

LubriOne™ MP-000/10T Dark Steel

Polyphenylene Ether + PS

PolyOne Corporation

Message:

PTFE lubricated poly(p-phenylene ether) (PPE) compound

General Information			
Additive	PTFE lubricant (10%)		
Features	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.50 - 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2700	MPa	ASTM D638
Tensile Strength	55.0	MPa	ASTM D638
Flexural Modulus	2600	MPa	ASTM D790
Flexural Strength	95.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	52	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	115	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	120 - 130	°C	
Drying Time	3.0 - 4.0	hr	
Rear Temperature	280 - 300	°C	
Middle Temperature	280 - 300	°C	
Front Temperature	280 - 300	°C	
Mold Temperature	90 - 110	°C	
Injection instructions			

Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW

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