



2079 Center Square Road
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TECHNICAL DATA AND PROCESS SHEET

15% GLASS FIBER REINFORCED, 15% PTFE LUBRICATED NYLON 12

INLUBE PA12GF15TF15

TYPICAL PROPERTIES

PROPERTY	VALUE	UNIT	METHOD
PHYSICAL			
SPECIFIC GRAVITY	1.23	-	ASTM D792
WATER ABSORPTION	0.1	%	ASTM D570
MOLD SHRINKAGE	0.4 – 0.8	%	
MECHANICAL			
TENSILE STRENGTH, BRK	11,700	psi	ASTM D638
TENSILE ELONGATION	4-6	%	ASTM D638
FLEXURAL MODULUS	450,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	2.7	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	12-16	ft-lb/in	ASTM D256
THERMAL			
HDTUL @ 264 PSI	320	°F	ASTM D648
ELECTRICAL			
SURFACE RESISTIVITY	>10EXP17	Ohm/Sq	ASTM D257
PROCESSING			
DRYING TEMPERATURE	180	°F	
DRYING TIME	4	hrs	
MELT TEMPERATURE	440-460	°F	
MOLD TEMPERATURE	160-180	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.0005-0.001	in	

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