

Latilon 28D K/20

Polycarbonate

LATI S.p.A.

Message:

Compound based on Polycarbonate (PC).
Carbon fibre.
Low smoke toxicity index and optical density. Fair dimensional stability.

General Information			
Filler / Reinforcement	Carbon Fiber,20% Filler by Weight		
Features	Good Dimensional Stability		
	Low Optical Density		
	Low Smoke Emission		
Physical	Nominal Value	Unit	Test Method
Density	1.28	g/cm ³	ISO 1183
Molding Shrinkage ¹			ISO 294-4
Across Flow : 2.00 mm	0.20 to 0.35	%	
Flow : 2.00 mm	0.10 to 0.20	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			ISO 527-2/1
23°C	12000	MPa	
60°C	11500	MPa	
90°C	10500	MPa	
120°C	9400	MPa	
Tensile Stress			ISO 527-2/5
Break, 23°C	130	MPa	
Break, 60°C	110	MPa	
Break, 90°C	90.0	MPa	
Break, 120°C	65.0	MPa	
Tensile Strain			ISO 527-2/5
Break, 23°C	1.7	%	
Break, 60°C	1.6	%	
Break, 90°C	1.6	%	
Break, 120°C	1.7	%	
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	30	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C, 3.20 mm)	85	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			

0.45 MPa, Unannealed	140	°C	ISO 75-2/B
1.8 MPa, Unannealed	135	°C	ISO 75-2/A
Continuous Use Temperature ²	135	°C	
Vicat Softening Temperature	145	°C	ISO 306/B50
CLTE - Flow (30 to 100°C)	2.5E-6	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Drying Temperature	120 to 130	°C	
Drying Time	3.0	hr	
Processing (Melt) Temp	280 to 300	°C	
Mold Temperature	100 to 120	°C	
Injection Rate	Moderate-Fast		
NOTE			
1.	at 60 Mpa of cavity pressure		
2.	20,000 hr		

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