

**TECHNICAL DATA AND PROCESS SHEET**

**20% CARBON FIBER REINFORCED 15% PTFE LUBRICATED PPA**

**INLUBE PPACF20TF15**

**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	1.38		1.38	
SPECIFIC VOLUME		20.1	in <sup>3</sup> /lb	0.725	cm <sup>3</sup> /gm
WATER ABSORPTION (24 Hrs)	D570	0.2	%	0.20	%
MOLD SHRINKAGE	D955	0.05-0.2	%	0.05-0.2	%
<b>MECHANICAL</b>					
TENSILE STRENGTH	D638	33,000	psi	228	MPa
ELONGATION, YIELD	D638				
FLEXURAL STRENGTH	D790	48,000	psi	331	MPa
FLEXURAL MODULUS	D790	2,300,000	psi	15,858	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1.3	ft.lb./in.	69	J/m
UNNOTCHED 1/8"		10	ft.lb./in.	533	J/m
ROCKWELL HARDNESS					
<b>THERMAL</b>					
HDTUL	D648	545	°F	285	°C
@ 264 PSI					
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696				
FLAMMABILITY <sup>1</sup>	U.L.Subj 94	HB@1/16	in	HB@1.5	mm
<b>ELECTRICAL</b>					
SURFACE RESISTIVITY		10e <sup>2</sup> -10e <sup>6</sup>	ohms/sq	10e <sup>2</sup> -10e <sup>6</sup>	ohms/sq
<b>PROCESSING</b>					
DRYING TEMPERATURE		180	°F	82	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		625	°F	330	°C
MOLD TEMPERATURE		275	°F	135	°C
BACK PRESSURE		50-100	psi	0.3 - 0.7	MPa
SCREW SPEED		40-70	rpm	40-70	rpm
VENT DEPTH		0.0005-0.001	in	0.0125-0.0251	mm

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