

Complet® LCF30-PES

Polyethersulfone

PlastiComp, Inc.

Message:

Complet® LCF30-PES is a polyethersulfone (PES) product, which contains 30% long carbon fiber as filler. It can be processed by injection molding and is available in North America, Europe or the Asia-Pacific region. The main features are: Rohs certification.

General Information			
Filler / Reinforcement	Long carbon fiber, 30% filler by weight		
RoHS Compliance	RoHS compliance		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.48	g/cm ³	ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	26500	MPa	ASTM D638
Tensile Strength	214	MPa	ASTM D638
Tensile Elongation (Break)	1.0	%	ASTM D638
Flexural Modulus	22100	MPa	ASTM D790
Flexural Strength	300	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	160	J/m	ASTM D256
Unnotched Izod Impact	510	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	210	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	149	°C	
Drying Time	6.0	hr	
Suggested Max Moisture	0.040	%	
Suggested Max Regrind	5	%	
Rear Temperature	349 - 366	°C	
Middle Temperature	360 - 377	°C	
Front Temperature	366 - 382	°C	
Nozzle Temperature	371 - 388	°C	
Processing (Melt) Temp	377 - 388	°C	
Mold Temperature	163 - 193	°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
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Injection instructions

Injection speed: 2-3 in/secInjection pressure: medium to maximum

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