



# LubriOne™ PC-000/10T BLACK

## Polycarbonate

### Key Characteristics

Product Description	
10% PTFE Lubricated Polycarbonate Compound	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• PTFE Micropowder, 10% Filler by Weight
Features	• Lubricated
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

### Technical Properties <sup>1</sup>

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.25	1.25	ASTM D792
Molding Shrinkage (0.118 in (3.00 mm))	0.50 to 0.70 %	0.50 to 0.70 %	ISO 294-4
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength <sup>2</sup>	7980 psi	55.0 MPa	ASTM D638
Tensile Elongation <sup>2</sup> (Break)	20 %	20 %	ASTM D638
Flexural Modulus <sup>3</sup>	305000 psi	2100 MPa	ASTM D790
Flexural Strength <sup>3</sup>	13100 psi	90.0 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact 73°F (23°C), 0.126 in (3.20 mm), Injection Molded	2.8 ft-lb/in	150 J/m	ASTM D256A
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed	257 °F	125 °C	ASTM D648
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	1.0E+14 ohms	1.0E+14 ohms	ASTM D257
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating			UL 94
0.0591 in (1.50 mm)	HB	HB	
0.118 in (3.00 mm)	HB	HB	

### Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	230 to 266 °F	110 to 130 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Processing (Melt) Temp	536 to 590 °F	280 to 310 °C
Mold Temperature	176 to 248 °F	80.0 to 120 °C

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**Injection Notes**

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

**Notes**

<sup>1</sup> Typical values are not to be construed as specifications.

<sup>2</sup> 2.0 in/min (50 mm/min)

<sup>3</sup> 0.051 in/min (1.3 mm/min)

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