LubriOne™ SF-30CF/15T BLACK

Polyphenylene Sulfide

Key Characteristics

Product Description	
PTFE lubricated	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Carbon Fiber, 30% Filler by Weight
Additive	• PTFE Lubricant: 15%
Features	• Lubricated
Appearance	• Black
Processing Method	• Injection Molding

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.52	1.52	ASTM D792
Molding Shrinkage - Flow	1.0E-3 to 1.5E-3 in/in	0.10 to 0.15 %	ASTM D955
Mechanical	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Tensile Modulus [2]	1.96E+6 psi	13500 MPa	ASTM D638
Tensile Strength [2]	20000 psi	138 MPa	ASTM D638
Tensile Elongation [2] (Break)	2.0 %	2.0 %	ASTM D638
Flexural Modulus [3]	2.18E+6 psi	15000 MPa	ASTM D790
Flexural Strength [3]	30500 psi	210 MPa	ASTM D790
Impact	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Notched Izod Impact			ASTM D256
73°F (23°C), 0.126 in (3.20 mm)	1.3 ft·lb/in	70 J/m	
Thermal	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	500 °F	260 °C	
Electrical	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Surface Resistivity	50 to 1.0E+3 ohms	50 to 1.0E+3 ohms	ASTM D257
Flammability	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Flame Rating			UL 94
0.030 in (0.75 mm)	V-1	V-1	
0.12 in (3.0 mm)	V-0	V-0	

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	284 to 302 °F	140 to 150 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Rear Temperature	608 to 626 °F	320 to 330 °C
Middle Temperature	608 to 626 °F	320 to 330 °C
Front Temperature	608 to 626 °F	320 to 330 °C
Mold Temperature	284 to 320 °F	140 to 160 °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.

[2] 0.20 in/min (5.0 mm/min)

[3] 0.051 in/min (1.3 mm/min)

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