

TES J-1200/20/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,20% Filler by Weight		
Additive	Flame Retardant		
Features	Good Dimensional Stability		
	Good Impact Resistance		
Agency Ratings	FDA Unspecified Rating		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.37	g/cm³	ASTM D792
Molding Shrinkage - Flow			ASTM D955
3.18 mm	0.080	%	
6.35 mm	0.18	%	
Water Absorption (24 hr)	0.22	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	59		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	5170	MPa	ASTM D638
Tensile Strength (Break, 23°C)	83.4	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	2.7	%	ASTM D638
Flexural Modulus (23°C)	6480	MPa	ASTM D790
Flexural Strength (Break, 23°C)	112	MPa	ASTM D790
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	101	°C	
1.8 MPa, Unannealed	100	°C	
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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