

**Plaslube® J-50/10/TF/15**

 Techmer Polymer Modifiers - *Polycarbonate*
**General Information**
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|                        |   |
|------------------------|---|
| Material Status        | • Commercial: Active  |
| Availability           | • Africa & Middle East • Europe • North America<br>• Asia Pacific • Latin America |
| Filler / Reinforcement | • Glass Fiber, 10% Filler by Weight   |
| Additive               | • PTFE Lubricant: 15%   |
| Features               | • Good Dimensional Stability • High Strength<br>• Good Toughness • Lubricated     |
| Uses                   | • Cams • Gears • Pulleys  |
| RoHS Compliance        | • RoHS Compliant  |
| Forms                  | • Pellets   |
| Processing Method      | • Injection Molding   |

**Properties <sup>1</sup>**

| Physical  | Nominal Value | Unit     | Test Method |
|---|---------------|----------|-------------|
| Density / Specific Gravity                              | 1.36          |          | ASTM D792   |
| Mechanical  | Nominal Value | Unit     | Test Method |
| Tensile Strength (73°F)                                 | 10500         | psi      | ASTM D638   |
| Flexural Modulus (73°F)                                 | 550000        | psi      | ASTM D790   |
| Flexural Strength (73°F)                                | 16500         | psi      | ASTM D790   |
| Flexural Strength (Break, 73°F)                         | 17000         | psi      | ASTM D790   |
| Impact  | Nominal Value | Unit     | Test Method |
| Notched Izod Impact (73°F, 0.125 in)                    | 2.5           | ft-lb/in | ASTM D256   |
| Thermal   | Nominal Value | Unit     | Test Method |
| Deflection Temperature Under Load (264 psi, Unannealed) | 290           | °F       | ASTM D648   |

**Processing Information**

| Injection              | Nominal Value | Unit |
|------------------------|---------------|------|
| Drying Temperature     | 250           | °F   |
| Drying Time            | 4.0           | hr   |
| Suggested Max Moisture | 0.030         | %    |
| Rear Temperature       | 580 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-Fast |      |
| 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.

