

P1130RCF

Recycled Carbon Fiber
Reinforced Impact-modified
Nylon 6



上緯綠金能股份有限公司
SWANCOR REGENER CO., LTD.

Product Description

P1130RCF is comprised of impact-modified PA6 and recycle carbon fiber., is balance stiffness and toughness. P1130RCF has good melting flow property and is suitable for injection molding to manufacture complex shape products of composite materials, such as automobile parts 、bicycle parts or low temperature impact resistance parts, etc.

Technical Data Sheet

	Property	Unit	Test Method	P1130RCF
General properties	Content reinforcement	wt%	--	30
	Specific gravity	g/cm ³	ISO 1183	1.22~1.24
Mechanical Properties	Tensile modulus	Mpa	ISO 527-1,2	17000~18000
	Tensile strength at break	Mpa	ISO 527-1,2	140~150
	Elongation at break	%	ISO 527-1,2	2~3
	Flexural strength	Mpa	ISO 178	12000~13000
	Flexural strength	Mpa	ISO 178	210~220
	Charpy impact strength(unnotched)	kJ/m ²	ISO 179/1eA	50~60
Other Properties	Surface resistivity	Ohm	IEC 60093	10 ⁴⁻⁶
	Melt Flow Index	g/10min	ASTM D1238	5~10

The above values is testing at 23°C, and only for reference of the selected grade

The data presented herein are believed to be accurate and reliable. We require customers to inspect and test our product before use and to satisfy themselves as to contents and suitability for their specific applications. Information herein is to assist customers in determining whether our products are suitable for their applications but not to be taken as a guarantee, express warranty or implied warranty of merchantability or fitness for particular purpose, nor is any protection from any law or patent to be inferred. All patent rights are reserved. The exclusive remedy for all proven claims is limited to replacement of our material and in no event shall we be liable for special, incidental or consequential damages.

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Drying method

Before injection molding process, we advise P1130RCF should be dehumidified by hopper dryer or either of these equipped with a dehumidifier can be used in hot-air blow-drying. The degree of drying achieved through hot-air blow-drying is determined by the pellet shape, initial and final water content, drying temperature and the temperature of and relative humidity of the dryer intake air. Drying condition recommendations please refer to the table below :

Drying Conditions

Properties	Unit	Value
Temperatures	°C	80~100
Time	hour	4~10

Injection molding recommendations

P1130RCF can be processed on commercially available injection molding machines with standard screws according to the recommendations of the machine manufacturer. To improve weld-line strength, we recommend that mold-wall temperatures are kept as high as possible, with adequate holding pressure times for reducing structure defect at wild line part. Injection molding recommendations please refer to the table below :

Typical Injection Molding Conditions

Properties	Unit	Value
Feed Zone	°C	240~280
Compression Zone	°C	250~290
Metering Zone	°C	250~290
Nozzle zone	°C	240~280
Mold Temperature	°C	70~130
Screw Speed	rpm	30~50
Injection speed	--	High
Back Pressure	--	Medium to maximum

Packaging

25Kg PE Inner-lined Paper Bag

Storage

Keep away from ignition source; flame, pilot light, electrical sparks, and sparking tools. Do not store in direct sunlight. NO SMOKING.

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