

# TES J-50/30/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		
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Flame Retardant		
Features	Flame Retardant		
	Good Dimensional Stability		
	Good Stiffness		
	Good Toughness		
	High Heat Resistance		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow			ASTM D955
3.18 mm	0.20	%	
6.35 mm	0.30	%	
Water Absorption (24 hr)	0.17	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	85		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	7580	MPa	ASTM D638
Tensile Strength (Break, 23°C)	114	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	2.0	%	ASTM D638
Flexural Modulus (23°C)	8270	MPa	ASTM D790
Flexural Strength (Break, 23°C)	162	MPa	ASTM D790
Compressive Strength	145	MPa	ASTM D695
Shear Strength	65.5	MPa	ASTM D732
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.35 mm)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load (1.8 MPa, Unannealed)	152	°C	ASTM D648
CLTE - Flow	1.4E-5	cm/cm/°C	ASTM D696
RTI Elec (1.47 mm)	125	°C	UL 746
RTI Imp (1.47 mm)	115	°C	UL 746
RTI Str (1.47 mm)	125	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating (1.59 mm)	V-0		UL 94
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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