



LubriOne™ PC-15CF/10T-2S BLK

Polycarbonate

Key Characteristics

Product Description	
Carbon fiber reinforced, PTFE and silicone lubricated polycarbonate compound	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Carbon Fiber, 15% Filler by Weight
Additive	• PTFE + Silicone Lubricant
Features	• Lubricated
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.34	1.34	ASTM D792
Molding Shrinkage - Flow	1.0E-3 to 3.0E-3 in/in	0.10 to 0.30 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength ²	17400 psi	120 MPa	ASTM D638
Flexural Modulus ³	1.23E+6 psi	8500 MPa	ASTM D790
Flexural Strength ³	23200 psi	160 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)	1.4 ft-lb/in	75 J/m	ASTM D256
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 66 psi (0.45 MPa), Unannealed	284 °F	140 °C	ASTM D648
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	270 °F	132 °C	ASTM D648
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	100 to 10000 ohms/sq	100 to 10000 ohms/sq	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	554 to 590 °F	290 to 310 °C
Middle Temperature	554 to 590 °F	290 to 310 °C
Front Temperature	554 to 590 °F	290 to 310 °C

Injection	Typical Value (English)	Typical Value (SI)
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 0.20 in/min (5.0 mm/min)

³ 0.051 in/min (1.3 mm/min)



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