

Electrafil® J-1200/CF/20 NAT

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber, 20% Filler by Weight
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm ³	
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	1.9	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.06E+6	psi	ASTM D638
Tensile Strength (Yield)	16800	psi	ASTM D638
Tensile Elongation (Break)	1.2	%	ASTM D638
Flexural Modulus	2.18E+6	psi	ASTM D790
Flexural Strength	23900	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.0	ft-lb/in	ASTM D256
Unnotched Izod Impact	4.5	ft-lb/in	ASTM D256
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+2 to 1.0E+6	ohms·cm	ASTM D257

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	455 to 480	°F
Middle Temperature	465 to 490	°F
Front Temperature	475 to 500	°F
Nozzle Temperature	475 to 500	°F
Processing (Melt) Temp	475 to 525	°F
Mold Temperature	110 to 150	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

Notes

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

