

Plaslube® PC-50/TF/22 BK223

Techmer Polymer Modifiers - *Polycarbonate*

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Flame Retardant • PTFE Lubricant
Features	• Flame Retardant • Lubricated
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.33		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	6500	psi	ISO 527-2
Tensile Stress (Break)	6200	psi	ISO 527-2
Tensile Strain (Break)	25	%	ISO 527-2
Flexural Modulus	305000	psi	ISO 178
Flexural Stress	10200	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	4.3	ft·lb/in	ISO 180

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	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

