

LubriOne™ PS-30CF/15T BK701

Polybutylene Terephthalate

PolyOne Corporation

Message:

PTFE lubricated

General Information			
Additive	PTFE lubricant		
	Carbon black (30%)		
Features	Lubrication		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.50	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.20 - 0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	130	MPa	ASTM D638
Flexural Modulus ²	17000	MPa	ASTM D790
Flexural Strength ³	230	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	75	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	215	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	10 - 1.0E+4	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	110 - 130	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	240 - 270	°C	
Middle Temperature	240 - 270	°C	
Front Temperature	240 - 270	°C	
Mold Temperature	75.0 - 95.0	°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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