

Plaslube® PC TL15 BK

 Techmer Polymer Modifiers - *Polycarbonate*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Lubricant • PTFE Lubricant
Features	• Lubricated
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.29		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	305000	psi	ASTM D638
Tensile Strength (Yield)	6800	psi	ASTM D638
Tensile Strength (Break)	5800	psi	ASTM D638
Tensile Elongation (Break)	12	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.9	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	460 to 520	°F
Middle Temperature	460 to 520	°F
Front Temperature	460 to 520	°F
Nozzle Temperature	460 to 520	°F
Processing (Melt) Temp	470 to 530	°F
Mold Temperature	120 to 200	°F
Injection Rate	Slow	
Back Pressure	50.0 to 100	psi
Screw Speed	Slow-Moderate	

