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Product Data Sheet & General Processing Conditions

EMI 2861-60A Thermoplastic Vulcanizate (TPV) Stainless Steel Fiber Electrically Conductive EMI/RFI Shielding

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	10 %	10 %	
Specific Gravity	1.02	1.02	D 792
MECHANICAL			
Tensile Strength	235 psi	2 MPa	D 412
Tensile Elongation	140.0 %	140.0 %	D 412
Tear Strength, Die C	75.0 pli	13.1 N/mm	D 624
Hardness			
Shore A, 10 s delay	60	60	D 2240
ELECTRICAL			
Volume Resistivity	< 1E2 ohm.cm	< 1E2 ohm.cm	D 257
Surface Resistivity	< 1E4 ohm/sq	< 1E4 ohm/sq	D 257
Surface Resistance	< 1E3 ohm	< 1E3 ohm	ESD STM11.11
Static Decay	< 0.50 s	< 0.50 s	FTMS101C 4046.1
EMI			
Shielding Effectiveness @ 3 mm thickness	48 dB @ 300 MHz	48 dB @ 300 MHz	D 4935
Shielding Effectiveness @ 3 mm thickness	45 dB @ 500 MHz	45 dB @ 500 MHz	D 4935
Shielding Effectiveness @ 3 mm thickness	47 dB @ 700 MHz	47 dB @ 700 MHz	D 4935
Shielding Effectiveness @ 3 mm thickness	50 dB @ 1000 MHz	50 dB @ 1000 MHz	D 4935
Shielding Effectiveness @ 3 mm thickness	51 dB @ 1300 MHz	51 dB @ 1300 MHz	D 4935
Shielding Effectiveness @ 3 mm thickness	53 dB @ 1500 MHz	53 dB @ 1500 MHz	D 4935

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	12000 - 18000 psi	83 - 124 MPa
Melt Temperature	360 - 410 °F	182 - 210 °C
Mold Temperature	60 - 150 °F	16 - 66 °C
Drying	2 hrs @ 175 °F	2 hrs @ 79 °C
Moisture Content	0.03 %	0.03 %
Dew Point	0 °F	-18 °C

PROCESSING NOTES

Use a reverse barrel profile. Remove hopper magnets. Allow 4 - 5 shots to properly disperse the conductive fibers. The surface finish should have a silver streaking appearance, not clumps.

Remove hopper magnets.