

### LFT-G®PA66-BC05B

产品名称 name:	LFT-G®PA66-BC05B
树脂类型 resin type:	● 尼龙 66 PA66
纤维类型 fiber type :	● 长碳纤 Long Carbon Fiber
纤维含量 fiber content:	● 50%
颜色 color :	● 黑色 Black
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	1.33 g/cm <sup>3</sup>	ASTM D-792
成型收缩率 Molding Shrinkage	0.10 - 0.20 %	ASTM D-955 (1/8 in (3.2 mm)section)

Mechanical	Typical Characteristic	Testing Standard
拉伸强度 Tensile Strength	287 MPa 285 MPa	ISO: 527 ASTM D-638
拉伸模量 Tensile Modulus	33963 MPa 33812 MPa	ISO: 527 ASTM D-638
拉伸伸长率 Tensile Elongation	0.5-1.5% 0.5-1.5%	ISO: 527 ASTM D-638
弯曲强度 Flexural Strength	392 MPa 390 MPa	GB/T 9341 ASTM D-790
弯曲模量 Flexural Modulus	21918 MPa 21586 MPa	GB/T 9341 ASTM D-790
悬臂梁缺口冲击强度 Notched Izod Impact	31 KJ/m <sup>2</sup> 285 J/m	ISO: 180 ASTM D-256
简支梁缺口冲击强度 Notched Charpy Impact	30 KJ/m <sup>2</sup>	ISO: 179



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 0.05%,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<sup>®</sup>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 0.05%以下，防止注塑成型时材料降解。

## Introduction/材料简介

**LFT-G<sup>®</sup>**

is the product 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; Recycling 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。

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**Availability** : Global

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