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## Preliminary Data Sheet ARIANEPLAST PETG/C

20% milled carbon fibres

Latest revision: Januari 2015

Properties	Test methods	Units	ARIANEPLAST PETG/C
<b><i>Physical properties</i></b>			
Specific gravity	ISO 1183	g/cm <sup>3</sup>	1,35
Water absorption at saturation, 23 °C	ISO 62	%	-
Humidity absorption, 23 °C/50 % r.h.	ISO 62	%	-
Mould shrinkage (flow direction, 3 mm)	ISO 2577	%	0,2 - 0,4
<b><i>Mechanical properties</i></b>			
Tensile strength (max.)	ISO 527	MPa	76
Elongation at break	ISO 527	%	7,5
Flexural strength	ISO 178	MPa	110
Flexural modulus	ISO 178	GPa	6,2
IZOD impact strength, notched	ISO 180/1eA	kJ/m <sup>2</sup>	6
IZOD impact strength, unnotched	ISO 180/1eU	kJ/m <sup>2</sup>	60
<b><i>Thermal properties</i></b>			
Heat distortion temperature (1,81 MPa)	ISO 75	°C	65
Relative temperature index, 3 mm, with impact	UL 746B	°C	-
Coefficient of linear thermal expansion	ISO 11359	K-1·10 <sup>-5</sup>	-
<b><i>Flammability</i></b>			
Burning behaviour	IEC 60695-11-10	-	HB @ 3,2 mm
UL recognition	UL94	-	-
<b><i>Electrical properties</i></b>			
Surface resistivity	ASTM D257	Ω/sq	10 <sup>9</sup>
Comparative tracking index	IEC 60112	V	-
Glow wire rating, 1,6 mm	IEC 695-2-1	°C	-

### ***Processing conditions (injection moulding)***

Drying conditions (dehumidifying drier)	: 3 - 5 Hours @ 65 °C
Maximum allowable moisture content	: 0,02 %
Melt temperature	: 235 - 255 °C

Mould temperature : 60 - 75 °C  
Screw speed : 0,1 - 0,2 m/s  
Back pressure : 0 - 1,0 MPa  
Injection pressure : Keep to a minimum  
Injection speed : Fast ram speed  
Hold pressure : Keep to a minimum

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