

HiFill® ABS GF20 BK

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20		ASTM D792
Molding Shrinkage - Flow (0.125 in)	3.0E-3 to 5.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	900000	psi	ASTM D638
Tensile Strength (Yield)	11000	psi	ASTM D638
Tensile Strength (Break)	10500	psi	ASTM D638
Tensile Elongation (Break)	1.5	%	ASTM D638
Flexural Modulus	950000	psi	ASTM D790
Flexural Strength	15000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.0	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	440 to 480	°F
Middle Temperature	450 to 490	°F
Front Temperature	460 to 500	°F
Nozzle Temperature	470 to 510	°F
Processing (Melt) Temp	450 to 515	°F
Mold Temperature	100 to 175	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

Notes

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

