TES J-50/20/RG

Techmer Polymer Modifiers - *Polycarbonate*

General Information

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 • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 20% 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	1.35		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3	in/in	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break, 73°F)	16000	psi	ASTM D638
Flexural Modulus (73°F)	850000	psi	ASTM D790
Flexural Strength (Break, 73°F)	22000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	1.8	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	280	°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