

OnForce™ LFT SF-40LCF/000 Black

Polyphenylene Sulfide

PolyOne Corporation

Message:

Polyvan's long fiber thermoplastic polymers are used in situations where high hardness and good impact resistance are required, such as metal substitution or other structural applications. These products exhibit enhanced physical and mechanical properties compared to staple fiber products. Its advantages include improved impact strength, elasticity and material strength in different temperature ranges. In addition, compared with traditional high-filled short fiber products, long fiber thermoplastic polymers show improved properties in terms of creep and fatigue resistance, improved dimensional stability and unique surface finish.

General Information			
Filler / Reinforcement	Long carbon fiber, 40% filler by weight		
Features	Thermal Stability		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Density	1.50	g/cm ³	ISO 1183
Molding Shrinkage ¹	0.30	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	30000	MPa	ISO 527-2
Tensile Stress (Break)	160	MPa	ISO 527-2
Tensile Strain (Break)	0.70	%	ISO 527-2
Flexural Modulus	22000	MPa	ISO 178
Flexural Stress	230	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	7.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength	22	kJ/m ²	ISO 179
Dart Drop Impact	8.47	J	ASTM D5420
Injection	Nominal Value	Unit	
Drying Temperature	150	°C	
Drying Time	4.0 - 6.0	hr	
Processing (Melt) Temp	320 - 340	°C	
Mold Temperature	150	°C	
Injection Rate	Slow-Moderate		
Back Pressure	1.00	MPa	
Injection instructions			
LFT compounds can be processed using equipment similar to that used for short fiber products. The mechanical properties of finished parts depend greatly on the length of the fibers in the molded part; therefore processing conditions must be set carefully in order to minimize fiber breakage. A "low shear process" is advised, with low back pressure, low screw speed and low-to-medium injection speed.			
NOTE			

1.

Measured on a tensile specimen.
Actual mold shrinkage values are
highly dependant on part
geometry, mold configuration, and
processing conditions.

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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

