Plaslube® PC-50/TF/13/SI/2 BK3

Techmer Polymer Modifiers - *Polycarbonate*

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Appearance	• Black
Processing Method	• Injection Molding

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.26	g/cm³	
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	13	g/10 min	ASTM D1238
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	7300	psi	ASTM D638
Tensile Stress (Yield)	6890	psi	ISO 527-2
Tensile Elongation (Break)	23	%	ASTM D638
Tensile Strain (Break)	19	%	ISO 527-2
Flexural Modulus	325000	psi	ASTM D790
Flexural Modulus	331000	psi	ISO 178
Flexural Strength	11400	psi	ASTM D790
Flexural Stress	11300	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (0.125 in)	4.0	ft·lb/in	ASTM D256
Notched Izod Impact Strength (0.125 in)	11	ft·lb/in²	ISO 180
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	250	°F	ASTM D648
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.06 in)	V-2		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	500 to 540	°F
Middle Temperature	510 to 550	°F
Front Temperature	520 to 560	°F
Nozzle Temperature	530 to 570	°F
Processing (Melt) Temp	510 to 565	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

Notes

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