

TECHNICAL DATA AND PROCESS SHEET

15% PTFE LUBRICATED POLYCARBONATE/ABS ALLOY

INLUBE PCABSTF15

TYPICAL PROPERTIES

<u>PROPERTY</u>	<u>VALUE</u>	<u>UNIT</u>	<u>METHOD</u>
PHYSICAL			
SPECIFIC GRAVITY	1.20	-	ASTM D792
MOLD SHRINKAGE, FLOW 0.125"	0.5-0.7	%	
MECHANICAL			
TENSILE STRENGTH, BRK	6700	psi	ASTM D638
TENSILE ELONGATION	10-20	%	ASTM D638
FLEXURAL MODULUS	330,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	3.50	ft-lb/in	ASTM D256
THERMAL			
HDTUL @ 264 PSI	270	°F	ASTM D648
ELECTRICAL			
VOLUME RESISTIVITY	>1exp17	Ohm-cm	ASTM D257
PROCESSING			
DRYING TEMPERATURE	200	°F	
DRYING TIME	3-4	hrs	
MAX MOISTURE CONTENT	0.02	%	
MELT TEMPERATURE	475-520	°F	
MOLD TEMPERATURE	140-180	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.001-0.002	in	

Revised TSC 11/20/09

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