

PROVISIONAL TECHNICAL DATA AND PROCESS SHEET

**10% PTFE LUBRICATED, PERMANENTLY ANTI STATIC, FLAME RETARDANT
 POLYCARBONATE/ABS ALLOY**

INELEC PCABSASTF10FR

TYPICAL PROPERTIES

PROPERTY	VALUE	UNIT	METHOD
PHYSICAL			
SPECIFIC GRAVITY	1.35 -		ASTM D792
MOLD SHRINKAGE, FLOW 0.125"	0.6-0.8	%	
MECHANICAL			
TENSILE STRENGTH, BRK	5,500	psi	ASTM D638
TENSILE ELONGATION	2-5	%	ASTM D638
FLEXURAL MODULUS	300,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	2.5	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	10-12	ft-lb/in	ASTM D256
THERMAL			
HDTUL @ 264 PSI	205	°F	ASTM D648
ELECTRICAL			
SURFACE RESISTIVITY	10 ⁹ -10 ¹¹	Ohm/sq	ASTMD257
PROCESSING			
DRYING TEMPERATURE	200	°F	
DRYING TIME	3-4	hrs	
MAX MOISTURE CONTENT	0.02	%	
MELT TEMPERATURE	470-500	°F	
MOLD TEMPERATURE	125-180	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.001-0.002	in	