TES J-1200/30/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 • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight		
Additive	• Flame Retardant		
Features	• Good Dimensional Stability	• Good Impact Resistance	
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity	1.41		ASTM D792
Molding Shrinkage - Flow			ASTM D955
0.125 in	6.0E-4	in/in	
0.250 in	1.3E-3	in/in	
Water Absorption (24 hr)	0.21	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus (73°F)	870000	psi	ASTM D638
Tensile Strength (Break, 73°F)	13300	psi	ASTM D638
Tensile Elongation (Break, 73°F)	2.7	%	ASTM D638
Flexural Modulus (73°F)	1.05E+6	psi	ASTM D790
Flexural Strength (Break, 73°F)	16600	psi	ASTM D790
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (M-Scale)	64		ASTM D785
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (66 psi, Unannealed)	224	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	214	°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