

TES J-1200/10/FD

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			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Agency Ratings	FDA Unspecified Rating		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	4140	MPa	ASTM D638
Tensile Strength (Break, 23°C)	62.1	MPa	ASTM D638
Flexural Modulus (23°C)	3790	MPa	ASTM D790
Flexural Strength (Break, 23°C)	89.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	69	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	100	°C	ASTM D648
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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