

Plaslube® J-50/10/TF/15 BK223

Techmer Polymer Modifiers - *Polycarbonate*

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Additive	• PTFE Lubricant
Features	• Lubricated
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.36	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	638000	psi	ISO 527-1
Tensile Stress (Yield)	9400	psi	ISO 527-2
Tensile Stress (Break)	9400	psi	ISO 527-2
Tensile Strain (Break)	3.4	%	ISO 527-2
Flexural Modulus	624000	psi	ISO 178
Flexural Stress	16700	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	45	ft-lb/in	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	275	°F	ISO 75-2/A

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	500 to 540	°F
Middle Temperature	510 to 550	°F
Front Temperature	520 to 560	°F
Nozzle Temperature	530 to 570	°F
Processing (Melt) Temp	510 to 570	°F
Mold Temperature	150 to 225	°F
Injection Rate	Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

