

**TECHNICAL DATA AND PROCESS SHEET**

**10% GLASS FIBER REINFORCED, 15% PTFE LUBRICATED POLYCARBONATE**

**INLUBE PCGF10TF15**

**TYPICAL PROPERTIES**

<b>PROPERTY</b>	<b>ASTM METHOD</b>	<b>English</b>	<b>UNITS</b>	<b>Metric SI</b>	<b>UNITS</b>
<b>GENERAL</b>					
SPECIFIC GRAVITY	D792	1.43		1.43	
SPECIFIC VOLUME		19.37	in <sup>3</sup> /lb	0.699	cm <sup>3</sup> /gm
WATER ABSORPTION (24 Hrs)	D570	0.1	%	0.10	%
MOLD SHRINKAGE	D955	0.2-0.4	%	0.2-0.4	%
<b>MECHANICAL</b>					
TENSILE STRENGTH	D638	9,000	psi	62	MPa
ELONGATION, YIELD	D638	4-6	%	4-6	%
FLEXURAL STRENGTH	D790	14,000	psi	97	MPa
FLEXURAL MODULUS	D790	450,000	psi	3,103	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		2.3	ft.lb./in.	123	J/m
UNNOTCHED 1/8"		20	ft.lb./in.	1066	J/m
ROCKWELL HARDNESS		M85	M Scale	M85	M Scale
<b>THERMAL</b>					
HDTUL @ 264 PSI	D648	290	°F	143	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	2	in./in. F x10 <sup>-5</sup>	3.6	mm/mm C 10 <sup>-6</sup>
FLAMMABILITY <sup>1</sup>	U.L.Subj 94	HB@1/16	in	HB@ 1.5	mm
<b>ELECTRICAL</b>					
SURFACE RESISTIVITY		10e <sup>16</sup>	ohms/sq	10e <sup>16</sup>	ohms/sq
<b>PROCESSING</b>					
DRYING TEMPERATURE		250	°F	121	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		540-630	°F	280- 330	°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		0.0015-0.003	in	0.038 - 0.075	mm

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