

Plaslube® PC / PBT IM 6120 BK

Techmer Polymer Modifiers - Polycarbonate + PBT

General

| | |
|-------------------|--------------------------|
| Material Status | • Commercial: Active |
| Availability | • North America |
| Additive | • Impact Modifier |
| Features | • High Impact Resistance |
| Appearance | • Black |
| Forms | • Pellets |
| Processing Method | • Injection Molding |

Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|---|----------------------|-------------|--------------------|
| Density / Specific Gravity | 1.17 | | ASTM D792 |
| Molding Shrinkage - Flow (0.125 in) | 7.0E-3 | in/in | ASTM D955 |
| Water Absorption (24 hr) | 0.10 | % | ASTM D570 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Strength (Yield) | 7500 | psi | ASTM D638 |
| Tensile Elongation (Yield) | 160 | % | ASTM D638 |
| Flexural Modulus | 290000 | psi | ASTM D790 |
| Flexural Strength | 11200 | psi | ASTM D790 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact (0.250 in) | 16 | ft-lb/in | ASTM D256 |
| Thermal | Nominal Value | Unit | Test Method |
| Deflection Temperature Under Load (66 psi, Unannealed) | 245 | °F | ASTM D648 |
| Deflection Temperature Under Load (264 psi, Unannealed) | 210 | °F | ASTM D648 |
| CLTE - Flow | 1.3E-5 | in/in/°F | ASTM D696 |
| Flammability | Nominal Value | Unit | Test Method |
| Flame Rating | HB | | UL 94 |

Processing Information

| Injection | Nominal Value | Unit |
|------------------------|----------------------|-------------|
| Drying Temperature | 210 | °F |
| Drying Time | 4.0 | hr |
| Rear Temperature | 460 to 510 | °F |
| Middle Temperature | 460 to 510 | °F |
| Front Temperature | 460 to 510 | °F |
| Processing (Melt) Temp | 460 to 510 | °F |
| Mold Temperature | 130 to 200 | °F |
| Back Pressure | 25.0 to 60.0 | psi |
| Screw Speed | 30 to 60 | rpm |

