

# TEKAMID™ TB120GM

Polyamide 6

Mando Advanced Materials Co., Ltd.

## Message:

TB120GM is GF/MF 40% reinforced polyamide 6 .

| General Information                                                                                                                          |                                      |                   |             |
|----------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------|-------------------|-------------|
| Filler / Reinforcement                                                                                                                       | Glass \mineral, 40% filler by weight |                   |             |
| Uses                                                                                                                                         | Application in Automobile Field      |                   |             |
| Physical                                                                                                                                     | Nominal Value                        | Unit              | Test Method |
| Specific Gravity                                                                                                                             | 1.48                                 | g/cm <sup>3</sup> | ASTM D792   |
| Molding Shrinkage - Flow                                                                                                                     | 0.50 - 0.80                          | %                 | ASTM D955   |
| Water Absorption (23°C, 24 hr)                                                                                                               | 1.3                                  | %                 | ASTM D570   |
| Mechanical                                                                                                                                   | Nominal Value                        | Unit              | Test Method |
| Tensile Strength <sup>1</sup> (Break)                                                                                                        | 118                                  | MPa               | ASTM D638   |
| Tensile Elongation <sup>2</sup> (Break)                                                                                                      | 3.0                                  | %                 | ASTM D638   |
| Flexural Modulus <sup>3</sup>                                                                                                                | 6570                                 | MPa               | ASTM D790   |
| Flexural Strength <sup>4</sup>                                                                                                               | 172                                  | MPa               | ASTM D790   |
| Impact                                                                                                                                       | Nominal Value                        | Unit              | Test Method |
| Notched Izod Impact (23°C, 3.18 mm)                                                                                                          | 40                                   | J/m               | ASTM D256   |
| Thermal                                                                                                                                      | Nominal Value                        | Unit              | Test Method |
| Deflection Temperature Under Load                                                                                                            |                                      |                   | ASTM D648   |
| 0.45 MPa, not annealed                                                                                                                       | 215                                  | °C                | ASTM D648   |
| 1.8 MPa, not annealed                                                                                                                        | 204                                  | °C                | ASTM D648   |
| Peak Melting Temperature                                                                                                                     | 220                                  | °C                | ASTM D3418  |
| Flammability                                                                                                                                 | Nominal Value                        |                   | Test Method |
| Flame Rating                                                                                                                                 | HB                                   |                   | UL 94       |
| Injection                                                                                                                                    | Nominal Value                        | Unit              |             |
| Drying Temperature                                                                                                                           | 80.0 - 100                           | °C                |             |
| Drying Time                                                                                                                                  | 4.0 - 5.0                            | hr                |             |
| Rear Temperature                                                                                                                             | 235 - 255                            | °C                |             |
| Middle Temperature                                                                                                                           | 240 - 270                            | °C                |             |
| Front Temperature                                                                                                                            | 270                                  | °C                |             |
| Nozzle Temperature                                                                                                                           | 250 - 280                            | °C                |             |
| Processing (Melt) Temp                                                                                                                       | 250 - 280                            | °C                |             |
| Mold Temperature                                                                                                                             | 80.0 - 100                           | °C                |             |
| Injection instructions                                                                                                                       |                                      |                   |             |
| Injection Speed: 40 to 70%Injection Pressure - 1st: 20 to 50%Injection Pressure - 2nd: 20 to 50%Injection Pressure - Back Pressure: 0 to 20% |                                      |                   |             |
| NOTE                                                                                                                                         |                                      |                   |             |
| 1.                                                                                                                                           | 5.0 mm/min                           |                   |             |

|    |            |
|----|------------|
| 2. | 5.0 mm/min |
| 3. | 3.0 mm/min |
| 4. | 3.0 mm/min |

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