Plaslube® PC-50/TF/13/SI/2

Techmer Polymer Modifiers - *Polycarbonate*

General Information

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Filler		
Additive	• PTFE Lubricant: 13%	• Silicone Lubricant: 2%	
Features	• Lubricated		
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.27		ASTM D792
Molding Shrinkage - Flow (0.125 in)	7.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.12	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (73°F)	7000	psi	ASTM D638
Flexural Modulus (73°F)	290000	psi	ASTM D790
Flexural Strength (73°F)	10500	psi	ASTM D790
Compressive Strength (73°F)	9000	psi	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	4.0	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 (264 psi, Unannealed)	276	°F	ASTM D648
CLTE - Flow	3.8E-5	in/in/°F	ASTM D696
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.06 in)	HB		UL 94

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	140 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.