



**Product Data Sheet &  
General Processing Conditions**

**EMI 331 C FR  
Polycarbonate (PC)  
10% Glass Fiber  
Stainless Steel Fiber  
Electrically Conductive  
EMI/RFI/ESD Protection  
Flame Retardant**



**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Primary Additive	5 %	5 %	
Specific Gravity	1.42	1.42	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0030 - 0.0040 in/in	0.30 - 0.40 %	D 955

**MECHANICAL**

Impact Strength, Izod notched 1/8 in (3.2 mm) section	0.8 ft-lbs/in	43 J/m	D 256
unnotched 1/8 in (3.2 mm) section	8.0 ft-lbs/in	427 J/m	D 4812
Tensile Strength	11000 psi	76 MPa	D 638
Tensile Elongation	3.0 - 5.0 %	3.0 - 5.0 %	D 638
Tensile Modulus	0.60 x 10 <sup>6</sup> psi	4137 MPa	D 638
Flexural Strength	20000 psi	138 MPa	D 790
Flexural Modulus	0.60 x 10 <sup>6</sup> psi	4137 MPa	D 790

**ELECTRICAL**

Volume Resistivity	< 1000 ohm.cm	< 1000 ohm.cm	D 257
Surface Resistivity	< 1E6 ohm/sq	< 1E6 ohm/sq	D 257
Surface Resistance	< 1E5 ohm	< 1E5 ohm	ESD STM11.11
Static Decay MIL-PRF-81705D, 5kV to 50 V, 12% RH	< 2.00 s	< 2.00 s	FTMS101C 4046.1

**THERMAL**

Ignition Resistance* Flammability	V-0 @ 1/16 in	V-0 @ 1.5 mm	UL94
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**EMI**

Shielding Effectiveness @ 3 mm thickness	35 dB @ 300 MHz	35 dB @ 300 MHz	D 4935
Shielding Effectiveness @ 3 mm thickness	32 dB @ 500 MHz	32 dB @ 500 MHz	D 4935
Shielding Effectiveness @ 3 mm thickness	31 dB @ 700 MHz	31 dB @ 700 MHz	D 4935
Shielding Effectiveness @ 3 mm thickness	32 dB @ 1000 MHz	32 dB @ 1000 MHz	D 4935
Shielding Effectiveness @ 3 mm thickness	33 dB @ 1300 MHz	33 dB @ 1300 MHz	D 4935
Shielding Effectiveness @ 3 mm thickness	35 dB @ 1500 MHz	35 dB @ 1500 MHz	D 4935

**PROPERTY NOTES**

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

\* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.

#### GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	530 - 580 °F	277 - 304 °C
Mold Temperature	160 - 250 °F	71 - 121 °C
Drying	4 hrs @ 250 °F	4 hrs @ 121 °C
Moisture Content	0.02 %	0.02 %
Dew Point	-20 °F	-29 °C

#### PROCESSING NOTES

Use a reverse barrel profile. Remove hopper magnets. Allow 4 - 5 shots to properly disperse the conductive fibers. The surface finish should have a silver streaking appearance, not clumps.

Remove hopper magnets.

Desiccant Type Dryer Required.

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This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein.

Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

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