LubriOne™ PC-20GF/10T BLACK

Polycarbonate

Key Characteristics

Product Description		
Glass Fiber Reinforced and PTFE Lubricated Polycarbonate Compound		
General		
Material Status	• Commercial: Active	
Regional Availability	• Asia Pacific	
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight	• PTFE Micropowder, 10% Filler by Weight
Features	• Lubricated	
Appearance	• Black	
Forms	• Pellets	
Processing Method	• Injection Molding	

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.42	1.42	ASTM D792
Molding Shrinkage - Flow	2.0E-3 in/in	0.20 %	ASTM D955
Mechanical	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Strength	11600 psi	80.0 MPa	ASTM D638
Flexural Modulus	725000 psi	5000 MPa	ASTM D790
Flexural Strength	20300 psi	140 MPa	ASTM D790
Impact	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Notched Izod Impact			ASTM D256A
73°F (23°C), 0.126 in (3.20 mm), Injection Molded	2.4 ft·lb/in	130 J/m	
Thermal	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed	275 °F	135 °C	
Flammability	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Flame Rating			UL 94
0.06 in (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	230 to 266 °F	110 to 130 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Processing (Melt) Temp	536 to 590 °F	280 to 310 °C
Mold Temperature	176 to 248 °F	80 to 120 °C

Injection Notes

Injection Pressure: MED-HIGH

Hold Pressure: MED-HIGH

Screw Speed: MODERATE

Back Pressure: LOW

Notes

[1] Typical values are not to be construed as specifications.

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