



2079 Center Square Road  
 Logan Township, NJ 08085  
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**TECHNICAL DATA AND PROCESS SHEET**

**30% GLASS FIBER REINFORCED 15% PTFE LUBRICATED ABS**

**INLUBE ABSGF30TF15**

**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	1.40		1.40	
SPECIFIC VOLUME		19.79	in <sup>3</sup> /lb	0.714	cm <sup>3</sup> /gm
WATER ABSORPTION (24 Hrs)	D570	0.12	%	0.12	%
MOLD SHRINKAGE	D955	0.1-0.2	%	0.1-0.2	%
<b>MECHANICAL</b>					
TENSILE STRENGTH	D638	11,500	psi	79	MPa
ELONGATION, YIELD	D638	3-4	%	3-4	%
FLEXURAL STRENGTH	D790	21,000	psi	145	MPa
FLEXURAL MODULUS	D790	1,100,000	psi	7,584	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1.1	ft.lb./in.	59	J/m
UNNOTCHED 1/8"		5	ft.lb./in.	267	J/m
ROCKWELL HARDNESS		M97	M Scale	M97	M Scale
<b>THERMAL</b>					
HDTUL @ 264 PSI	D648	220	°F	104	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	1.8	in./in. F x10 <sup>-5</sup>	3.24	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		10e <sup>16</sup>	ohms/sq	10e <sup>16</sup>	ohms/sq
<b>PROCESSING</b>					
DRYING TEMPERATURE		170	°F	77	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		400-550	°F	205- 288	°C
MOLD TEMPERATURE		180	°F	82	°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

This information is based on our experience to date and we believe it to be reliable. It is intended only as a guide for use at your discretion and risk. We cannot guarantee favorable results and assume no liability in connection with its use of the products described. Each user bears full responsibility for making it's own determination as to the suitability of the product described. None of this information is to be taken as a license to operate under, or recommendation to infringe any patents.