

## TECHNICAL DATA AND PROCESS SHEET

### SILICONE LUBRICATED POLYSTYRENE

#### INLUBE INX-STY-11085

#### TYPICAL PROPERTIES

<b>PROPERTY</b>	<b>VALUE</b>	<b>UNIT</b>	<b>METHOD</b>
<b>PHYSICAL</b>			
SPECIFIC GRAVITY	1.04	-	ASTM D792
MOLD SHRINKAGE, FLOW 0.125"	0.5-0.7	%	ASTM D955
<b>MECHANICAL</b>			
TENSILE STRENGTH, BRK	3,600	psi	ASTM D638
TENSILE ELONGATION	>10	%	ASTM D638
FLEXURAL STRENGTH	6,500	psi	ASTM D790
FLEXURAL MODULUS	340,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	1.8	ft-lb/in	ASTM D256
<b>THERMAL</b>			
HDT @ 264 psi	180	°F	ASTM D648
<b>ELECTRICAL</b>			
VOLUME RESISTIVITY	10 <sup>17</sup>	Ohm-cm	ASTM D257
<b>PROCESSING</b>			
DRYING TEMPERATURE	170	°F	
DRYING TIME (not required)	2-4	hrs	
MELT TEMPERATURE	380 - 480	°F	
MOLD TEMPERATURE	100-150	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.0005-0.001	in	

6/20/11 DJV

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