

# TES J-1200/30

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                       | E253782-484551                   |                   |             |
| Filler / Reinforcement              | Glass Fiber,30% 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                    | 1.29                             | g/cm <sup>3</sup> | ASTM D792   |
| Molding Shrinkage - Flow            |                                  |                   | ASTM D955   |
| 3.18 mm                             | 0.20                             | %                 |             |
| 6.35 mm                             | 0.30                             | %                 |             |
| Water Absorption (24 hr)            | 0.30                             | %                 | ASTM D570   |
| Hardness                            | Nominal Value                    | Unit              | Test Method |
| Rockwell Hardness (M-Scale)         | 80                               |                   | ASTM D785   |
| Mechanical                          | Nominal Value                    | Unit              | Test Method |
| Tensile Modulus (23°C)              | 6890                             | MPa               | ASTM D638   |
| Tensile Strength (Break, 23°C)      | 89.6                             | MPa               | ASTM D638   |
| Tensile Elongation (Break, 23°C)    | 2.0                              | %                 | ASTM D638   |
| Flexural Modulus (23°C)             | 6890                             | MPa               | ASTM D790   |
| Flexural Strength (Break, 23°C)     | 114                              | MPa               | ASTM D790   |
| Impact                              | Nominal Value                    | Unit              | Test Method |
| Notched Izod Impact (23°C, 3.18 mm) | 64                               | J/m               | ASTM D256   |
| Thermal                             | Nominal Value                    | Unit              | Test Method |
| Deflection Temperature Under Load   |                                  |                   | ASTM D648   |
| 0.45 MPa, Unannealed                | 110                              | °C                |             |
| 1.8 MPa, Unannealed                 | 102                              | °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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