Plaslube® PC-50/TF/15

Techmer Polymer Modifiers - *Polycarbonate*

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Filler		
Additive	• PTFE Lubricant: 15%		
Features	• Good Dimensional Stability • Good Toughness	• Lubricated • Pleasing Surface Appearance	
Uses	• Business Equipment		
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.29		ASTM D792
Density	0.0466	lb/in³	ISO 1183 [2]
Molding Shrinkage - Flow (0.125 in)	7.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.12	%	ASTM D570
Water Absorption (Saturation)	0.35	%	ISO 62 [2]
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile modulus	363000	psi	ISO 527-2 [2]
Tensile Strength (73°F)	7500	psi	ASTM D638
Tensile Stress (Yield)	7250	psi	ISO 527-2 [2]
Tensile Strain (Yield)	6.0	%	ISO 527-2 [2]
Tensile Elongation (Break, 73°F)	40	%	ASTM D638
Nominal strain at break	40	%	ISO 527-2 [2]
Flexural Modulus (73°F)	300000	psi	ASTM D790
Flexural Strength (Break, 73°F)	11000	psi	ASTM D790
Compressive Strength	9000	psi	ASTM D695
Coefficient of Friction (vs. Steel - Static)	0.090		ASTM D1894
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	3.3	ft·lb/in	ASTM D256
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	109		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	290	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	275	°F	ASTM D648
Deflection Temperature Under Load (264 psi)	266	°F	ISO 75-2 [2]
CLTE - Flow	3.9E-5	in/in/°F	ASTM D696
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.06 in)	HB		UL 94
Burning Behav. at 1.6mm nom. thickn. (0.06 in, UL)	HB		ISO 1210 [2]

Additional Information
Compressive Strength, ASTM D695, 73°F: 9000 psi

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	4.0	hr
Suggested Max Moisture	0.030	%
Rear Temperature	570 to 600	°F
Middle Temperature	590 to 620	°F
Front Temperature	580 to 610	°F
Nozzle Temperature	580 to 610	°F
Processing (Melt) Temp	580 to 630	°F
Mold Temperature	160 to 190	°F
Injection Rate	Moderate	
Back Pressure	50.0 to 100	psi

Injection Notes

Screw Speed: Medium
Recommendations for Molding and Tool Conditions: Well vented
Moisture Content, as received: Product is packaged at 0.2% or less.