

TES J-50/30

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 • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber, 30% 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	1.45		ASTM D792
Molding Shrinkage - Flow (0.125 in)	1.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.090	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	1.20E+6	psi	ASTM D638
Tensile Strength (Break, 73°F)	19500	psi	ASTM D638
Tensile Elongation (Break, 73°F)	2.5	%	ASTM D638
Flexural Modulus (73°F)	1.10E+6	psi	ASTM D790
Flexural Strength (Break, 73°F)	25000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.250 in)	3.0	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	85		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	305	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	290	°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

Notes

¹ Typical properties: these are not to be construed as specifications.

