

**Plaslube® PC CF15 TL6 BK**

 Techmer Polymer Modifiers - *Polycarbonate*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber, 15% Filler by Weight
Additive	• PTFE Lubricant
Features	• Lubricated
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

**Properties <sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.31		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.20	%	ASTM D570
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Strength (Break)	16200	psi	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	1.25E+6	psi	ASTM D790
Flexural Strength	23000	psi	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.27		
vs. Steel - Static	0.22		
Wear Factor	45	10 <sup>-10</sup> in <sup>3</sup> ·min/ft·lb·hr	ASTM D3702
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (73°F, 0.125 in)	1.0	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	6.0	ft·lb/in	ASTM D4812
<b>Hardness</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Rockwell Hardness (R-Scale)	118		ASTM D785
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Deflection Temperature Under Load (66 psi, Unannealed)	292	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	283	°F	ASTM D648
CLTE - Flow	1.1E-5	in/in/°F	ASTM D696
<b>Electrical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Surface Resistivity	1.0E+5	ohms	ASTM D257
Volume Resistivity	1.0E+4	ohms·cm	ASTM D257
<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating (0.06 in)	V-2		UL 94

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
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

<sup>1</sup> Typical properties: these are not to be construed as specifications.

