

TES J-50/10

Techmer Polymer Modifiers - Polycarbonate

Product Description

Molding Parameters:

4 hours recommended for high tensile strength and smooth surface finish, or for vacuum metalizing.

The dry temperature at 16 hours is 180°F.

For 2-zone machines, the rear temperature is 600-650°F, and the front temperature is 580-620°F.

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight
Features	• Creep Resistant • Good Dimensional Stability • High Strength • Fatigue Resistant • High Heat Resistance
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.28		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.13	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	650000	psi	ASTM D638
Tensile Strength (Break, 73°F)	12000	psi	ASTM D638
Tensile Elongation (Break, 73°F)	3.5	%	ASTM D638
Flexural Modulus (73°F)	600000	psi	ASTM D790
Flexural Strength (Break, 73°F)	18000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.250 in)	1.8	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	75		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	300	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	285	°F	ASTM D648
RTI Elec			UL 746B
0.06 in	167	°F	
0.12 in	167	°F	
RTI Imp			UL 746B
0.06 in	167	°F	
0.12 in	167	°F	
RTI Str			UL 746B
0.06 in	167	°F	
0.12 in	167	°F	
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	V-2		
0.12 in	V-0		

Processing Information

Injection

Nominal Value Unit



Drying Temperature	250 °F
Drying Time	2.0 to 4.0 hr
Suggested Max Moisture	0.10 %
Rear Temperature	570 to 600 °F
Middle Temperature	590 to 650 °F
Front Temperature	600 to 630 °F
Nozzle Temperature	590 to 630 °F
Processing (Melt) Temp	580 to 625 °F
Mold Temperature	160 to 190 °F

