

TECHNICAL DATA AND PROCESS SHEET

20% PTFE LUBRICATED ACETAL HOMOPOLYMER

INLUBE POMHTF20

TYPICAL PROPERTIES

<u>PROPERTY</u>	<u>VALUE</u>	<u>UNIT</u>	<u>METHOD</u>
PHYSICAL			
SPECIFIC GRAVITY	1.53	-	ASTM D792
WATER ABSORPTION	0.2	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	1.8-2.3	%	ASTM D955
MECHANICAL			
TENSILE STRENGTH, BRK	7,700	psi	ASTM D638
TENSILE ELONGATION (BRK)	10-15	%	ASTM D638
FLEXURAL MODULUS	380,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	0.9	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	10-12	ft-lb/in	ASTM D4812
THERMAL			
HDTUL @ 264 PSI	204	°F	ASTM D648
ELECTRICAL			
SURFACE RESISTIVITY	$>10^{17}$	Ohm/Sq	ASTM D257
PROCESSING			
DRYING TEMPERATURE	180	°F	
DRYING TIME	4	hrs	
MELT TEMPERATURE	390-410	°F	
MOLD TEMPERATURE	180-220	°F	
BACK PRESSURE	25-50	psi	
SCREW SPEED	30-60	rpm	
VENT DEPTH	0.0005-0.001	in	

REVISED: 1/11/11 DJV

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