



2079 Center Square Road
 Logan Township, NJ 08085
 Phone: 856-467-3030

TECHNICAL DATA AND PROCESS SHEET

20% GLASS FIBER REINFORCED, 15% PTFE LUBRICATED POLYCARBONATE

INLUBE PCGF20TF15

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.46		1.46	
SPECIFIC VOLUME		18.97	in ³ /lb	0.685	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	0.06	%	0.06	%
MOLD SHRINKAGE	D955	0.15-0.3	%	0.15-0.3	%
MECHANICAL					
TENSILE STRENGTH	D638	14,500	psi	100	MPa
ELONGATION, YIELD	D638	3-5	%	3-5	%
FLEXURAL STRENGTH	D790	22,000	psi	152	MPa
FLEXURAL MODULUS	D790	850,000	psi	5,861	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		2.8	ft.lb./in.	149	J/m
UNNOTCHED 1/8"		16	ft.lb./in.	853	J/m
ROCKWELL HARDNESS		M92	M Scale	M92	M Scale
THERMAL					
HDTUL @ 264 PSI	D648	200	°F	93	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	1.8	in./in. F x10 ⁻⁵	3.24	mm/mm C 10 ⁻⁶
FLAMMABILITY ¹	U.L.Subj 94	HB@1/16	in	HB@ 1.5	mm
ELECTRICAL					
SURFACE RESISTIVITY		10e ¹⁶	ohms/sq	10e ¹⁶	ohms/sq
PROCESSING					
DRYING TEMPERATURE		250	°F	121	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		540-630	°F	280- 330	°C
MOLD TEMPERATURE		200	°F	93	°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

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