

TES J-50/30/RG

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, 30% Filler by Weight
Features	• Good Flow
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.41		ASTM D792
Molding Shrinkage - Flow			ASTM D955
0.125 in	1.0E-3	in/in	
0.250 in	3.0E-3	in/in	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break, 73°F)	17000	psi	ASTM D638
Flexural Modulus (73°F)	950000	psi	ASTM D790
Flexural Strength (Break, 73°F)	20500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	2.5	ft·lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	284	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	2.0 to 4.0	hr
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

