

Plaslube® PC GF30 TL15

 Techmer Polymer Modifiers - *Polycarbonate*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Additive	• PTFE Lubricant
Features	• Lubricated
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.55		ASTM D792
Water Absorption (24 hr)	0.060	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	17500	psi	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	1.10E+6	psi	ASTM D790
Flexural Strength	23000	psi	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.20		
vs. Steel - Static	0.18		
Wear Factor	30	10 ⁻¹⁰ in ³ ·min/ft·lb·hr	ASTM D3702
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	2.0	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)	295	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	290	°F	ASTM D648
CLTE - Flow	1.6E-5	in/in/°F	ASTM D696
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.

