

**TECHNICAL DATA AND PROCESS SHEET**

**30% CARBON FIBER REINFORCED 15% PTFE LUBRICATED COPOLYMER ACETAL  
 INLUBE POMCCF30TF15**

**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	1.58		1.58	
SPECIFIC VOLUME		17.5	in <sup>3</sup> /lb	0.633	cm <sup>3</sup> /gm
WATER ABSORPTION (24 Hrs)	D570	0.5	%	0.50	%
MOLD SHRINKAGE	D955	0.4-0.6	%	0.4-0.6	%
<b>MECHANICAL</b>					
TENSILE STRENGTH	D638	21,500	psi	148	MPa
ELONGATION, YIELD	D638	1-2	%	1-2	%
FLEXURAL STRENGTH	D790	34,000	psi	234	MPa
FLEXURAL MODULUS	D790	2,100,000	psi	14,479	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1.0	ft.lb./in.	53	J/m
UNNOTCHED 1/8"		4	ft.lb./in.	213	J/m
ROCKWELL HARDNESS					
<b>THERMAL</b>					
HDTUL	D648	325	°F	163	°C
@ 264 PSI					
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>2</sup> -10e <sup>6</sup>	ohms/sq	10e <sup>2</sup> -10e <sup>6</sup>	ohms/sq
<b>PROCESSING</b>					
DRYING TEMPERATURE		180	°F	82	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		375-410	°F	190 - 210	°C
MOLD TEMPERATURE		200	°F	93	°C
BACK PRESSURE		50-100	psi	0.3 - 0.7	MPa
SCREW SPEED		30-60	rpm	30-60	rpm
VENT DEPTH		0.0005-0.001	in	0.0125 - 0.0251	mm

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