

## TECHNICAL DATA AND PROCESS SHEET

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### 15% GLASS FIBER REINFORCED, 15% PTFE LUBRICATED NYLON 12

#### INLUBE PA12GF15TF15

#### TYPICAL PROPERTIES

<u>PROPERTY</u>	<u>VALUE</u>	<u>UNIT</u>	<u>METHOD</u>
<b>PHYSICAL</b>			
SPECIFIC GRAVITY	1.23	-	ASTM D792
WATER ABSORPTION	0.1	%	ASTM D570
MOLD SHRINKAGE	0.4 – 0.8	%	
<b>MECHANICAL</b>			
TENSILE STRENGTH, BRK	11,700	psi	ASTM D638
TENSILE ELONGATION	4-6	%	ASTM D638
FLEXURAL MODULUS	450,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	2.7	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	12-16	ft-lb/in	ASTM D256
<b>THERMAL</b>			
HDTUL @ 264 PSI	320	°F	ASTM D648
<b>ELECTRICAL</b>			
SURFACE RESISTIVITY	>10EXP17	Ohm/Sq	ASTM D257
<b>PROCESSING</b>			
DRYING TEMPERATURE	180	°F	
DRYING TIME	4	hrs	
MELT TEMPERATURE	440-460	°F	
MOLD TEMPERATURE	160-180	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.0005-0.001	in	

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