

TES J-1200/20/VO

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, 20% Filler by Weight
Additive	• Flame Retardant
Features	• Good Dimensional Stability • Good Impact Resistance
Agency Ratings	• FDA Unspecified Rating
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.37		ASTM D792
Molding Shrinkage - Flow			ASTM D955
0.125 in	8.0E-4	in/in	
0.250 in	1.8E-3	in/in	
Water Absorption (24 hr)	0.22	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	750000	psi	ASTM D638
Tensile Strength (Break, 73°F)	12100	psi	ASTM D638
Tensile Elongation (Break, 73°F)	2.7	%	ASTM D638
Flexural Modulus (73°F)	940000	psi	ASTM D790
Flexural Strength (Break, 73°F)	16300	psi	ASTM D790
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	59		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	214	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	212	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94

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

