

**Plaslube® PEEK CF15 TL10 A**

 Techmer Polymer Modifiers - *Polyetheretherketone*
**General Information**
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|                        |  |
|------------------------|--|
| Material Status        | <ul style="list-style-type: none"> <li>Commercial: Active</li> </ul> |
| Availability           | <ul style="list-style-type: none"> <li>North America</li> </ul>      |
| Filler / Reinforcement | <ul style="list-style-type: none"> <li>Carbon Fiber</li> </ul>       |
| Additive               | <ul style="list-style-type: none"> <li>PTFE Lubricant</li> </ul>     |
| Features               | <ul style="list-style-type: none"> <li>Lubricated</li> </ul>         |
| Appearance             | <ul style="list-style-type: none"> <li>Black</li> </ul>              |
| Processing Method      | <ul style="list-style-type: none"> <li>Injection Molding</li> </ul>  |

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

| <b>Physical</b>   | <b>Nominal Value</b> | <b>Unit</b> | <b>Test Method</b> |
|---|----------------------|-------------|--------------------|
| Density / Specific Gravity                              | 1.42                 |             | ASTM D792          |
| Molding Shrinkage - Flow (0.125 in)                     | 2.0E-3               | in/in       | ASTM D955          |
| Water Absorption (24 hr)                                | 0.15                 | %           | ASTM D570          |
| <b>Mechanical</b>                                       | <b>Nominal Value</b> | <b>Unit</b> | <b>Test Method</b> |
| Tensile Strength (Break)                                | 19000                | psi         | ASTM D638          |
| Tensile Elongation (Break)                              | 1.5                  | %           | ASTM D638          |
| Flexural Modulus  | 1.40E+6              | psi         | ASTM D790          |
| Flexural Strength                                       | 31000                | psi         | ASTM D790          |
| <b>Impact</b>   | <b>Nominal Value</b> | <b>Unit</b> | <b>Test Method</b> |
| Notched Izod Impact (73°F, 0.125 in)                    | 1.2                  | ft·lb/in    | ASTM D256          |
| <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 (264 psi, Unannealed) | 570                  | °F          | ASTM D648          |
| CLTE - Flow   | 6.0E-6               | in/in/°F    | ASTM D696          |
| <b>Electrical</b>                                       | <b>Nominal Value</b> | <b>Unit</b> | <b>Test Method</b> |
| Volume Resistivity                                      | 1.0E+5               | ohms·cm     | ASTM D257          |
| <b>Flammability</b>                                     | <b>Nominal Value</b> | <b>Unit</b> | <b>Test Method</b> |
| Flame Rating (0.06 in)                                  | V-0                  |             | UL 94              |

**Processing Information**

| <b>Injection</b>       | <b>Nominal Value</b> | <b>Unit</b> |
|------------------------|----------------------|-------------|
| Drying Temperature     | 300                  | °F          |
| Drying Time            | 2.0 to 4.0           | hr          |
| Rear Temperature       | 680 to 730           | °F          |
| Middle Temperature     | 680 to 730           | °F          |
| Front Temperature      | 680 to 730           | °F          |
| Processing (Melt) Temp | 680 to 720           | °F          |
| Mold Temperature       | 350 to 425           | °F          |
| Back Pressure          | 50.0 to 100          | psi         |
| Screw Speed            | 50 to 100            | rpm         |

