PolyOne™

LubriOne™ PC-000/5T-2S BK002
Polycarbonate

Key Characteristics

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

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.21	1.21	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 Strength [2]	7980 psi	55.0 MPa	ASTM D638
Flexural Modulus [3]	319000 psi	2200 MPa	ASTM D790
Flexural Strength [3]	11600 psi	80.0 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)	8.4 ft·lb/in	450 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)	257 °F	125 °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 (0.13 in (3.2 mm))	HB	HB	UL 94

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.

[2] 2.0 in/min (50 mm/min)

[3] 0.051 in/min (1.3 mm/min)

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