

LubriOne™ PC-000/10T BLACK

Polycarbonate

PolyOne Corporation

Message:

10% PTFE Lubricated Polycarboante Compound

General Information			
Filler / Reinforcement	PTFE ultra fine powder, 10% packing by weight		
Features	Lubrication		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	g/cm ³	ASTM D792
Molding Shrinkage (3.00 mm)	0.50 - 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	55.0	MPa	ASTM D638
Tensile Elongation ² (Break)	20	%	ASTM D638
Flexural Modulus ³	2100	MPa	ASTM D790
Flexural Strength ⁴	90.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm, Injection Molded)	150	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	125	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.50 mm	HB		UL 94
3.00 mm	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	110 - 130	°C	
Drying Time	4.0 - 6.0	hr	
Processing (Melt) Temp	280 - 310	°C	
Mold Temperature	80.0 - 120	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	50 mm/min		

2.	50 mm/min
3.	1.3 mm/min
4.	1.3 mm/min

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