

TECHNICAL DATA AND PROCESS SHEET

30% GLASS FIBER REINFORCED, 15% PTFE LUBRICATED POLYCARBONATE

INLUBE PCGF30TF15

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.55		1.55	
SPECIFIC VOLUME		17.87	in ³ /lb	0.645	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	0.06	%	0.06	%
MOLD SHRINKAGE	D955	0.1-0.2	%	0.1-0.2	%
MECHANICAL					
TENSILE STRENGTH	D638	17,500	psi	121	MPa
ELONGATION, YIELD	D638	2-4	%	2-4	%
FLEXURAL STRENGTH	D790	26,000	psi	179	MPa
FLEXURAL MODULUS	D790	1,200,000	psi	8,274	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		3.1	ft.lb./in.	165	J/m
UNNOTCHED 1/8"		12	ft.lb./in.	640	J/m
ROCKWELL HARDNESS		M95	M Scale	M95	M Scale
THERMAL					
HDTUL @ 264 PSI	D648	300	°F	149	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	1.5	in./in. F x10 ⁻⁵	2.7	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		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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