

LubriOne™ SF-30GF/15T BK006

Polyphenylene Sulfide
PolyOne Corporation

Message:
PTFE lubricated

General Information			
Filler / Reinforcement	Glass 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	1.62	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.30 - 0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	125	MPa	ASTM D638
Flexural Modulus ²	12000	MPa	ASTM D790
Flexural Strength ³	220	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	95	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	1.0E+15	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-0		UL 94
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.	1.3 mm/min		

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