

HiFill® ABS-R WT142013

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

General Information

General	
Material Status	Commercial: Active
Availability	North America
Recycled Content	Yes
Appearance	White
Processing Method	Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.30		ASTM D792
Molding Shrinkage - Flow (0.125 in)	8.0E-3 to 0.011	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	400000	psi	ASTM D638
Tensile Strength (Yield)	4800	psi	ASTM D638
Tensile Strength (Break)	3900	psi	ASTM D638
Tensile Elongation (Break)	7.5	%	ASTM D638
Flexural Modulus	430000	psi	ASTM D790
Flexural Strength	8900	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	480 to 510	°F
Processing (Melt) Temp	460 to 510	°F
Mold Temperature	100 to 175	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Moderate	

Notes

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

