

## General Properties of CF330 BC3024

Items	unit	Test Method <sup>*)</sup>	CF30% Filled Grades/Black
			CF330 BC3024
			High viscosity
Melting Point	℃	ISO 11357-3	370
Glass transition temperature	℃	ISO 11357-2	155
Density	g/cm <sup>3</sup>	ISO 1183	1.41
MVR (400℃, 10kg)	ml/10min	ISO 1133	7
Tensile Strength	MPa	ISO 527-1,2	265
Tensile strain at break	%	ISO 527-1,2	1.5
Flexural Strength	MPa	ISO 178	380
Flexural Modulus	MPa	ISO 178	23,500
Charpy notched impact strength	kJ/m <sup>2</sup>	ISO 179/1eA	6
Deflection Temperature Under Load (1.82MPa)	℃	ISO 75-1,2	355
Mold Shrinkage (80×80×3mmt, Flow direction, Cavity Pressure 100MPa)	%	original method	0.4
Mold Shrinkage (80×80×3mmt, Transverse direction, Cavity Pressure 100MPa)	%	original method	0.7

<sup>\*)</sup> mainly compliant with ISO Standards or original method

## Standard molding conditions of CF330 BC3024

Preliminary drying	Cylinder temperature(℃)				Mold temperature (℃)	Injection speed (mm/s)	Holding pressure (MPa)
	Nozzle	Front section	Center section	Rear section			
140~160℃ more than 3hours	400~430	400~430	380~400	370~390	180~210	20~150	70~120

### [Alert Notes]

\*A cylinder of high temperature type is required. A nozzle diameter of standard size or larger is recommended.

\*The nozzle tends to solidify, hence retraction of the injection unit as well as temperature increase of nozzle and front section of the cylinder is recommended.

\*Please contact us for details.

## NOTES TO USERS

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