

Plaslube® PC-50/TF/15

Polycarbonate

Techmer Engineered Solutions

Message:

Plaslube®PC-50/TF/15 is a polycarbonate (PC) product that contains fillers. It can be processed by injection molding and is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. Typical application areas are: commercial/office supplies.

Features include:

flame retardant/rated flame

ROHS certification

Good dimensional stability

Good toughness

beautiful

General Information			
Filler / Reinforcement	Filler		
Additive	PTFE lubricant (15%)		
Features	Good dimensional stability		
	Good toughness		
	Lubrication		
	Good appearance		
Uses	Business equipment		
RoHS Compliance	RoHS compliance		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.29	g/cm ³	ASTM D792
--	1290	kg/m ³	ISO 1183 ¹
Molding Shrinkage - Flow (3.18 mm)	0.70	%	ASTM D955
Water Absorption			
24 hr	0.12	%	ASTM D570
Saturation	0.35	%	ISO 62 ²
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	109		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2500	MPa	ISO 527-2 ³
Tensile Stress			
Yield	50.0	MPa	ISO 527-2 ⁴
23°C	51.7	MPa	ASTM D638
Tensile Strain			
Yield	6.0	%	ISO 527-2 ⁵

Fracture, 23°C	40	%	ASTM D638
Tensile Elongation at Break	40	%	ISO 527-2 ⁶
Flexural Modulus (23°C)	2070	MPa	ASTM D790
Flexural Strength (Break, 23°C)	75.8	MPa	ASTM D790
Compressive Strength	62.1	MPa	ASTM D695
Coefficient of Friction (vs. Steel - Static)	0.090		ASTM D1894
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	180	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	143	°C	ASTM D648
1.8 MPa, not annealed	135	°C	ASTM D648
1.8 MPa	130	°C	ISO 75-2 ⁷
CLTE - Flow	7.0E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating (1.59 mm)	HB		UL 94
Burning Behav. at 1.6mm nom. thickn. (1.50 mm, UL)	HB		ISO 1210 ⁸
Additional Information			
Compressive Strength, ASTM D695, 73°F: 9000 psi			
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.030	%	
Rear Temperature	299 - 316	°C	
Middle Temperature	310 - 327	°C	
Front Temperature	304 - 321	°C	
Nozzle Temperature	304 - 321	°C	
Processing (Melt) Temp	304 - 332	°C	
Mold Temperature	71.1 - 87.8	°C	
Injection Rate	Moderate		
Back Pressure	0.345 - 0.689	MPa	
Injection instructions			
Screw Speed: MediumRecommendations for Molding and Tool Conditions: Well ventedMoisture Content, as received: Product is packaged at 0.2% or less.			
NOTE			
1.	?????,?? ISO 10350 ??? 23°C/50%r.h. ???		
2.	?????,?? ISO 10350 ??? 23°C/50%r.h. ???		
3.	?????,?? ISO 10350 ??? 23°C/50%r.h. ???		
4.	?????,?? ISO 10350 ??? 23°C/50%r.h. ???		

5.	?????,?? ISO 10350 ??? 23°C/50%r.h. ???
6.	?????,?? ISO 10350 ??? 23°C/50%r.h. ???
7.	?????,?? ISO 10350 ??? 23°C/50%r.h. ???
8.	?????,?? ISO 10350 ??? 23°C/50%r.h. ???

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Recommended distributors for this material

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

