

**TECHNICAL DATA AND PROCESS SHEET**

**30% CARBON FIBER REINFORCED, 15% PTFE LUBRICATED POLYCARBONATE**

**INLUBE PCCF30TF15**

**TYPICAL PROPERTIES**

<b>PROPERTY</b>	<b>ASTM METHOD</b>	<b>English</b>	<b>UNITS</b>	<b>Metric SI</b>	<b>UNITS</b>
<b>GENERAL</b>					
SPECIFIC GRAVITY	D792	1.43		1.43	
SPECIFIC VOLUME		19.37	in <sup>3</sup> /lb	0.699	cm <sup>3</sup> /gm
WATER ABSORPTION (24 Hrs)	D570	0.06	%	0.06	%
MOLD SHRINKAGE	D955	0.05-0.1	%	0.05-0.1	%
<b>MECHANICAL</b>					
TENSILE STRENGTH	D638	22,000	psi	152	MPa
ELONGATION, YIELD	D638		%	0	%
FLEXURAL STRENGTH	D790	33,000	psi	228	MPa
FLEXURAL MODULUS	D790	1,900,000	psi	13,100	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1	ft.lb./in.	53	J/m
UNNOTCHED 1/8"		10	ft.lb./in.	533	J/m
ROCKWELL HARDNESS		M92	M Scale	M92	M Scale
<b>THERMAL</b>					
HDTUL	D648	290	°F	143	°C
@ 264 PSI					
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	1	in./in. F x10 <sup>-5</sup>	1.8	mm/mm C 10 <sup>-6</sup>
FLAMMABILITY <sup>1</sup>	U.L.Subj 94	HB@1/16	in	HB@ 1.5	mm
<b>ELECTRICAL</b>					
SURFACE RESISTIVITY		10e2-10e4	ohms/sq	10e2-10e4	ohms/sq
<b>PROCESSING</b>					
DRYING TEMPERATURE		250	°F	121	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		540-630	°F	280- 330	°C
MOLD TEMPERATURE		200	°F	93	°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

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