35	mm	
Screw L/D Ratio	18.0:1.0 to 20.0:1.0		
Screw Compression Ratio	2.0 : 1.0 - 3.0 : 1.0		

Injection instructions

Injection speed: 2 to 3 in/sec Injection pressure: medium to maximum

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Recommended distributors for this material

Susheng Import & Export Trading Co., Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

