

Plaslube® PC GF10 TS15 BK

 Techmer Polymer Modifiers - *Polycarbonate*
General Information

General	
Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Filler / Reinforcement	<ul style="list-style-type: none"> Glass Fiber, 10% Filler by Weight
Additive	<ul style="list-style-type: none"> PTFE + Silicone Lubricant
Features	<ul style="list-style-type: none"> Lubricated
Appearance	<ul style="list-style-type: none"> Colors Available
Forms	<ul style="list-style-type: none"> Pellets
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.34		ASTM D792
Water Absorption (24 hr)	0.020	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	7900	psi	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	500000	psi	ASTM D790
Flexural Strength	13000	psi	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.19		
vs. Steel - Static	0.20		
Wear Factor	10	10 ⁻¹⁰ in ³ ·min/ft·lb·hr	ASTM D3702
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	3.8	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	116		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	290	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	280	°F	ASTM D648
CLTE - Flow	1.8E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-1		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	575 to 600	°F
Middle Temperature	600 to 630	°F
Front Temperature	590 to 620	°F
Nozzle Temperature	590 to 620	°F
Processing (Melt) Temp	580 to 620	°F
Mold Temperature	160 to 190	°F
Injection Rate	Moderate	



Back Pressure

0.00 to 100 psi

Injection Notes

Screw Speed: Medium

Recommendations for Molding and Tool Conditions: Well vented mold

Moisture Content, as received: Product is packaged at 0.2% or less.

Notes

¹ Typical properties: these are not to be construed as specifications.

