

TECHNICAL DATA AND PROCESS SHEET

20% GLASS FIBER REINFORCED, 15% PTFE LUBRICATED HEAT STABILIZED POLYPROPYLENE BASED ON FDA COMPLIANT RAW MATERIALS.

INLUBE PPGF20TF15HSFC

TYPICAL PROPERTIES

<u>PROPERTY</u>	<u>VALUE</u>	<u>UNIT</u>	<u>METHOD</u>
PHYSICAL			
SPECIFIC GRAVITY	1.15	-	ASTM D792
WATER ABSORPTION	0.03	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	0.2-0.5	%	
MECHANICAL			
TENSILE STRENGTH, BRK	5,800	psi	ASTM D638
FLEXURAL STRENGTH	8,200	psi	ASTM D790
FLEXURAL MODULUS	675,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	0.8	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	3.0	ft-lb/in	ASTM D256
THERMAL			
HDTUL @ 264 PSI	220	°F	ASTM D648
ELECTRICAL			
SURFACE RESISTIVITY	10exp17	Ohms/Sq	ASTM D257
PROCESSING			
DRYING TEMPERATURE	170	°F	
DRYING TIME (not required)	2-4	hrs	
MELT TEMPERATURE	380-440	°F	
MOLD TEMPERATURE	100-150	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	

TSC 12/13/12

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