

**Electrafil® PC CF20 FR BK 7MM**

 Techmer Polymer Modifiers - *Polycarbonate*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber, 20% Filler by Weight
Additive	• Flame Retardant
Features	• Flame Retardant
Appearance	• Black
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.29		ASTM D792
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	1.85E+6	psi	ASTM D638
Tensile Strength (Yield)	19000	psi	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	2.5	ft·lb/in	ASTM D256
<b>Electrical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Surface Resistivity	< 1.0E+4	ohms	ASTM D257
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating (0.06 in)	V-0		UL 94

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	250	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	550 to 600	°F
Middle Temperature	560 to 600	°F
Front Temperature	570 to 600	°F
Nozzle Temperature	570 to 600	°F
Processing (Melt) Temp	550 to 625	°F
Mold Temperature	175 to 225	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Moderate	

**Notes**

<sup>1</sup> Typical properties: these are not to be construed as specifications.

