Product Data Sheet &
General Processing Conditions

EMI 2561 HF
Polycarbonate/ABS Alloy (PC/ABS)
Stainless Steel Fiber
Electrically Conductive
EMI/RFI Shielding
High Flow

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.25	1.25	D 792
Molding Shrinkage			
1/8 in (3.2 mm) section	0.0040 - 0.0060 in/in	0.40 - 0.60 %	D 955
MECHANICAL			
Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	1.5 ft-lbs/in	80 J/m	D 256
unnotched 1/8 in (3.2 mm) section	8.0 ft-lbs/in	427 J/m	D 4812
Tensile Strength	8000 psi	55 MPa	D 638
Tensile Elongation	5.0 - 8.0 %	5.0 - 8.0 %	D 638
Tensile Modulus	0.38 x 10^6 psi	2620 MPa	D 638
Flexural Strength	13500 psi	93 MPa	D 790
Flexural Modulus	0.42 x 10^6 psi	2896 MPa	D 790
ELECTRICAL			
Volume Resistivity	< 1E1 ohm.cm	< 1E1 ohm.cm	D 257
Surface Resistivity	< 1E4 ohm/sq	< 1E4 ohm/sq	D 257
Surface Resistance	< 1E3 ohm	< 1E3 ohm	ESD STM11.11
Static Decay			
MIL-PRF-81705D, 5kV to 50 V, 12% RH	< 0.50 s	< 0.50 s	FTMS101C 4046.1
EMI			
Shielding Effectiveness @ 2 mm thickness	60 dB @ 300 MHz	60 dB @ 300 MHz	D 4935
Shielding Effectiveness @ 2 mm thickness	60 dB @ 500 MHz	60 dB @ 500 MHz	D 4935
Shielding Effectiveness @ 2 mm thickness	61 dB @ 700 MHz	61 dB @ 700 MHz	D 4935
Shielding Effectiveness @ 2 mm thickness	62 dB @ 1000 MHz	62 dB @ 1000 MHz	D 4935
Shielding Effectiveness @ 2 mm thickness	63 dB @ 1300 MHz	63 dB @ 1300 MHz	D 4935
Shielding Effectiveness @ 2 mm thickness	65 dB @ 1500 MHz	65 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.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	470 - 525 °F	243 - 274 °C
Mold Temperature	125 - 200 °F	52 - 93 °C
Drying	4 hrs @ 200 °F	4 hrs @ 93 °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.
Desiccant Type Dryer Required.

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