

TES J-71/20/VO/ND

Polyamide + SAN

Techmer Engineered Solutions

Message:

Molding Parameters:

The dry temperature at 16 hours is 165°F.

For 2-zone machines, the rear temperature is 510-540°F, and the front temperature is 500-530°F.

General Information			
Filler / Reinforcement	Glass Fiber		
Additive	Flame Retardant		
Features	Flame Retardant		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.16	%	ASTM D955
Water Absorption (24 hr)	0.43	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	90		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	9860	MPa	ASTM D638
Tensile Strength (Break, 23°C)	108	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	1.8	%	ASTM D638
Flexural Modulus (23°C)	7930	MPa	ASTM D790
Flexural Strength (Break, 23°C)	164	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	53	J/m	ASTM D256
Unnotched Izod Impact (23°C, 3.18 mm)	270	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	177	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating (1.59 mm)	V-0		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	2.0 to 4.0	hr	
Rear Temperature	254 to 271	°C	
Middle Temperature	271 to 288	°C	
Front Temperature	260 to 282	°C	

Nozzle Temperature	249 to 288	°C
Processing (Melt) Temp	249 to 277	°C
Mold Temperature	60.0 to 82.2	°C

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