

TES J-50/20/FR

Polycarbonate

Techmer Engineered Solutions

Message:

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 550-590°F, and the front temperature is 540-560°F.

General Information			
UL YellowCard	E253782-484567	E253782-484573	
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	Flame Retardant		
Features	Flame Retardant		
	Good Dimensional Stability		
	High Heat Resistance		
RoHS Compliance	RoHS Compliant		
Appearance	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.36	g/cm³	ASTM D792
Molding Shrinkage - Flow			ASTM D955
3.18 mm	0.30	%	
6.35 mm	0.40	%	
Water Absorption (24 hr)	0.15	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	77		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	6890	MPa	ASTM D638
Tensile Strength (Break, 23°C)	96.5	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	3.0	%	ASTM D638
Flexural Modulus (23°C)	6210	MPa	ASTM D790
Flexural Strength (Break, 23°C)	145	MPa	ASTM D790
Compressive Strength	124	MPa	ASTM D695
Shear Strength	62.1	MPa	ASTM D732
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.35 mm)	96	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648

0.45 MPa, Unannealed	149	°C	
1.8 MPa, Unannealed	149	°C	
CLTE - Flow	2.2E-5	cm/cm/°C	ASTM D696
RTI Elec			UL 746
1.47 mm	125	°C	
3.18 mm	75.0	°C	
RTI Imp			UL 746
1.47 mm	115	°C	
3.18 mm	75.0	°C	
RTI Str			UL 746
1.47 mm	125	°C	
3.18 mm	75.0	°C	
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.59 mm	V-0		
3.18 mm	5VA		
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	277 to 288	°C	
Middle Temperature	288 to 310	°C	
Front Temperature	282 to 293	°C	
Nozzle Temperature	277 to 293	°C	
Processing (Melt) Temp	282 to 299	°C	
Mold Temperature	71.1 to 87.8	°C	

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