



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

TECHNICAL DATA AND PROCESS SHEET

**30% GLASS FIBER REINFORCED 15% PTFE LUBRICATED COPOLYMER ACETAL
 INLUBE POMCGF30TF15**

TYPICAL PROPERTIES

PROPERTY	ASTM METHOD	English	UNITS	Metric SI	UNITS
GENERAL					
SPECIFIC GRAVITY	D792	1.73		1.73	
SPECIFIC VOLUME		16.0	in ³ /lb	0.578	cm ³ /gm
WATER ABSORPTION (24 Hrs)	D570	0.3	%	0.30	%
MOLD SHRINKAGE	D955	0.4-0.7	%	0.4-0.7	%
MECHANICAL					
TENSILE STRENGTH	D638	19,000	psi	131	MPa
ELONGATION, YIELD	D638	1-2	%	1-2	%
FLEXURAL STRENGTH	D790	25,000	psi	172	MPa
FLEXURAL MODULUS	D790	1,200,000	psi	8,274	MPa
SHEAR STRENGTH	D732				
IZOD IMPACT STRENGTH	D256				
NOTCHED 1/8"		0.7	ft.lb./in.	37	J/m
UNNOTCHED 1/8"		7	ft.lb./in.	373	J/m
ROCKWELL HARDNESS					
THERMAL					
HDTUL @ 264 PSI	D648	310	°F	154	°C
COEFFICIENT OF LINEAR THERMAL EXPANSION	D696	2.5	in./in. F x10 ⁻⁵	4.5	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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