

# Plaslube® PC CF15 TL6 BK

Polycarbonate  
Techmer Engineered Solutions

Message:

Plaslube®PC CF15 TL6 BK is a polycarbonate (PC) product that contains 15% 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, 15% filler by weight		
Additive	PTFE lubricant		
Features	Lubrication		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.31	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	0.20	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	112	MPa	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	8620	MPa	ASTM D790
Flexural Strength	159	MPa	ASTM D790
Coefficient of Friction			ASTM D1894
With steel-dynamic	0.27		ASTM D1894
With steel-static	0.22		ASTM D1894
Wear Factor	91	10 <sup>-8</sup> mm <sup>3</sup> /N · m	ASTM D3702
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	53	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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#### Recommended distributors for this material

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