

# STARAMIDE

## ACF2



**DESCRIPTION** Staramide ACF2 is a 10 % Carbon Fiber Reinforced Polyamide 66 injection Molding Resin

| PROPERTY (1) | UNIT | STANDARD | TYPICAL VALUE (1)<br>Dry As Moulded |
|--------------|------|----------|-------------------------------------|
|--------------|------|----------|-------------------------------------|

### PHYSICAL

|         |                   |          |      |
|---------|-------------------|----------|------|
| Density | g/cm <sup>3</sup> | ISO 1183 | 1.19 |
|---------|-------------------|----------|------|

### MECHANICAL

|                                  |     |         |      |
|----------------------------------|-----|---------|------|
| Flexural Modulus, 2 mm/min       | MPa | ISO 178 | 7500 |
| Flexural Stress, yield, 2 mm/min | MPa | ISO 178 | 230  |
| Tensile Modulus, 1 mm/min        | MPa | ISO 527 | 8000 |
| Tensile Strain, break, 5 mm/min  | %   | ISO 527 | 2.5  |
| Tensile Stress, break, 5 mm/min  | MPa | ISO 527 | 135  |

### IMPACT

|                                    |                   |            |   |
|------------------------------------|-------------------|------------|---|
| Izod Impact, notched 80*10*4 +23°C | kJ/m <sup>2</sup> | ISO 180/1A | 8 |
|------------------------------------|-------------------|------------|---|

### THERMAL

|                                  |    |         |     |
|----------------------------------|----|---------|-----|
| Vicat Softening Temp, Rate B/120 | °C | ISO 306 | 255 |
|----------------------------------|----|---------|-----|

### ELECTRICAL

|                          |     |           |          |
|--------------------------|-----|-----------|----------|
| Surface Resistivity, ROA | Ohm | IEC 60093 | 1.00E+07 |
|--------------------------|-----|-----------|----------|

Source RJF, last update 01-07-2010

(1) Typical values for natural color unless specified otherwise. Do not constitute a specification. Significant variations are possible for colors

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| PARAMETER                   | SETTING   | UNIT |
|-----------------------------|-----------|------|
| Drying Temperature          | 75 - 85   | °C   |
| Drying Time                 | 4 - 6     | hrs  |
| Maximum Moisture Content    | 0.2       | %    |
| Mold Temperature            | 70 - 90   | °C   |
| Rear - Zone 1 Temperature   | 260 280   | °C   |
| Middle - Zone 2 Temperature | 270 - 280 | °C   |
| Front - Zone 3 Temperature  | 270 - 290 | °C   |
| Melt Temperature            | 270 - 290 | °C   |

**PROCESSING PARAMETERS:** see above typical molding conditions.

**DRYING:** is not essential when material is delivered in sealed bags with moisture content below 0.2%.

**BARRELS, SCREWS, MOULDS:** use wear resisting steel or alloy such as bimetallic cylinders, nitrided screws.

**USE OF REGRIND:** the properties of the component should be checked in order to ascertain the maximum acceptable level of regrind.

**SAFETY:** please refer to Material Safety Datasheet

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