

Plaslube® PC-50/TF/15

 Techmer Polymer Modifiers - *Polycarbonate*
General Information

General			
Material Status	<ul style="list-style-type: none"> Commercial: Active 		
Availability	<ul style="list-style-type: none"> Africa & Middle East Asia Pacific 	<ul style="list-style-type: none"> Europe Latin America 	<ul style="list-style-type: none"> North America
Filler / Reinforcement	<ul style="list-style-type: none"> Filler 		
Additive	<ul style="list-style-type: none"> PTFE Lubricant: 15% 		
Features	<ul style="list-style-type: none"> Good Dimensional Stability Good Toughness 	<ul style="list-style-type: none"> Lubricated Pleasing Surface Appearance 	
Uses	<ul style="list-style-type: none"> Business Equipment 		
RoHS Compliance	<ul style="list-style-type: none"> RoHS Compliant 		
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	1.29		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)	7500	psi	ASTM D638
Tensile Elongation (Break, 73°F)	40	%	ASTM D638
Flexural Modulus (73°F)	300000	psi	ASTM D790
Flexural Strength (Break, 73°F)	11000	psi	ASTM D790
Compressive Strength (73°F)	9000	psi	ASTM D695
Coefficient of Friction (vs. Steel - Static)	0.090		ASTM D1894
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	3.3	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 (66 psi, Unannealed)	290	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	275	°F	ASTM D648
CLTE - Flow	3.9E-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	160 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.

Notes

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

