

HiFill® ABS CC20 IM BK93398

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Impact Modifier
Features	• Impact Modified
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.12		ASTM D792
Molding Shrinkage - Flow (0.125 in)	8.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.19	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	155000	psi	ASTM D638
Tensile Strength (Yield)	2600	psi	ASTM D638
Tensile Strength (Break)	2500	psi	ASTM D638
Tensile Elongation (Break)	4.9	%	ASTM D638
Flexural Modulus	165000	psi	ASTM D790
Flexural Strength	4000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.70	ft-lb/in	ASTM D256
Unnotched Izod Impact	9.4	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	219	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	165	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	440 to 480	°F
Middle Temperature	450 to 500	°F
Front Temperature	460 to 510	°F
Nozzle Temperature	470 to 520	°F
Processing (Melt) Temp	450 to 520	°F
Mold Temperature	100 to 175	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

Notes

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

