



# LubriOne™ PC-30GF/15T BLACK

## Polycarbonate

### Key Characteristics

Product Description	
30 % glass fiber reinforced, PTFE lubricated polycarbonate compound	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Additive	• PTFE Lubricant
Features	• Lubricated
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

### Technical Properties <sup>1</sup>

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.55	1.55	ASTM D792
Molding Shrinkage - Flow	1.0E-3 to 3.0E-3 in/in	0.10 to 0.30 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Modulus <sup>2</sup>	986000 psi	6800 MPa	ASTM D638
Tensile Strength <sup>2</sup>	16700 psi	115 MPa	ASTM D638
Tensile Elongation <sup>2</sup> (Break)	3.5 %	3.5 %	ASTM D638
Flexural Modulus <sup>3</sup>	1.17E+6 psi	8100 MPa	ASTM D790
Flexural Strength <sup>3</sup>	24700 psi	170 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact 73°F (23°C), 0.126 in (3.20 mm)	4.1 ft-lb/in	220 J/m	ASTM D256
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	282 °F	139 °C	ASTM D648
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating (0.24 in (6.0 mm))	V-0	V-0	UL 94

### Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	248 to 266 °F	120 to 130 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Rear Temperature	554 to 590 °F	290 to 310 °C
Middle Temperature	554 to 590 °F	290 to 310 °C
Front Temperature	554 to 590 °F	290 to 310 °C
Mold Temperature	176 to 230 °F	80.0 to 110 °C

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**Injection Notes**

Injection Pressure: MED-HIGH  
 Hold Pressure: MED-HIGH  
 Screw Speed: MODERATE  
 Back Pressure: LOW

**Notes**

<sup>1</sup> Typical values are not to be construed as specifications.

<sup>2</sup> 0.20 in/min (5.0 mm/min)

<sup>3</sup> 0.051 in/min (1.3 mm/min)

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