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TECHNICAL DATA AND PROCESS SHEET

**20% CARBON FIBER REINFORCED 15% PTFE LUBRICATED COPOLYMER ACETAL
 INLUBE POMCCF20TF15**

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.55		1.55	
SPECIFIC VOLUME		17.9	in ³ /lb	0.645	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	0.5	%	0.50	%
MOLD SHRINKAGE	D955	0.5-0.7	%	0.5-0.7	%
MECHANICAL					
TENSILE STRENGTH	D638	21,000	psi	145	MPa
ELONGATION, YIELD	D638	1-2	%	1-2	%
FLEXURAL STRENGTH	D790	22,000	psi	152	MPa
FLEXURAL MODULUS	D790	1,800,000	psi	12,411	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		0.8	ft.lb./in.	43	J/m
UNNOTCHED 1/8"		6	ft.lb./in.	320	J/m
ROCKWELL HARDNESS					
THERMAL					
HDTUL @ 264 PSI	D648	320	°F	160	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	2.2	in./in. F x10 ⁻⁵	3.96	mm/mm C 10 ⁻⁶
FLAMMABILITY ¹	U.L.Subj 94	HB@1/16	in	HB@1.5	mm
ELECTRICAL					
SURFACE RESISTIVITY		10e ² -10e ⁶	ohms/sq	10e ² -10e ⁶	ohms/sq
PROCESSING					
DRYING TEMPERATURE		180	°F	82	°C
DRYING TIME		4	hrs	4	hrs
MELT TEMPERATURE		375-410	°F	190 - 210	°C
MOLD TEMPERATURE		200	°F	93	°C
BACK PRESSURE		50-100	psi	0.3 - 0.7	MPa
SCREW SPEED		30-60	rpm	30-60	rpm
VENT DEPTH		0.0005-0.001	in	0.0125 - 0.0251	mm

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