

**Plaslube® PEEK CF10 TL10 GL10 A**

 Techmer Polymer Modifiers - *Polyetheretherketone*
**General Information**
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|                        |                                      |                                     |                              |
|------------------------|--------------------------------------|-------------------------------------|------------------------------|
| Material Status        | • Commercial: Active                 |                                     |                              |
| Availability           | • North America                      |                                     |                              |
| Filler / Reinforcement | • Carbon Fiber, 10% Filler by Weight | • Glass Fiber, 10% Filler by Weight | • Talc, 10% Filler by Weight |
| Additive               | • Lubricant                          |                                     |                              |
| Features               | • Lubricated                         |                                     |                              |
| Processing Method      | • Injection Molding                  |                                     |                              |

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

|                                     | Nominal Value   | Unit     | Test Method |
|-------------------------------------|-----------------|----------|-------------|
| <b>Physical</b>                     |                 |          |             |
| Density / Specific Gravity          | 1.44            |          | ASTM D792   |
| Molding Shrinkage - Flow (0.125 in) | 5.0E-3 to 0.010 | in/in    | ASTM D955   |
| <b>Mechanical</b>                   |                 |          |             |
| Tensile Modulus                     | 1.70E+6         | psi      | ASTM D638   |
| Tensile Strength (Yield)            | 19000           | psi      | ASTM D638   |
| Tensile Elongation (Break)          | 3.5             | %        | ASTM D638   |
| <b>Impact</b>                       |                 |          |             |
| Notched Izod Impact (0.125 in)      | 1.2             | ft·lb/in | ASTM D256   |

**Processing Information**

|                        | Nominal Value | Unit |
|------------------------|---------------|------|
| <b>Injection</b>       |               |      |
| Drying Temperature     | 300           | °F   |
| Drying Time            | 3.0 to 4.0    | hr   |
| Rear Temperature       | 670 to 710    | °F   |
| Middle Temperature     | 680 to 720    | °F   |
| Front Temperature      | 690 to 730    | °F   |
| Nozzle Temperature     | 695 to 740    | °F   |
| Processing (Melt) Temp | 690 to 750    | °F   |
| Mold Temperature       | 250 to 400    | °F   |
| Injection Rate         | Slow-Moderate |      |
| Back Pressure          | 50.0 to 100   | psi  |
| Screw Speed            | Moderate      |      |

