

Complet® LCF30-PA66

Polyamide 66

PlastiComp, Inc.

Message:

Complet® LCF30-PA66 is a polyamide 66 (nylon 66) 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	1.27	g/cm ³	ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	23400	MPa	ASTM D638
Tensile Strength	276	MPa	ASTM D638
Tensile Elongation (Break)	1.0 - 2.0	%	ASTM D638
Flexural Modulus	19300	MPa	ASTM D790
Flexural Strength	400	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	190	J/m	ASTM D256
Unnotched Izod Impact	800	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	249	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	85.0	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.18	%	
Suggested Max Regrind	5	%	
Rear Temperature	282 - 299	°C	
Middle Temperature	288 - 304	°C	
Front Temperature	293 - 310	°C	
Nozzle Temperature	288 - 304	°C	
Processing (Melt) Temp	293 - 310	°C	
Mold Temperature	93.3	°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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