

TES J-80/10

Acetal (POM) Copolymer
Techmer Engineered Solutions

Message:

Molding Parameters:
For 2-zone machines, the rear temperature is 360-410°F, and the front temperature is 350-380°F.

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Features	Copolymer		
	Good Chemical Resistance		
	Good Dimensional Stability		
	Good Stiffness		
	Good Toughness		
	High Strength		
	Self Lubricating		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.48	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.60 to 0.80	%	ASTM D955
Water Absorption (24 hr)	0.26	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	80		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5170	MPa	ASTM D638
Tensile Strength (Yield)	68.9	MPa	ASTM D638
Tensile Elongation (Yield)	3.0	%	ASTM D638
Flexural Modulus	4480	MPa	ASTM D790
Flexural Strength (Yield)	103	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	160	°C	
1.8 MPa, Unannealed	157	°C	
Injection	Nominal Value	Unit	
Drying Temperature	71.1	°C	

Drying Time	1.0	hr
Rear Temperature	177 to 193	°C
Middle Temperature	188 to 210	°C
Front Temperature	182 to 199	°C
Nozzle Temperature	177 to 204	°C
Processing (Melt) Temp	193 to 216	°C
Mold Temperature	82.2 to 121	°C

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