



LubriOne™ PC-000/05T BLACK

Polycarbonate

Key Characteristics

Product Description	
PTFE lubricated polycarbonate compound	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Additive	• PTFE Lubricant
Features	• Lubricated
Appearance	• Black
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.23	1.23	ASTM D792
Molding Shrinkage - Flow	6.0E-3 to 8.0E-3 in/in	0.60 to 0.80 %	Internal Method
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength	7980 psi	55.0 MPa	ASTM D638
Flexural Modulus	363000 psi	2500 MPa	ASTM D790
Flexural Strength	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)	2.2 ft·lb/in	120 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)	262 °F	128 °C	ASTM D648
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	1.0E+15 ohms	1.0E+15 ohms	ASTM D257
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating			UL 94
0.06 in (1.5 mm)	HB	HB	
0.12 in (3.0 mm)	HB	HB	

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
Processing (Melt) Temp	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