

TES J-1200/10/VO

Acrylonitrile Butadiene Styrene
Techmer Engineered Solutions

Message:

Molding Parameters:
For 2-zone machines, the rear temperature is 450-520°F, and the front temperature is 420-470°F.

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Additive	Flame Retardant		
Features	Good Dimensional Stability		
	Good Impact Resistance		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.20	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break, 23°C)	75.8	MPa	ASTM D638
Flexural Modulus (23°C)	4830	MPa	ASTM D790
Flexural Strength (Break, 23°C)	103	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.35 mm)	59	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	100	°C	ASTM D648
Flammability	Nominal Value	Test Method	
Flame Rating (1.59 mm)	V-0	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	71.1	°C	
Drying Time	1.0	hr	
Rear Temperature	216 to 232	°C	
Middle Temperature	221 to 238	°C	
Front Temperature	210 to 221	°C	
Nozzle Temperature	199 to 221	°C	
Processing (Melt) Temp	232 to 260	°C	
Mold Temperature	71.1 to 87.8	°C	

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