



LubriOne™ MP-000/10T Dark Steel

Polyphenylene Ether + PS

Key Characteristics

Product Description	
PTFE lubricated poly(p-phenylene ether) (PPE) compound	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Additive	• PTFE Lubricant: 10%
Features	• Lubricated
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.12	1.12	ASTM D792
Molding Shrinkage - Flow	5.0E-3 to 8.0E-3 in/in	0.50 to 0.80 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Modulus	392000 psi	2700 MPa	ASTM D638
Tensile Strength	7980 psi	55.0 MPa	ASTM D638
Flexural Modulus	377000 psi	2600 MPa	ASTM D790
Flexural Strength	13800 psi	95.0 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact	0.97 ft·lb/in	52 J/m	ASTM D256
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	239 °F	115 °C	ASTM D648

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	248 to 266 °F	120 to 130 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Rear Temperature	536 to 572 °F	280 to 300 °C
Middle Temperature	536 to 572 °F	280 to 300 °C
Front Temperature	536 to 572 °F	280 to 300 °C
Mold Temperature	194 to 230 °F	90 to 110 °C

Injection Notes
Injection Pressure: MED-HIGH
Hold Pressure: MED-HIGH
Screw Speed: MODERATE
Back Pressure: LOW

Notes

¹ Typical values are not to be construed as specifications.