

TECHNICAL DATA AND PROCESS SHEET

30% GLASS FIBER REINFORCED 15% PTFE LUBRICATED COPOLYMER ACETAL

INLUBE POMCGF30TF15

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.73		1.73	
SPECIFIC VOLUME		16.0	in ³ /lb	0.578	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	0.3	%	0.30	%
MOLD SHRINKAGE	D955	0.4-0.7	%	0.4-0.7	%
MECHANICAL					
TENSILE STRENGTH	D638	19,000	psi	131	MPa
ELONGATION, YIELD	D638	1-2	%	1-2	%
FLEXURAL STRENGTH	D790	25,000	psi	172	MPa
FLEXURAL MODULUS	D790	1,200,000	psi	8,274	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		0.7	ft.lb./in.	37	J/m
UNNOTCHED 1/8"		7	ft.lb./in.	373	J/m
ROCKWELL HARDNESS					
THERMAL					
HDTUL	D648	310	°F	154	°C
@ 264 PSI					
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	2.5	in./in. F x10 ⁻⁵	4.5	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		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

This information is based on our experience to date and we believe it to be reliable. It is intended only as a guide for use at your discretion and risk. We cannot guarantee favorable results and assume no liability in connection with its use of the products described. Each user bears full responsibility for making it's own determination as to the suitability of the product described. None of this information is to be taken as a license to operate under, or recommendation to infringe any patents