TES J-80/20

Techmer Polymer Modifiers - *Acetal (POM) Copolymer*

Product Description			
Molding Parameters: For 2-zone machines, the rear temperature is 360-410°F, and the front temperature is 350-380°F.			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight		
Features	• Chemical Resistant • Copolymer • Good Dimensional Stability	• Good Stiffness • Good Toughness • High Strength	• Self Lubricating
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity	1.55		ASTM D792
Molding Shrinkage - Flow	5.0E-3 to 6.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.27	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	1.00E+6	psi	ASTM D638
Tensile Strength (Yield)	12000	psi	ASTM D638
Tensile Elongation (Yield)	2.2	%	ASTM D638
Flexural Modulus	800000	psi	ASTM D790
Flexural Strength (Yield)	16000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F, 0.125 in)	1.0	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)	325	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	320	°F	ASTM D648

Processing Information

Injection	**Nominal Value**	**Unit**
Drying Temperature	160	°F
Drying Time	1.0	hr
Rear Temperature	350 to 380	°F
Middle Temperature	370 to 410	°F
Front Temperature	360 to 390	°F
Nozzle Temperature	350 to 400	°F
Processing (Melt) Temp	380 to 420	°F
Mold Temperature	180 to 250	°F