

TES J-1200/30

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

Product Description

Molding Parameters:

For 2-zone machines, the rear temperature is 450-520°F, and the front temperature is 420-470°F.

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Features	• Good Dimensional Stability
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.29		ASTM D792
Molding Shrinkage - Flow			ASTM D955
0.125 in	2.0E-3	in/in	
0.250 in	3.0E-3	in/in	
Water Absorption (24 hr)	0.30	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	1.00E+6	psi	ASTM D638
Tensile Strength (Break, 73°F)	13000	psi	ASTM D638
Tensile Elongation (Break, 73°F)	2.0	%	ASTM D638
Flexural Modulus (73°F)	1.00E+6	psi	ASTM D790
Flexural Strength (Break, 73°F)	16500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.2	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	80		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	230	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	215	°F	ASTM D648
RTI Elec			UL 746B
0.06 in	140	°F	
0.12 in	140	°F	
0.24 in	140	°F	
RTI Imp			UL 746B
0.06 in	140	°F	
0.12 in	140	°F	
0.24 in	140	°F	
RTI Str			UL 746B
0.06 in	140	°F	
0.12 in	140	°F	
0.24 in	140	°F	
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in		HB	



0.12 in	HB
0.24 in	HB

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	160	°F
Drying Time	1.0	hr
Rear Temperature	420 to 450	°F
Middle Temperature	430 to 460	°F
Front Temperature	410 to 430	°F
Nozzle Temperature	390 to 430	°F
Processing (Melt) Temp	450 to 500	°F
Mold Temperature	160 to 190	°F

