LFT-G®CPP-NA-LGF40

产品名称 name：	LFT-G®CPP-NA-LGF40
树脂类型 resin type：	• CPP
纤维类型 fiber type ：	• 长玻纤 Long Glass Fiber
纤维含量 fiber content：	• 40%
颜色 color ：	• 黑色、本色 black and natrue
材料特性 material properties：	• 注塑级,机械性能良好 Injection molding,good mechanical properties

Materials Characteristic/材料参数

Physical	Typical Characteristic	Testing Standard
比重 Specific Gravity	1.22 g/cm^3	ASTM D-792
成型收缩率 Molding Shrinkage	0.10 - 0.30 %	ASTM D-955 (1/8 in (3.2 mm)section)

Mechanical	Typical Characteristic	Testing Standard
拉伸强度 Tensile Strength	130 MPa 128 MPa	ISO：527 ASTM D-638
拉伸模量 Tensile Modulus	8561 MPa 8781 MPa	ISO：527 ASTM D-638
拉伸伸长率 Tensile Elongation	1.8-2.5% 1.8-2.5%	ISO：527 ASTM D-638
弯曲强度 Flexural Strength	183 MPa 185 MPa	GB/T 9341 ASTM D-790
弯曲模量 Flexural Modulus	7104 MPa 7277 MPa	GB/T 9341 ASTM D-790
悬臂梁缺口冲击强度 Notched Izod Impact	50 KJ/m^2 415 J/m	ISO：180 ASTM D-256
简支梁缺口冲击强度 Notched Charpy Impact	50 KJ/m^2	ISO：179

Materials Process guidline/加工参数参考

Thermal	Typical Characteristic	Testing Standard
热变形温度 Deflection Temperature (1.8MPa)	158 °C	ISO 75-2

Flammability	Typical Characteristic	Testing Standard
阻燃性 Flame Retardant	HB @ 1.5 mm	ASTM D-635

Injection	Typical Characteristic
注塑压力 Injection Pressure	69~103 MPa
熔体温度[1] Melt Temperature	210~250 °C
模具温度[2] Mould temperature	38~69 °C
干燥[3] Pre-drying	2~4 hrs @80~90 °C
干燥含水量[4] Dry water content	＜ 0.1 %

Processing Notes/工艺注意事项

Values included in this Property Data Sheet are based on limited laboratory test specimens. These values are typical values and are not meant to be used for setting maximum or minimum values for specification purposes. Any determination of the suitability of the materials shown in this property data sheet for use by the end user is the sole responsibility of the user, who must assure himself that the material as subsequently processed meets the need of his particular product or use. To the best of our knowledge the information in this publication is accurate and reliable, LFT-G® does not assume any liability whatsoever for the accuracy of this information.
Note: [1]The melt temperature is the measured temperature of the melt in the barrel, the customer needs to evaluate the deviation between the set temperature and the measured temperature of the barrel of the machine to avoid carbonization cracking of the material caused by overheating;[2]the mold temperature here refers to the measured mold temperature rather than the set mold temperature,as the mold temperature is related to the appearance and dimensional stability of the product, please evaluate it according to the product requirements；[3]it is recommended to use a dehumidification dryer for drying, customers are requested to evaluate the actual drying temperature and time according to their own drying equipment

conditions within the suggested reference range, in order to achieve moisture content in line with the requirements of production;[4] before injection molding, it is recommended to bake the product with moisture content below 0.1%,the material will degrade when placed in injection molding.

该属性数据表中包含的值是基于有限的实验室测试样品得出的。 这些值是典型值，并非旨在出于规格目的设置最大值或最小值。 确定该属性数据表中显示的材料是否适合最终用户的使用是用户的全部责任，用户必须确保自己随后加工的材料满足其特定产品或用途的需求。 据我们所知，本出版物中的信息准确可靠，LFT-G®对本信息的准确性不承担任何责任。
备注：【1】该熔体温度是炮筒内熔体的实测温度，客户需自行评估机台炮筒设定温度与实测温度之间的偏差，避免因过热引起材料碳化裂解；【2】该处模温是指实测模具温度而非设定模具温度。因模温涉及到产品外观和尺寸稳定性，请客户根据产品要求自行评估；【3】推荐使用除湿干燥机进行干燥，请客户根据自己的烘料设备状况在建议的参考范围内自行评估实际的烘料温度和时间，以期达到符合生产所要求的水分含量；【4】注塑成型前，建议把产品水分含量烘烤至 0.1%以下，防止注塑成型时材料降解。

Introducation/材料简介

LFT-G® is the producct name for long fiber reinforced thermoplastic materials for injection moldings,compression molding and extrusion.Retention of fiber length in the finished part is key to the performance .Fiber length is retained by proper use of free flowing check valves,metering screws and a complete evaluation of the mold to reduce high shear and allow the materials to fill the part while maintaining the critical fiber length.The fiberglass is continuous within the pellet and offers incredible properties and performance when molded correctly.

LFT-G 是长纤维增强热塑性材料，生产的产品适用于注塑，压缩和挤出成型的应用。成品中的纤维长度被部分保留是关键。适当的时候使用止回阀门，完整的评估螺杆和模具，为了减少高剪切，保持纤维长度可以适应填充的材料零件。粒料中的玻璃纤维是连续的，脱模时可以提供优异的材料性能。

Injection molding general processing /模具

Use full round runners with minimum diameters of about 5-6MM;Use maximum allowable gate size no limited;Shorten sprues to mini and taper them to gate in graduated taper;Use large sprue, straight gate, can not use dispensing;Sprue/Runner;Gate minimum about 5mm；Recyling can be added to LFT-G during the molding process.It is recommended that no more than about 3-5% recycle be added to reduce the possibility of property and performance degradation in the molded part.The injection Molding machine should be purged with polyethylene or polypropylene prior to shut down.It is recommended to leave long glass products in the barrel or in the tools.Use metering screw for plasticizing and delivery to material to mold.40% feeding;18:1 to 24:1 l/d ratio;Mold with more than 100Tons machine for better performance;Use 100% a free flow check valve and a large open nozzle to reduce shear.

使用最小直径在 5-6MM 的圆形流道改变物流流动；允许浇口尺寸没有最大上限;缩短浇道，逐渐缩小；使用大水口，直胶口，不能点胶；浇口/流道;浇口最小约 5mm 成型过程中如果将再生料添加到 LFT-G 中，添加范围不能超过 5%,因为会降低或减少成型部件的性能。关闭注塑机之前，先用聚乙烯或聚丙烯冲洗。长玻璃制品不要留在进料筒中。使用螺杆将材料塑化并输送到模腔中。40%下料,18:1/24:1 比率;模具吨位最少 100 吨,使用大口径喷嘴以便降低剪切力.

Web : www.lfrt-plastic.com;www.lft-g.com;
Email : info@lfrtplastic.com
Tel : 0086 7277077
Availability：Global