

Plaslube® PC GF30 TL15

Polycarbonate

Techmer Engineered Solutions

Message:

Plaslube®PC GF30 TL15 is a polycarbonate (PC) product, which contains a 30% glass fiber reinforced material. It can be processed by injection molding and is available in North America.

Features include:

flame retardant/rated flame

Lubrication

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	PTFE lubricant		
Features	Lubrication		
Appearance	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.55	g/cm ³	ASTM D792
Water Absorption (24 hr)	0.060	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	116		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	121	MPa	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	7580	MPa	ASTM D790
Flexural Strength	159	MPa	ASTM D790
Coefficient of Friction			ASTM D1894
With steel-dynamic	0.20		ASTM D1894
With steel-static	0.18		ASTM D1894
Wear Factor	60	10 ⁻⁸ mm ³ /N · m	ASTM D3702
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	146	°C	ASTM D648
1.8 MPa, not annealed	143	°C	ASTM D648
CLTE - Flow	2.9E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	V-1		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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