

名称: **PPLCF10**  
 牌号: **P801A LCF**



| 产品简介 Product Description                          | 主要应用 Applications                        |
|---|--|
| ·10%长碳纤维增强聚丙烯 10% long carbon fiber reinforced PP | ·注塑成型 Injection molding                  |
| ·优异的导电性能 Excellent conductivity                   | ·优异的机械性能 Excellent mechanical properties |

| 性能 Properties                                  | 测试标准 Test Method     | 测试条件 Test Condition  | 单位 Unit           | 典型值 Typical Values |
|--|----------------------|----------------------|-------------------|--------------------|
| <b>物理性能 Physical properties</b>                |                      |                      |                   |                    |
| 密度 Specific Gravity                            | ISO 1183             | 23℃                  | g/cm <sup>3</sup> | 0.96               |
| 灰份 Ash   | ISO 3451             | 800℃,30min           | %                 | 10                 |
| <b>机械性能 Mechanical properties</b>              |                      |                      |                   |                    |
| 拉伸强度 Tensile Strength                          | ISO 527              | 5mm/min              | MPa               | 124                |
| 拉伸模量 Tensile Modulus                           | ISO 527              | 1mm/min              | MPa               | 8880               |
| 弯曲强度 Flexural Strength                         | ISO 178              | 2mm/min              | MPa               | 161                |
| 弯曲模量 Flexural Modulus                          | ISO 178              | 2mm/min              | MPa               | 7340               |
| 简支梁无缺口冲击强度<br>Unnotched Charpy Impact Strength | ISO 179-1/1eU        | 23℃                  | kJ/m <sup>2</sup> | 27                 |
|  |                      | -30℃                 |                   | 28                 |
| 简支梁缺口冲击强度<br>Notched Charpy Impact Strength    | ISO 179-1/1eA        | 23℃                  | kJ/m <sup>2</sup> | 7.4                |
|  |                      | -30℃                 |                   | 6.9                |
| <b>热性能 Thermal properties</b>                  |                      |                      |                   |                    |
| 热变形温度<br>Heat Deflection Temp.                 | ISO 75               | 1.80MPa              | ℃                 | 162                |
|  |                      | 0.45MPa              |                   | 166                |
| <b>其他 Others properties</b>                    |                      |                      |                   |                    |
| 表面电阻 Surface resistance                        | ESD STM11.11         |                      | Ω                 | < 10 <sup>5</sup>  |
| 收缩率 Mold Shrinkage <sup>(1)</sup>              | internal test method | flow direction       | %                 | 0.08-0.16          |
|  |                      | cross flow direction | %                 | 0.63-0.83          |
| 阻燃性 Flammability                               | ISO 3795             | —                    | mm/min            | 50                 |

**说明:** 以上数据是典型值, 不是保证值。根据模具设计, 例如浇口类型, 浇口分布, 浇口数量的不同, 注塑工艺和制件厚度的不同, 测试结果会有波动。不同的颜色, 测试结果也会有波动。在使用材料之前, 请咨询旭光聚合物有限公司。

**Note:** Above data is typical value, not guarantee value. The data will vary with tool design such as gate type , gate location, gate number, injection molding process and part thickness. The data will vary with different color as well. Prior to use the material, please consult with Sunway polymer.

| 典型加工条件 Processing Conditions <sup>(2)</sup> |            | 参考范围 Range <sup>(2)</sup> |
|---|------------|---------------------------|
| 熔体温度 Melt Temp.                             |            | 210-230℃                  |
| 料筒温度 Barrel Zone Temp.                      | 后段, Rear   | 210-240℃                  |
|   | 中段, Center | 210--220℃                 |
|   | 前段, Front  | 215--235℃                 |
| 模具温度 Mold Temp.                             |            | 30-50℃                    |
| 预干燥 Pre-Dry needed                          |            | 90-110℃,2-4h              |

**说明:** (1) 收缩率板的尺寸为: 210\*140\*2.8mm。由于制件厚度, 浇口数量, 类型不同, 收缩率会有变化; 开模之前, 最好在类似的模具上试模;

(2) 以上数值仅供注塑机参考使用, 可根据不同机型、不同模具以及产品要求, 对上述工艺做适当调整。

**Note:** (1) The dimension of shrinkage plaque is 210\*140\*2.8mm. The part's shrinkage will have deviation due to part thickness, number of gate and type of gate; It is better to do mold trial on similar tool before cutting a new tool.

(2) The above process condition is only for reference. The actual process should be adjusted according to different type of machine, mold design and product design.

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