

HiFill® ABS 348 LE PL041

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

General Information

General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.06		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	15.0	psi	ASTM D638
Tensile Strength (Yield)	7500	psi	ASTM D638
Tensile Strength (Break)	6000	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	440000	psi	ASTM D790
Flexural Strength	12000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.5	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	465 to 505	°F
Mold Temperature	100 to 175	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 100	psi
Screw Speed	Slow-Moderate	

Notes

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

