

Plaslube® PC CF10 TL10 BK

Polycarbonate

Techmer Engineered Solutions

Message:

Plaslube® PC CF10 TL10 BK is a polycarbonate (PC) product that contains 10% carbon fiber reinforcement. It can be processed by injection molding and is available in North America.

Features include:

flame retardant/rated flame

Lubrication

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 10% filler by weight		
Additive	PTFE lubricant		
Features	Lubrication		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.33	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	0.10	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	114	MPa	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	6550	MPa	ASTM D790
Flexural Strength	145	MPa	ASTM D790
Coefficient of Friction			ASTM D1894
With steel-dynamic	0.25		ASTM D1894
With steel-static	0.18		ASTM D1894
Wear Factor	73	10 ⁻⁸ mm ³ /N · m	ASTM D3702
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	75	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	320	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	144	°C	ASTM D648
1.8 MPa, not annealed	139	°C	ASTM D648
CLTE - Flow	2.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method

Surface Resistivity	1.0E+5	ohms	ASTM D257
Volume Resistivity	1.0E+4	ohms·cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-2		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	302 - 316	°C	
Middle Temperature	316 - 332	°C	
Front Temperature	310 - 327	°C	
Nozzle Temperature	310 - 327	°C	
Processing (Melt) Temp	304 - 327	°C	
Mold Temperature	71.1 - 87.8	°C	
Injection Rate	Moderate		
Back Pressure	0.00 - 0.689	MPa	

Injection instructions

Screw Speed: Medium Recommendations for Molding and Tool Conditions: Well vented mold Moisture Content, as received: Product is packaged at 0.2% or less.

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

