

**TECHNICAL DATA AND PROCESS SHEET**

**30% GLASS FIBER REINFORCED 15% PTFE LUBRICATED PPA**

**INLUBE PPAGF30TF15**

**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	1.56		1.56	
SPECIFIC VOLUME		17.8	in <sup>3</sup> /lb	0.641	cm <sup>3</sup> /gm
WATER ABSORPTION (24 Hrs)	D570	0.2	%	0.20	%
MOLD SHRINKAGE	D955	0.2-0.5	%	0.2-0.5	%
<b>MECHANICAL</b>					
TENSILE STRENGTH	D638	28,500	psi	197	MPa
ELONGATION, YIELD	D638	1-2	%	1-2	%
FLEXURAL STRENGTH	D790	35,000	psi	241	MPa
FLEXURAL MODULUS	D790	1,450,000	psi	9,997	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		2.0	ft.lb./in.	107	J/m
UNNOTCHED 1/8"		14	ft.lb./in.	746	J/m
ROCKWELL HARDNESS					
<b>THERMAL</b>					
HDTUL @ 264 PSI	D648	540	°F	282	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	1.5	in./in. F x10 <sup>-5</sup>	2.7	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		180	°F	82	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		625	°F	330	°C
MOLD TEMPERATURE		275	°F	135	°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	0.0125-0.0251	mm

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