



2079 Center Square Road
Logan Township, NJ 08085

TECHNICAL DATA AND PROCESS SHEET

30% GLASS FIBER REINFORCED, 13% PTFE/2% SILICONE LUBRICATED NYLON 6/12

INLUBE PA612GF30TF13SI2

TYPICAL PROPERTIES

PROPERTY	VALUE	UNIT	METHOD
PHYSICAL			
SPECIFIC GRAVITY	1.42	-	ASTM D792
WATER ABSORPTION (24 hr.)	0.10	%	ASTM D570
WATER ABSORPTION (Saturated)	1.5	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	0.2-0.6	%	
MECHANICAL			
TENSILE STRENGTH, BRK	19,500	psi	ASTM D638
TENSILE ELONGATION	2-4	%	ASTM D638
FLEXURAL STRENGTH	29,500	psi	ASTM D790
FLEXURAL MODULUS	1,100,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	2.2	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	15-17	ft-lb/in	ASTM D256
THERMAL			
HDTUL @ 264 PSI	420	°F	ASTM D648
ELECTRICAL			
SURFACE RESISTIVITY	10 ² – 10 ⁶	Ohm/Sq	ASTM D257
PROCESSING			
DRYING TEMPERATURE	175	°F	
DRYING TIME	4	hrs	
MELT TEMPERATURE	510-530	°F	
MOLD TEMPERATURE	200	°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