

Plaslube® J-50/30/TF/15 BK3585

Techmer Polymer Modifiers - *Polycarbonate*

General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Moisture (248°F)	0.040	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	16400	psi	ASTM D638
Flexural Modulus	1.41E+6	psi	ASTM D790
Flexural Modulus	1.39E+6	psi	ISO 178
Flexural Strength	27600	psi	ASTM D790
Flexural Stress	26600	psi	ISO 178
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	270	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	292	°F	ISO 75-2/A
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-1		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	550 to 590	°F
Middle Temperature	560 to 600	°F
Front Temperature	570 to 610	°F
Nozzle Temperature	580 to 620	°F
Processing (Melt) Temp	560 to 615	°F
Mold Temperature	200 to 275	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Moderate	

