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TECHNICAL DATA AND PROCESS SHEET

**20% GLASS FIBER REINFORCED 15% PTFE LUBRICATED COPOLYMER ACETAL
 INLUBE POMCGF20TF15**

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.63		1.63	
SPECIFIC VOLUME		17.0	in ³ /lb	0.613	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	0.3	%	0.30	%
MOLD SHRINKAGE	D955	0.7-0.9	%	0.7-0.9	%
MECHANICAL					
TENSILE STRENGTH	D638	16,000	psi	110	MPa
ELONGATION, YIELD	D638	2-3	%	2-3	%
FLEXURAL STRENGTH	D790	21,000	psi	145	MPa
FLEXURAL MODULUS	D790	900,000	psi	6,205	MPa
SHEAR STRENGTH	D732		psi		MPa
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		1.2	ft.lb./in.	64	J/m
UNNOTCHED 1/8"		8	ft.lb./in.	426	J/m
ROCKWELL HARDNESS					
THERMAL					
HDTUL @ 264 PSI	D648	300	°F	149	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	3.3	in./in. F x10 ⁻⁵	5.94	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		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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