

InLube® PPATF20HW

Americhem - Polyphthalamide

General Information
Product Description

20% PTFE LUBRICATED, HOT WATER MOLDABLE PPA

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• PTFE Lubricant: 20%		
Features	• Chemical Resistant • Good Mold Release	• Hot Water Moldability • Low Friction	• Lubricated • Wear Resistant
Uses	• Aerospace Applications • Connectors • Consumer Applications • Electrical/Electronic Applications	• Engineering Parts • Industrial Applications • Industrial Parts • Metal Replacement	• Military/Defense Applications • Oil/Gas Applications • Outdoor Applications • Semiconductor Applications
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.36		ASTM D792
Molding Shrinkage - Flow	0.015 to 0.025	in/in	ASTM D955
Water Absorption (24 hr)	0.40	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	550000	psi	ASTM D638
Tensile Strength	11100	psi	ASTM D638
Tensile Elongation (Yield)	2.0 to 4.0	%	ASTM D638
Flexural Modulus	500000	psi	ASTM D790
Flexural Strength (Yield)	17800	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.80	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	7.0	ft·lb/in	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	245	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	4.0	hr
Processing (Melt) Temp	625	°F
Mold Temperature	175 to 200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm

