



PRODUCT INFORMATION

TAROLON 3002 G3

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

ISO short ISO 1043: PC-GF15 FR
Form Pellets
UL file E143048

Key Features

- Designed for injection moulding applications
- Glass fibres reinforced
- Good flowability

Compliance

- UL94 approved all colours V2 at 1,5 mm and V1 at 3,0 mm. UL746 B approved.

Availability

- W: lubricated
- Various colours (NT-WT-GY-BK)
- L: UV stabilized

Process

- INJECTION MOULDING

Application

- Electronic
- Electrical
- Automotive

Property	Method	Unit	Value	Condition	State
ELECTRICAL					
Tracking Resistance (CTI - Method A)	IEC 60112	Volt	150		
PHYSICAL					
Density (+23°C)	ISO 1183	g/cm ³	1,28-1,30		
Filler content	ISO 3451	%	15	850°C - 1 h	
Water Absorption (24h / +23°C)	ISO 62	%	0,08		
Water Absorption at Saturation	ISO 62	%	0,25		
Mould Shrinkage (Parallel)	Internal method	%	0,3-0,5		
Melt Flow Rate (MFR)	ISO 1133	g/10 min	8	300°C - 1,2 kg	
MECHANICAL					
Tensile Modulus	ISO 527-1,2	MPa	4200	Speed 1 mm/min	
Elongation at Break	ISO 527-1,2	%	5	Speed 50 mm/min	

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Tensile Break Strength	ISO 527-1,2	MPa	75	Speed 50 mm/min
Flexural Modulus	ISO 178	MPa	4300	Speed 1 mm/min
Flexural Break Strength	ISO 178	MPa	110	Speed 1 mm/min
IZOD Notched Impact	ASTM D256	J/m	100	+23°C
CHARPY Notched Impact (+23°C)	ISO 179/1eA	kJ/m ²	8	

THERMAL

Softening Temperature - 1 kg (VST/A/50)	ISO 306	°C	153	50°C / h
Deflection Temperature 1,80 MPa (HDT A)	ISO 75A	°C	140	120°C / h
Ball Pressure Test	IEC 60695-10-2	°C	125	

FLAMMABILITY

Flame Behaviour (1,5 mm)	UL94	Class	V2	UL approved
Flame Behaviour (3,0 mm)	UL94	Class	V1	UL approved
Oxygen index	ASTM D2863	%	30	

INJECTION MOULDING

	Value
Drying Temperature (Desiccant Dryer)	120°C
Drying Time (Desiccant Dryer)	2 - 4 hours
Suggested Max Moisture	0,02 %
Suggested Max Regrind	< 15 %
Melt Temperature	260 - 290°C
Feed Temperature	80 - 100°C
Rear Temperature	250 - 270°C
Middle Temperature	260 - 280°C
Front Temperature	270 - 285°C
Nozzle Temperature	275 - 295°C
Mould Temperature	80 - 120°C
Injection Rate	Medium to Fast
Back Pressure	As low as possible (< 0,3 Mpa)
Screw Revolving Speed	25 - 50 rpm
Screw Revolving Speed	50 rpm @ Diameter 40 mm
Screw Revolving Speed	35 rpm @ Diameter 55 mm



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Screw Revolving Speed	25 rpm @ Diameter 75 mm
Cushion	3 - 5 mm
Vent Depth	0,05 mm

Notes During processing, a dehumidifying hopper dryer is recommended at a temperature of 60 to 80°C.