

TAROLON 3002 G3

Polycarbonate

Taro Plast S.p.A.

Message:

Polycarbonate medium high viscosity 15% glass fibres reinforced, flame retardant UL94 V1.

General Information			
UL YellowCard	E143048-571828		
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Additive	Flame retardancy		
Features	Medium and high viscosity		
	Flame retardancy		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.28 - 1.30	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	8.0	g/10 min	ISO 1133
Molding Shrinkage - Flow	0.30 - 0.50	%	Internal method
Water Absorption			ISO 62
23°C, 24 hr	0.080	%	ISO 62
Saturated, 23°C	0.25	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4200	MPa	ISO 527-2/1
Tensile Stress (Break)	75.0	MPa	ISO 527-2/50
Tensile Strain (Break)	5.0	%	ISO 527-2/50
Flexural Modulus ¹	4300	MPa	ISO 178
Flexural Stress ²	110	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	8.0	kJ/m²	ISO 179/1eA
Notched Izod Impact (23°C)	100	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ³ (1.8 MPa, Unannealed)	140	°C	ISO 75-2/A
Vicat Softening Temperature	153	°C	ISO 306/A50
Ball Pressure Test (125°C)	Pass		IEC 60695-10-2
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index (Solution A)	150	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94

1.50 mm	V-2	UL 94
3.00 mm	V-1	UL 94
Oxygen Index	30	%
		ASTM D2863
Injection	Nominal Value	Unit
Drying Temperature	100 - 110	°C
Drying Time	1.0 - 2.0	hr
Processing (Melt) Temp	260 - 300	°C
Mold Temperature	100 - 120	°C
Injection Rate	Moderate	
Injection instructions		
Pre-heat Temperature: 120 to 130°CPre-heat Time: 3 hrs		
NOTE		
1.	1.0 mm/min	
2.	1.0 mm/min	
3.	120°C/hr	

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