

LubriOne™ PC-000/5T-2S BK002

Polycarbonate
PolyOne Corporation

Message:
PTFE/Silicone lubricated polycarbonate compound

General Information			
Additive	PTFE silicone lubricant		
Features	Lubrication		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.50 - 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	55.0	MPa	ASTM D638
Flexural Modulus ²	2200	MPa	ASTM D790
Flexural Strength ³	80.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	450	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	125	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.20 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	120 - 130	°C	
Drying Time	3.0 - 4.0	hr	
Rear Temperature	280 - 300	°C	
Middle Temperature	280 - 300	°C	
Front Temperature	280 - 300	°C	
Mold Temperature	90.0 - 110	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	50 mm/min		
2.	1.3 mm/min		
3.	1.3 mm/min		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519
Phone: +86 13424755533
Email: sales@su-jiao.com
No. 215, Lianhe North Road, Fengxian District, Shanghai, China

