

TECNOBLEND B45 G4

Acrylonitrile Butadiene Styrene + Nylon

Taro Plast S.p.A.

Message:

ABS/PA alloy 20% glass fibres reinforced combining excellent dimensional stability, good impact strength, rigidity and chemical resistance with high heat resistance and low shrinkage.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Features	Good dimensional stability		
	Rigid, good		
	Impact resistance, good		
	Good chemical resistance		
	Heat resistance, high		
	Low shrinkage		
Agency Ratings	EU 2000/53/EC		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (240°C/10.0 kg)	30	g/10 min	ISO 1133
Molding Shrinkage			Internal method
Vertical flow direction: 23°C, 3.20mm	0.70	%	Internal method
Flow direction: 23°C, 3.20mm	0.40	%	Internal method
Water Absorption (Saturation, 23°C)	1.1	%	ISO 62
Granule Humidity ¹		%	
Reinforcement Content ² (750°C)	20	%	ISO 3451
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5400	MPa	ISO 527-2/1
Tensile Stress (Break)	85.0	MPa	ISO 527-2/50
Tensile Strain (Break)	3.0	%	ISO 527-2/50
Flexural Modulus ³	4600	MPa	ISO 178
Flexural Stress ⁴	120	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	6.5	kJ/m ²	ISO 179/1eA
23°C	14	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-20°C	60	J/m	ASTM D256
23°C	120	J/m	ASTM D256

-30°C	6.0	kJ/m ²	ISO 180/1A
Notched Izod Impact (23°C)	12.0	kJ/m ²	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵			
0.45 MPa, not annealed	180	°C	ISO 75-2/B
1.8 MPa, not annealed	110	°C	ISO 75-2/A
Vicat Softening Temperature			
--	185	°C	ISO 306/A50
--	175	°C	ISO 306/B50
CLTE - Flow (-30 to 30°C)	4.0E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index (Solution A)	> 600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Burning Rate ⁶ (1.60 mm)	< 100	mm/min	ISO 3795
Flame Rating (1.60 mm)	HB		UL 94
Glow Wire Flammability Index (2.00 mm)	650	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	1.0	hr	
Processing (Melt) Temp	240 - 280	°C	
Mold Temperature	40.0 - 80.0	°C	
Injection Rate	Moderate		
Injection instructions			
Pre-heat Temperature: 80 to 100°CPre-heat Time: 3 hr			
NOTE			
1.	TARO 002		
2.	1 hr		
3.	1.0 mm/min		
4.	1.0 mm/min		
5.	120°C/hr		
6.	US FMVSS302		

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