

HiFill® Cool Gray 3

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Grey
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.07		ASTM D792
Molding Shrinkage - Flow (0.125 in)	4.0E-3 to 6.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	360000	psi	ASTM D638
Tensile Strength (Yield)	7000	psi	ASTM D638
Tensile Strength (Break)	7000	psi	ASTM D638
Tensile Elongation (Break)	1.5	%	ASTM D638
Flexural Modulus	380000	psi	ASTM D790
Flexural Strength	10000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	3.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	198	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	185	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	455 to 485	°F
Middle Temperature	465 to 495	°F
Front Temperature	475 to 505	°F
Nozzle Temperature	485 to 515	°F
Processing (Melt) Temp	465 to 520	°F
Mold Temperature	100 to 150	°F
Injection Rate	Moderate-Fast	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Moderate	

Notes

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

