



# LubriOne™ PC-000/5T-2S NC704

## Polycarbonate

### Key Characteristics

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

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

| Physical                                          | Typical Value (English) | Typical Value (SI) | Test Method |
|---------------------------------------------------|-------------------------|--------------------|-------------|
| 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 <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>                    | 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           | 90.0 to 110 °C     |

| Injection Notes              |  |
|------------------------------|--|
| Injection Pressure: MED-HIGH |  |
| Hold Pressure: MED-HIGH      |  |
| Screw Speed: MODERATE        |  |
| Back Pressure: LOW           |  |

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**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)**CONTACT INFORMATION****Americas**United States - Avon Lake  
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