

Electrafil® J-1200/CF/30 NT

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber, 30% Filler by Weight
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.21		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.10E+8	psi	ASTM D638
Tensile Stress (Yield)	14500	psi	ISO 527-2
Tensile Stress (Break)	13800	psi	ISO 527-2
Tensile Strain (Break)	0.80	%	ISO 527-2
Flexural Modulus	2.55E+6	psi	ISO 178
Flexural Stress	20300	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	2.4	ft-lb/in	ASTM D256
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+2 to 1.0E+6	ohms	ASTM D257

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	450 to 480	°F
Middle Temperature	460 to 490	°F
Front Temperature	470 to 500	°F
Nozzle Temperature	475 to 505	°F
Processing (Melt) Temp	465 to 505	°F
Mold Temperature	100 to 175	°F
Injection Rate	Slow	
Back Pressure	25.0 to 100	psi
Screw Speed	Slow-Moderate	

