



# LubriOne™ PC-10GF/15T BLACK

## Polycarbonate

### Key Characteristics

| Product Description    |                                     |
|------------------------|-------------------------------------|
| PTFE lubricated        |                                     |
| General                |                                     |
| Material Status        | • Commercial: Active                |
| Regional Availability  | • Asia Pacific                      |
| Filler / Reinforcement | • Glass Fiber, 10% Filler by Weight |
| Additive               | • PTFE Lubricant                    |
| Features               | • Lubricated                        |
| Appearance             | • Black                             |
| Processing Method      | • Injection Molding                 |

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

| Physical                                          | Typical Value (English) | Typical Value (SI) | Test Method |
|---------------------------------------------------|-------------------------|--------------------|-------------|
| Specific Gravity                                  | 1.35                    | 1.35               | ASTM D792   |
| Molding Shrinkage - Flow                          | 3.0E-3 to 5.0E-3 in/in  | 0.30 to 0.50 %     | ASTM D955   |
| Mechanical                                        | Typical Value (English) | Typical Value (SI) | Test Method |
| Tensile Strength <sup>2</sup>                     | 10400 psi               | 72.0 MPa           | ASTM D638   |
| Flexural Modulus <sup>3</sup>                     | 508000 psi              | 3500 MPa           | ASTM D790   |
| Flexural Strength <sup>3</sup>                    | 16000 psi               | 110 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)                   | 2.8 ft-lb/in            | 150 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) | 275 °F                  | 135 °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   | 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      |
| Mold Temperature   | 194 to 230 °F           | 90.0 to 110 °C     |

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**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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