

TEKAMID™ TB120HI

Polyamide 6

Mando Advanced Materials Co., Ltd.

Message:

TB120HI is PA6 unreinforced impact modified product.

General Information			
Additive	Impact modifier		
Features	Impact modification		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.4	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break)	63.7	MPa	ASTM D638
Flexural Modulus ²	2350	MPa	ASTM D790
Flexural Strength ³	93.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	120	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	55.0	°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	225 - 245	°C	
Middle Temperature	230 - 260	°C	
Front Temperature	240 - 270	°C	
Nozzle Temperature	240 - 270	°C	
Processing (Melt) Temp	240 - 270	°C	
Mold Temperature	60.0 - 80.0	°C	
Injection instructions			
Injection Speed: 20 to 50%Injection Pressure - 1st: 30 to 60%Injection Pressure - 2nd: 30 to 60%Injection Pressure - Back Pressure: 0 to 20%			
NOTE			
1.	50 mm/min		
2.	3.0 mm/min		
3.	3.0 mm/min		

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Recommended distributors for this material

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