

TECHNICAL DATA AND PROCESS SHEET

15% CARBON FIBER REINFORCED 15% PTFE LUBRICATED NYLON 610

INLUBE PA610CF15TF15

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.25		1.25	
SPECIFIC VOLUME		22.16	in ³ /lb	0.800	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	0.19	%	0.19	%
MOLD SHRINKAGE	D955	0.4-0.5	%	0.4-0.5	%
MECHANICAL					
TENSILE STRENGTH	D638	18,500	psi	128	MPa
ELONGATION, YIELD	D638	3-4	%	3-4	%
FLEXURAL STRENGTH	D790	29,000	psi	200	MPa
FLEXURAL MODULUS	D790	1,100,000	psi	7,584	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1	ft.lb./in.	64	J/m
UNNOTCHED 1/8"		10	ft.lb./in.	533	J/m
ROCKWELL HARDNESS					
THERMAL					
HDTUL @ 264 PSI	D648	400	°F	204	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	2.2	in./in. F x10 ⁻⁵	3.96	mm/mm C 10 ⁻⁶
FLAMMABILITY ¹	U.L.Subj 94	HB@1/16	in	HB@ 1.5	mm
ELECTRICAL					
SURFACE RESISTIVITY		10e2 -10e6	ohms/sq	10e2 -10e6	ohms/sq
PROCESSING					
DRYING TEMPERATURE		175	°F	79	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		460-525	°F	238 - 275	°C
MOLD TEMPERATURE		200	°F	93	°C
BACK PRESSURE		50-100	psi	0.3 - 0.7	MPa
SCREW SPEED		40-70	rpm	40-70	rpm
VENT DEPTH		0.0005-0.001	in	0.0125 - 0.025	mm

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