Plaslube® PEI CF30 TL15

Techmer Polymer Modifiers - *Polyetherimide*

General Information

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber, 30% Filler by Weight
Additive	• PTFE Lubricant
Features	• Lubricated
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.47		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.30	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break)	29400	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	2.50E+6	psi	ASTM D790
Flexural Strength	39000	psi	ASTM D790
Coefficient of Friction			ASTM D1894
vs. Steel - Dynamic	0.19		
vs. Steel - Static	0.20		
Wear Factor	35	10^-10 in³·min/ft·lb·hr	ASTM D3702
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	1.8	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	13	ft·lb/in	ASTM D4812
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	121		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	415	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	410	°F	ASTM D648
CLTE - Flow	9.0E-6	in/in/°F	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.0E+7	ohms·cm	ASTM D257

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	285	°F
Drying Time	3.0	hr
Rear Temperature	675 to 735	°F
Middle Temperature	675 to 735	°F
Front Temperature	675 to 735	°F
Processing (Melt) Temp	670 to 730	°F
Mold Temperature	275 to 325	°F
Back Pressure	50.0 to 100	psi
Screw Speed	50 to 100	rpm