



**Product Data Sheet &
General Processing Conditions**

**PermaStat® 301 TFE 10
Polycarbonate (PC)
Glass Fiber
PTFE Lubricated
ESD Protection
Permanently Anti-static**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	10 %	10 %	
Specific Gravity	1.30	1.30	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0030 - 0.0050 in/in	0.30 - 0.50 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	2.5 ft-lbs/in	133 J/m	D 256
unnotched 1/8 in (3.2 mm) section	25.0 ft-lbs/in	1335 J/m	D 4812
Tensile Strength	6500 psi	45 MPa	D 638
Tensile Elongation	7.0 - 10.0 %	7.0 - 10.0 %	D 638
Tensile Modulus	0.40 x 10 ⁶ psi	2758 MPa	D 638
Flexural Strength	10000 psi	69 MPa	D 790
Flexural Modulus	0.35 x 10 ⁶ psi	2413 MPa	D 790

ELECTRICAL

Volume Resistivity	1.0e9 - 9.9e10 ohm.cm	1.0e9 - 9.9e10 ohm.cm	D 257
Surface Resistivity	1.0e10 - 9.9e11 ohm/sq	1.0e10 - 9.9e11 ohm/sq	D 257
Surface Resistance	1.0e9 - 9.9e10 ohm	1.0e9 - 9.9e10 ohm	ESD STM11.11
Static Decay MIL-PRF-81705D, 5kV to 50 V, 12% RH	< 2.00 s	< 2.00 s	FTMS101C 4046.1

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.
Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	6000 - 10000 psi	41 - 69 MPa
Melt Temperature	430 - 470 °F	221 - 243 °C
Mold Temperature	150 - 250 °F	66 - 121 °C
Drying	4 hrs @ 250 °F	4 hrs @ 121 °C
Moisture Content	0.02 %	0.02 %
Dew Point	-20 °F	-29 °C

PROCESSING NOTES

Do not exceed 520 °F (270 °C) melt temperature.
Desiccant Type Dryer Required.