LubriOne™ PC-20GF/15T NC042 S-RoHs

Polycarbonate

PolyOne Corporation

Message:

PTFE lubricated

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	PTFE lubricant		
Features	Lubrication		
Appearance	Natural color		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.43	g/cm³	ASTM D792
Molding Shrinkage - Flow	0.10 - 0.30	%	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [1]	100	MPa	ASTM D638
Flexural Modulus [2]	5500	MPa	ASTM D790
Flexural Strength [3]	135	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C, 3.20 mm)	170	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	135	°C	ASTM D648
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+15	ohms	ASTM D257
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (3.20 mm)	HB		UL 94
Injection	**Nominal Value**	**Unit**	
Drying Temperature	120 - 130	°C	
Drying Time	3.0 - 4.0	hr	
Rear Temperature	290 - 310	°C	
Middle Temperature	290 - 310	°C	
Front Temperature	290 - 310	°C	
Mold Temperature	90.0 - 110	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	50 mm/min		
2.	1.3 mm/min		

3.	1.3 mm/min

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China