

TES J-50/10

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			
UL YellowCard	E253782-484570		
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Features	Fatigue Resistant		
	Good Creep Resistance		
	Good Dimensional Stability		
	High Heat Resistance		
	High Strength		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	0.13	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	75		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	4480	MPa	ASTM D638
Tensile Strength (Break, 23°C)	82.7	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	3.5	%	ASTM D638
Flexural Modulus (23°C)	4140	MPa	ASTM D790
Flexural Strength (Break, 23°C)	124	MPa	ASTM D790
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	141	°C	
RTI Elec	UL 746		
1.47 mm	75.0	°C	

3.05 mm	75.0	°C	
RTI Imp			UL 746
1.47 mm	75.0	°C	
3.05 mm	75.0	°C	
RTI Str			UL 746
1.47 mm	75.0	°C	
3.05 mm	75.0	°C	
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.47 mm	V-2		
3.05 mm	V-0		
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.10	%	
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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