

LubriOne™ PC-000/05T Ice Green

Polycarbonate

PolyOne Corporation

Message:

PC compound with PTFE lubricated.

General Information			
UL YellowCard	E76261-101413966		
Filler / Reinforcement	Fluoropolymer, 5.0% filler by weight		
Additive	PTFE lubricant (5%)		
Features	Self-lubricating		
Uses	Transfer application		
	Household goods		
	Printing machine parts		
RoHS Compliance	RoHS compliance		
Appearance	Green		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.90 - 1.2	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (23°C, 3.20 mm)	55.0	MPa	ASTM D638
Flexural Modulus ² (23°C, 3.20 mm)	2200	MPa	ASTM D790
Flexural Strength ³ (23°C, 3.20 mm)	85.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	120	J/m	ASTM D256
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.5 mm	HB		UL 94
3.0 mm	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	120 - 130	°C	
Drying Time	3.0 - 4.0	hr	
Processing (Melt) Temp	290 - 310	°C	
Mold Temperature	90 - 110	°C	
NOTE			
1.	50 mm/min		
2.	1.3 mm/min		

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