

LubriOne™ PC-20GF/13T-2S NATURAL

Polycarbonate

PolyOne Corporation

Message:

PTFE/Silicone lubricated

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	PTFE silicone lubricant		
Features	Lubrication		
Appearance	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.43	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.10 - 0.30	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	90.0	MPa	ASTM D638
Flexural Modulus ²	5500	MPa	ASTM D790
Flexural Strength ³	130	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	120	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	138	°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		

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