

TECHNICAL DATASHEET

TRILFT® LF4650C20

PA6 + Long Carbon Fiber

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.17
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	1,950
Flexural Strength at yield	kg _f /cm ²	D790	2,750
Flexural Modulus	kg _f /cm ²	D790	110,000
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	13
THERMAL			
HDT, 4.6 kgf/cm ²	°C		215
ELECTRICAL			
OTHERS			
Mold Shrinkage (3mm thickness)	%	D955	0.1

※ The figures listed in this table are typical values obtained under the standard test methods and may not be applicable for products that are under different application condition.

PROCESSING GUIDE

TRILFT® LF4650C20 GRADE

PA6 + Long Carbon Fiber

- General processing conditions for TRILFTLF4650C20 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	80
Drying Time	hr	4-6
Moisture Content, Max	%	0.02
Melt Temperature	℃	240~270
Nozzle Temperature	℃	240~270
Front Temperature	℃	240~270
Middle Temperature	℃	240~260
Rear Temperature	℃	240~260
Mold Temperature	℃	60~80
Back Pressure	MPa	<70
Screw Speed	rpm	<60
Injection Pressure	MPa	<70
Injection Speed	%	<60
Hold Pressure	MPa	<50
Injection Cushion	mm	3~6

Global Network

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