

LubriOne™ SF-30CF/15T BLACK

Polyphenylene Sulfide
PolyOne Corporation

Message:
PTFE lubricated

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 30% filler by weight		
Additive	PTFE lubricant		
Features	Lubrication		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.52	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.10 - 0.15	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	13500	MPa	ASTM D638
Tensile Strength ²	138	MPa	ASTM D638
Tensile Elongation ³ (Break)	2.0	%	ASTM D638
Flexural Modulus ⁴	15000	MPa	ASTM D790
Flexural Strength ⁵	210	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	70	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	260	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	50 - 1.0E+3	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-0		Internal method
Injection	Nominal Value	Unit	
Drying Temperature	140 - 150	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	320 - 330	°C	
Middle Temperature	320 - 330	°C	
Front Temperature	320 - 330	°C	
Mold Temperature	140 - 160	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			

1.	5.0 mm/min
2.	5.0 mm/min
3.	5.0 mm/min
4.	1.3 mm/min
5.	1.3 mm/min

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