

TEKAMID™ TB120CR

Polyamide 6

Mando Advanced Materials Co., Ltd.

Message:

TB120CR is a unreinforced polyamide 6 with fast crystallinity.

General Information			
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.4	%	ASTM D955
Water Absorption (23°C, 24 hr)	1.7	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break)	75.5	MPa	ASTM D638
Tensile Elongation ² (Break)	60	%	ASTM D638
Flexural Modulus ³	2650	MPa	ASTM D790
Flexural Strength ⁴	108	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	44	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	175	°C	ASTM D648
1.8 MPa, not annealed	85.0	°C	ASTM D648
Peak Melting Temperature	220	°C	ASTM D3418
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	4.0 - 5.0	hr	
Rear Temperature	240 - 260	°C	
Middle Temperature	240 - 260	°C	
Front Temperature	240 - 260	°C	
Nozzle Temperature	250 - 270	°C	
Processing (Melt) Temp	240 - 270	°C	
Mold Temperature	60.0 - 90.0	°C	
Injection instructions			
Injection Speed: 20 to 50%Injection Pressure - 1st: 30 to 60%Injection Pressure - 2nd: 30 to 60%Injection Pressure - Back Pressure: 0 to 20%			
NOTE			
1.	5.0 mm/min		
2.	5.0 mm/min		
3.	3.0 mm/min		

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