

TES J-4/30/VO

Techmer Polymer Modifiers - Polyamide 612

Product Description

Molding Parameters:

The dry temperature at 16 hours is 165°F.

For 2-zone machines, the rear temperature is 510-540°F, and the front temperature is 500-530°F.

General

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Europe • North America • Asia Pacific • Latin America
Filler / Reinforcement	• Glass Fiber
Additive	• Flame Retardant
Features	• Flame Retardant
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.55		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.16	%	ASTM D570
Mechanical			
Tensile Modulus (73°F)	1.00E+6	psi	ASTM D638
Tensile Strength (Break, 73°F)	19000	psi	ASTM D638
Tensile Elongation (Break, 73°F)	3.5	%	ASTM D638
Flexural Modulus (73°F)	1.25E+6	psi	ASTM D790
Flexural Strength (Break, 73°F)	28000	psi	ASTM D790
Impact			
Notched Izod Impact (73°F, 0.250 in)	1.5	ft·lb/in	ASTM D256
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	405	°F	ASTM D648
Flammability			
Flame Rating (0.06 in)	V-0		UL 94

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	490 to 520	°F
Middle Temperature	520 to 550	°F
Front Temperature	500 to 540	°F
Nozzle Temperature	480 to 550	°F
Processing (Melt) Temp	480 to 530	°F
Mold Temperature	140 to 180	°F

