

## Plaslube® J-50/10/TF/15 BK223

Techmer Polymer Modifiers - *Polycarbonate*

### General Information

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

### Properties <sup>1</sup>

| Physical                                                | Nominal Value | Unit              | Test Method |
|---------------------------------------------------------|---------------|-------------------|-------------|
| Density                                                 | 1.36          | g/cm <sup>3</sup> | 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 |      |

