

HiFill® ABS 348 11-0601 Br White

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• White
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.10		ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	6.3	g/10 min	ASTM D1238
Moisture (266°F)	0.080	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	8100	psi	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	3.6	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	450 to 480	°F
Middle Temperature	460 to 490	°F
Front Temperature	470 to 500	°F
Nozzle Temperature	475 to 505	°F
Processing (Melt) Temp	450 to 500	°F
Mold Temperature	100 to 175	°F
Injection Rate	Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	Slow-Moderate	

Notes

¹ Typical properties: these are not to be construed as specifications.

