

HiFill FR® J-1200/30/VO/NatI

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

General Information

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight		
Features	• Flame Retardant	• Good Dimensional Stability	• Good Impact Resistance
RoHS Compliance	• RoHS Compliant		
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.41		ASTM D792
Molding Shrinkage - Flow	6.0E-4 to 1.3E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.21	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	870000	psi	ASTM D638
Tensile Strength (Yield)	13300	psi	ASTM D638
Tensile Elongation (Yield)	2.7	%	ASTM D638
Flexural Modulus	1.05E+6	psi	ASTM D790
Flexural Strength (Yield)	16600	psi	ASTM D790
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	64		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	224	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	214	°F	ASTM D648
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	160 to 180	°F
Drying Time	2.0 to 16	hr
Rear Temperature	410 to 440	°F
Middle Temperature	420 to 450	°F
Front Temperature	400 to 420	°F
Nozzle Temperature	380 to 420	°F
Processing (Melt) Temp	440 to 490	°F
Mold Temperature	150 to 180	°F

Notes

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

