

HiFill® ABS GF40

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 40% Filler by Weight
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.37		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	1.60E+6	psi	ASTM D638
Tensile Strength (Yield)	12500	psi	ASTM D638
Tensile Strength (Break)	12500	psi	ASTM D638
Tensile Elongation (Break)	1.2	%	ASTM D638
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	3.0 to 4.0	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	0.00 to 50.0	psi
Screw Speed	Slow	

Notes

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

