

TES J-1200/20

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			
UL YellowCard	E253782-484554		
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	Good Dimensional Stability		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.23	g/cm³	ASTM D792
Molding Shrinkage - Flow			ASTM D955
3.18 mm	0.30	%	
6.35 mm	0.30	%	
Water Absorption (24 hr)	0.30	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	75		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	6210	MPa	ASTM D638
Tensile Strength (Break, 23°C)	82.7	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	2.0	%	ASTM D638
Flexural Modulus (23°C)	5860	MPa	ASTM D790
Flexural Strength (Break, 23°C)	110	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	80	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	107	°C	
1.8 MPa, Unannealed	98.9	°C	
RTI Elec			UL 746
1.47 mm	60.0	°C	
3.05 mm	60.0	°C	
6.10 mm	60.0	°C	
RTI Imp			UL 746
1.47 mm	60.0	°C	

3.05 mm	60.0	°C	
6.10 mm	60.0	°C	
RTI Str			UL 746
1.47 mm	60.0	°C	
3.05 mm	60.0	°C	
6.10 mm	60.0	°C	
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.47 mm	HB		
3.05 mm	HB		
6.10 mm	HB		
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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