

InLube® PCGF10TF15VHFMR

Americhem - Polycarbonate

General Information

Product Description

10% GLASS FIBER REINFORCED, 15% PTFE LUBRICATED VERY HIGH FLOW MOLD RELEASE POLYCARBONATE

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight		
Additive	• Mold Release	• PTFE Lubricant: 15%	
Features	• Chemical Resistant • Filled • Good Dimensional Stability • Good Mold Release	• High Flow • High Stiffness • High Strength • Low Friction	• 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	1.36		ASTM D792
Molding Shrinkage - Flow	3.0E-3 to 6.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Mechanical			
Tensile Strength	8000	psi	ASTM D638
Tensile Elongation (Yield)	3.0 to 7.0	%	ASTM D638
Flexural Modulus	550000	psi	ASTM D790
Flexural Strength	14000	psi	ASTM D790
Impact			
Notched Izod Impact (0.125 in)	2.5	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	15 to 20	ft·lb/in	ASTM D4812
Hardness			
Rockwell Hardness (M-Scale)	121		
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	275	°F	ASTM D648
Electrical			
Surface Resistivity	1.0E+17	ohms	
Flammability			
Flame Rating (0.06 in)	HB		UL 94

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	250	°F
Drying Time	4.0	hr
Processing (Melt) Temp	540 to 630	°F
Mold Temperature	200	°F
Back Pressure	50.0 to 100	psi



Screw Speed	40 to 70 rpm
Vent Depth	1.5E-3 to 3.0E-3 in

Notes

¹ Typical properties: these are not to be construed as specifications.

