



# LubriOne™ PC-000/05T NC006

## Polycarbonate

### Key Characteristics

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

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

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 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength <sup>2</sup>	7980 psi	55.0 MPa	ASTM D638
Flexural Modulus <sup>3</sup>	319000 psi	2200 MPa	ASTM D790
Flexural Strength <sup>3</sup>	12300 psi	85.0 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact			ASTM D256
73°F (23°C), 0.126 in (3.20 mm)	2.2 ft-lb/in	120 J/m	
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	262 °F	128 °C	
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
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

<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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