



# LubriOne™ PC-000/20T Black

## Polycarbonate

### Key Characteristics

#### Product Description

LubriOne™ Lubricated and Wear-Resistant Compounds have been specifically formulated to be self-lubricating materials, offering low coefficient of friction and improved wear resistance properties. LubriOne compounds have been demonstrated to reduce friction, noise, vibration, heat buildup and improve product durability.

#### General

Material Status	• Commercial: Active		
Regional Availability	• Asia Pacific		
Features	• Low Friction	• Lubricated	• Wear Resistant
Uses	• Appliance Components • Automotive Applications • Bearings • Business Equipment	• Consumer Applications • Conveyor Parts • Gears • Industrial Applications	• Printer Parts • Pulleys • Rollers
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

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

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.32	1.32	ASTM D792
Molding Shrinkage - Flow	5.0E-3 to 7.0E-3 in/in	0.50 to 0.70 %	ASTM D955
Water Absorption (24 hr, 0.125 in (3.18 mm))	0.12 %	0.12 %	ASTM D570
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength <sup>2</sup> (Yield)	7250 psi	50.0 MPa	ASTM D638
Flexural Modulus <sup>3</sup>	312000 psi	2150 MPa	ASTM D790
Flexural Strength <sup>3</sup>	10900 psi	75.0 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact 73°F (23°C), 0.125 in (3.18 mm), Injection Molded	2.5 ft-lb/in	130 J/m	ASTM D256A
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed, 0.250 in (6.35 mm)	260 °F	127 °C	ASTM D648
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating 0.06 in (1.5 mm) 0.12 in (3.0 mm)	HB HB	HB HB	UL 94

### Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	248 °F	120 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Processing (Melt) Temp	550 to 600 °F	288 to 316 °C
Mold Temperature	176 °F	80 °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> Type I, 2.0 in/min (50 mm/min)

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



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