Electrafil® PC 04007 FR BK

Techmer Polymer Modifiers - *Polycarbonate*

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Stainless Steel Fiber
Features	• Electromagnetic Shielding (EMI) • Flame Retardant
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.23		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	9000	psi	ASTM D638
Tensile Elongation (Yield)	5.0	%	ASTM D638
Flexural Modulus	360000	psi	ASTM D790
Flexural Strength	15100	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	2.2	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	8.3	ft·lb/in	ASTM D4812
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	265	°F	ASTM D648
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0 to 1.0E+3	ohms	ASTM D257
Volume Resistivity	1.0 to 1.0E+3	ohms·cm	ASTM D257
Shielding Effectiveness	50	dB	ASTM D4935
Static Decay	< 0.1	sec	FTMS 101B
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.06 in)	V-0		UL 94
Additional Information	**Nominal Value**	**Unit**	**Test Method**
TPCI #	9691124		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	575 to 600	°F
Middle Temperature	600 to 630	°F
Front Temperature	590 to 620	°F
Nozzle Temperature	590 to 620	°F
Processing (Melt) Temp	580 to 620	°F
Mold Temperature	160 to 190	°F
Injection Rate	Moderate	
Back Pressure	0.00 to 100	psi

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Injection Notes
Screw Speed: Medium Recommendations for Molding and Tool Conditions: Well vented mold Moisture Content, as received: Product is packaged at 0.2% or less.

Notes

[1] Typical properties: these are not to be construed as specifications.

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