



Phone: (248) 486-1449 Fax: (248) 486-7966

Technical Data Sheet
LCA® 420L Type Black
PBT 30% Glass Fiber, Lubricated

Typical Compound Properties	Value / Measure		Test Methods
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Physical Properties	English Units (ISO)	Metric Units	
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Density	1.5 g/cm ³	1.5 g/cm ³	ASTM D-792 (ISO 1183)
Ash Content	30 %	30 %	ASTM D-5630
Linear Mold Shrinkage	.003 - .005 in/in	mm/mm	ASTM D-955

Mechanical Properties			
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Izod Impact - Notched	1.20 ft-lb/in (kJ/m ²)	64 J/m	ASTM D-256 (ISO 108/1A)
Tensile Strength @ Yield	15,000 psi (Mpa)	103 MPa	ASTM D-638 (ISO 527 - 1,2)
Tensile Strength @ Break	psi (Mpa)	0 MPa	ASTM D-638 (ISO 527 - 1,2)
Tensile Elongation @ Yield	%	0 %	ASTM D-638 (ISO 527 - 1,2)
Tensile Elongation @ Break	9 %	9 %	ASTM D-638 (ISO 527 - 1,2)
Flexural Strength @ Yield	psi (Mpa)	0 MPa	ASTM D-790 (ISO 178)
Flexural Stress @ Break	psi (Mpa)	0 MPa	ASTM D-790 (ISO 178)
Flexural Stress @ 5% Strain	psi (Mpa)	0 MPa	ASTM D-790 (ISO 178)
Flexural Modulus	1,000,000 psi (Mpa)	6,900 MPa	ASTM D-790 (ISO 178)

Thermal Properties			
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DTUL @ 66 psi (455 kPa)	Deg. F	Deg. C	ASTM D-648 (ISO 75 - 1,2)
@ 264 psi (1820 kPa)	Deg. F	Deg. C	ASTM D-648 (ISO 75 - 1,2)
Vicat Softening Temperature	Deg. F	Deg. C	ASTM D-1525 (ISO 306)
Melt Point	Deg. F	Deg. C	ASTM D-789-92e1

All tests are performed on dry as molded ASTM (ISO) test bars.

General Product Type Information

The property values listed above have been obtained using laboratory controlled test methods. They are offered without guarantee since conditions under which the product is used are beyond our control. Therefore, Uniplas, Inc. disclaims any liability for loss or damage incurred in connection with the use of this product.

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Typical Processing Conditions			
Process Variable	Description	Values	
Temperatures			
Barrel		F	C
	Rear	460 - 490	
	Center	470 - 500	
	Front	480 - 510	
	Nozzle	470 - 500	
	Mold	150 - 190	
	Process Temp	480 - 510	
Drying			
Type		Dehumidifier	
Temperature		250	
Time		3 - 4 Hours	
Max. % Moisture			
Special Requirements			

Optimum processing conditions will depend on such factors as machine size, screw design, part dimension, mold design, runner and gate design, and material residence time. These recommendations are intended only as a guide to achieve stable processing and good part quality.

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