

TES J-50/30/RG

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 600-650°F, and the front temperature is 580-620°F.

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	Good Flow		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.41	g/cm ³	ASTM D792
Molding Shrinkage - Flow			ASTM D955
3.18 mm	0.10	%	
6.35 mm	0.30	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break, 23°C)	117	MPa	ASTM D638
Flexural Modulus (23°C)	6550	MPa	ASTM D790
Flexural Strength (Break, 23°C)	141	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	130	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	140	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	2.0 to 4.0	hr	
Rear Temperature	299 to 316	°C	
Middle Temperature	310 to 343	°C	
Front Temperature	316 to 332	°C	
Nozzle Temperature	310 to 332	°C	
Processing (Melt) Temp	304 to 329	°C	
Mold Temperature	71.1 to 87.8	°C	

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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