

## TES J-1200/20

### 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
Features	• Good Dimensional Stability
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

#### ASTM & ISO Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.23		ASTM D792
Molding Shrinkage - Flow			ASTM D955
0.125 in	3.0E-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)	900000	psi	ASTM D638
Tensile Strength (Break, 73°F)	12000	psi	ASTM D638
Tensile Elongation (Break, 73°F)	2.0	%	ASTM D638
Flexural Modulus (73°F)	850000	psi	ASTM D790
Flexural Strength (Break, 73°F)	16000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	1.5	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	75		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	225	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	210	°F	ASTM D648
RTI Elec			UL 746
0.06 in	140	°F	
0.12 in	140	°F	
0.24 in	140	°F	
RTI Imp			UL 746
0.06 in	140	°F	
0.12 in	140	°F	
0.24 in	140	°F	
RTI Str			UL 746
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

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
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

