Plaslube® PC / PBT IM 1799 BK

Techmer Polymer Modifiers - *Polycarbonate + PBT*

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier
Features	• High Impact Resistance
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.22		ASTM D792
Melt Mass-Flow Rate (MFR) (265°C/5.0 kg)	16	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	9000	psi	ASTM D638
Tensile Elongation (Yield)	120	%	ASTM D638
Flexural Modulus	370000	psi	ASTM D790
Flexural Strength	13800	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			ASTM D256
-40°F, 0.125 in	3.0	ft·lb/in	
73°F, 0.125 in	14	ft·lb/in	
Instrumented Dart Impact			ASTM D3763
-40°F, Total Energy	55.0	in·lb	
73°F, Total Energy	56.0	in·lb	
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	245	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	230	°F	ASTM D648
CLTE - Flow	4.5E-5	in/in/°F	ASTM D696
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	210	°F
Drying Time	4.0	hr
Rear Temperature	460 to 510	°F
Middle Temperature	460 to 510	°F
Front Temperature	460 to 510	°F
Processing (Melt) Temp	460 to 510	°F
Mold Temperature	130 to 200	°F
Back Pressure	25.0 to 60.0	psi
Screw Speed	30 to 60	rpm