

## HiFill® ABS GB10 BK

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

### General Information

#### General

|                        |                                    |
|------------------------|------------------------------------|
| Material Status        | • Commercial: Active               |
| Availability           | • North America                    |
| Filler / Reinforcement | • Glass Bead, 10% Filler by Weight |
| Appearance             | • Black                            |
| Processing Method      | • Injection Molding                |

### Properties <sup>1</sup>

| Physical                       | Nominal Value | Unit     | Test Method |
|--------------------------------|---------------|----------|-------------|
| Density / Specific Gravity     | 1.11          |          | ASTM D792   |
| Mechanical                     | Nominal Value | Unit     | Test Method |
| Tensile Modulus                | 360000        | psi      | ASTM D638   |
| Tensile Strength (Yield)       | 5700          | psi      | ASTM D638   |
| Tensile Elongation (Break)     | 15            | %        | ASTM D638   |
| Impact                         | Nominal Value | Unit     | Test Method |
| Notched Izod Impact (0.125 in) | 1.8           | ft·lb/in | ASTM D256   |

### Processing Information

| Injection              | Nominal Value | Unit |
|------------------------|---------------|------|
| Drying Temperature     | 180           | °F   |
| Drying Time            | 2.0 to 4.0    | hr   |
| Rear Temperature       | 455 to 480    | °F   |
| Middle Temperature     | 465 to 490    | °F   |
| Front Temperature      | 475 to 500    | °F   |
| Nozzle Temperature     | 475 to 500    | °F   |
| Processing (Melt) Temp | 475 to 525    | °F   |
| Mold Temperature       | 110 to 150    | °F   |
| Injection Rate         | Slow-Moderate |      |
| Back Pressure          | 0.00 to 100   | psi  |
| Screw Speed            | Slow-Moderate |      |

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

