

TEKAMID™ HT14ST

Polyamide 6 + ABS

Mando Advanced Materials Co., Ltd.

Message:

H14ST is a unreinforced PA6/ABS alloy product with super toughness.

General Information			
Features	Ultra high toughness		
Uses	Electrical/Electronic Applications		
	Application in Automobile Field		
	Sporting goods		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.70	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.90	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break)	47.1	MPa	ASTM D638
Tensile Elongation ² (Break)	100	%	ASTM D638
Flexural Modulus ³	1960	MPa	ASTM D790
Flexural Strength ⁴	73.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.18 mm	> 390	J/m	ASTM D256
23°C, 3.18 mm ⁵	No Break		ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	80.0	°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 - 120	°C	
Drying Time	3.0 - 4.0	hr	
Rear Temperature	230 - 250	°C	
Middle Temperature	230 - 250	°C	
Front Temperature	230 - 250	°C	
Nozzle Temperature	240 - 260	°C	
Processing (Melt) Temp	230 - 260	°C	
Mold Temperature	70.0 - 90.0	°C	

Injection instructions

Injection Speed: 30 to 70% Injection Pressure - 1st: 20 to 50% Injection Pressure - 2nd: 20 to 50% Injection Pressure - Back Pressure: 0 to 20%

NOTE

1.	50 mm/min
2.	50 mm/min
3.	3.0 mm/min
4.	3.0 mm/min
5.	90 kgf-cm/cm

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