



TECHNICAL DATA AND PROCESS SHEET

**30% CARBON FIBER REINFORCED, 13% PTFE/2% SILICONE LUBRICATED
NYLON 6/12**

INLUBE PA612CF30TF13SI2

TYPICAL PROPERTIES

PROPERTY	VALUE	UNIT	METHOD
PHYSICAL			
SPECIFIC GRAVITY	1.30	-	ASTM D792
WATER ABSORPTION (24 hr.)	0.10	%	ASTM D570
WATER ABSORPTION (Saturated)	1.5	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	0.2-0.4	%	
MECHANICAL			
TENSILE STRENGTH, BRK	28,010	psi	ASTM D638
TENSILE ELONGATION	1-3	%	ASTM D638
FLEXURAL STRENGTH	44,324	psi	ASTM D790
FLEXURAL MODULUS	2,757,208	psi	ASTM D790
IZOD IMPACT, NOTCHED	1.7	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	11-13	ft-lb/in	ASTM D256
THERMAL			
HDTUL @ 264 PSI	420	°F	ASTM D648
ELECTRICAL			
SURFACE RESISTIVITY	10 ² – 10 ⁶	Ohm/Sq	ASTM D257
PROCESSING			
DRYING TEMPERATURE	175	°F	
DRYING TIME	4	hrs	
MELT TEMPERATURE	510-530	°F	
MOLD TEMPERATURE	200	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.0005-0.001	in	

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