

TECHNICAL DATA AND PROCESS SHEET

20% GLASS FIBER REINFORCED 15% PTFE LUBRICATED PBT

INLUBE PBTGF20TF15

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English		Metric SI		
		English	UNITS	Metric SI	UNITS	
GENERAL						
SPECIFIC GRAVITY	D792	1.56		1.56		
SPECIFIC VOLUME		17.76	in ³ /lb	0.641	cm ³ /gm	
WATER ABSORPTION (24 Hrs)	D570	0.05	%	0.05	%	
MOLD SHRINKAGE	D955	0.3-0.4	%	0.3-0.4	%	
MECHANICAL						
TENSILE STRENGTH	D638	15,000	psi	103	MPa	
ELONGATION, YIELD	D638	3-5	%	3-5	%	
FLEXURAL STRENGTH	D790	24,000	psi	165	MPa	
FLEXURAL MODULUS	D790	1,000,000	psi	6,895	MPa	
SHEAR STRENGTH	D732					
IZOD IMPACT STRENGTH	D256					
NOTCHED 1/8"		1	ft.lb./in.	53	J/m	
UNNOTCHED 1/8"		15	ft.lb./in.	800	J/m	
ROCKWELL HARDNESS						
THERMAL						
HDTUL	D648	410	°F	210	°C	
@ 264 PSI						
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	2.2	in./in. F x10 ⁻⁵	3.96	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		230	°F	110	°C	
DRYING TIME		4	hrs	4	hrs	
MELT TEMPERATURE		430-500	°F	220- 260	°C	
MOLD TEMPERATURE		225	°F	107	°C	
BACK PRESSURE		50-100	psi	0.3 - 0.7	MPa	
SCREW SPEED		40-70	rpm	40-70	rpm	
VENT DEPTH		0.0015-0.003	in	0.038 - 0.075	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.