

InLube® PCGFM20TF15HF

Americhem - Polycarbonate

General Information
Product Description

20% MILLED GLASS FIBER REINFORCED, 15% PTFE LUBRICATED, HIGH FLOW, POLYCARBONATE

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Milled Glass Fiber, 20% Filler by Weight		
Additive	• PTFE Lubricant: 15%		
Features	• Chemical Resistant • Good Dimensional Stability • Good Mold Release	• High Flow • High Stiffness • High Strength	• Lubricated • Wear Resistant
Uses	• Automotive Applications • Closures • Connectors • Consumer Applications	• Electrical/Electronic Applications • Engineering Parts • Household Goods • Housings	• Industrial Applications • Industrial Parts • Office Automation Equipment
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.45		ASTM D792
Molding Shrinkage - Flow	4.0E-3 to 8.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.060	%	ASTM D570
Mechanical			
Tensile Modulus	400000	psi	ASTM D638
Tensile Strength	5500	psi	ASTM D638
Tensile Elongation (Yield)	> 8.0	%	ASTM D638
Flexural Modulus	350000	psi	ASTM D790
Flexural Strength (Break)	10000	psi	ASTM D790
Impact			
Notched Izod Impact (0.125 in)	2.0	ft-lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	18	ft-lb/in	ASTM D4812
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	275	°F	ASTM D648

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	250	°F
Drying Time	3.0 to 4.0	hr
Processing (Melt) Temp	540 to 580	°F
Mold Temperature	180 to 240	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm
Vent Depth	1.0E-3 to 3.0E-3	in

