

TECHNICAL DATA AND PROCESS SHEET

30% GLASS FIBER REINFORCED, PTFE/SILICONE LUBRICATED PBT

INLUBE PBTGF30TF13SI2

TYPICAL PROPERTIES

PROPERTY	ASTM	English	UNITS	Metric SI	UNITS
	METHOD				
GENERAL					
SPECIFIC GRAVITY	D792	1.66		1.66	
SPECIFIC VOLUME		16.69	in ³ /lb	0.602	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	0.05	%	0.05	%
MOLD SHRINKAGE	D955	0.1-0.2	%	0.1-0.2	%
MECHANICAL					
TENSILE STRENGTH	D638	16,500	psi	114	MPa
ELONGATION, YIELD	D638	2-4	%	2-4	%
FLEXURAL STRENGTH	D790	25,000	psi	172	MPa
FLEXURAL MODULUS	D790	1,300,000	psi	8,963	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1.7	ft.lb./in.	91	J/m
UNNOTCHED 1/8"		13	ft.lb./in.	693	J/m
ROCKWELL HARDNESS					
THERMAL					
HDTUL	D648	425	°F	218	°C
@ 264 PSI					
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	1.4	in./in. F x10 ⁻⁵	2.52	mm/mm C 10 ⁻⁶
FLAMMABILITY ¹	U.L.Subj 94	HB@1/16	in	HB@ 1.5	mm
ELECTRICAL					
SURFACE RESISTIVITY		10e ¹⁶	ohms/sq	10e ¹⁶	ohms/sq
PROCESSING					
DRYING TEMPERATURE		230	°F	110	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		430-500	°F	220- 260	°C
MOLD TEMPERATURE		175	°F	79	°C
BACK PRESSURE		50-100	psi	0.3 - 0.7	MPa
SCREW SPEED		40-70	rpm	40-70	rpm
VENT DEPTH		0.0015-0.003	in	0.038 - 0.075	mm
				2/2/2012	JAD

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