

**HiFill® J-1200/10 BK2089**

 Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*
**General Information**
**General**

|                   |  |
|-------------------|--|
| Material Status   | <ul style="list-style-type: none"> <li>Commercial: Active</li> </ul> |
| Availability      | <ul style="list-style-type: none"> <li>North America</li> </ul>      |
| Appearance        | <ul style="list-style-type: none"> <li>Black</li> </ul>              |
| Processing Method | <ul style="list-style-type: none"> <li>Injection Molding</li> </ul>  |

**Properties <sup>1</sup>**

| Physical                                 | Nominal Value | Unit                  | Test Method |
|--|---------------|-----------------------|-------------|
| Melt Mass-Flow Rate (MFR) (230°C/3.8 kg) | 2.9           | g/10 min              | ASTM D1238  |
| Mechanical                               | Nominal Value | Unit                  | Test Method |
| Tensile Stress (Yield)                   | 11000         | psi                   | ISO 527-2   |
| Tensile Strain (Break)                   | 1.5           | %                     | ISO 527-2   |
| Impact                                   | Nominal Value | Unit                  | Test Method |
| Notched Izod Impact Strength (0.125 in)  | 3.1           | ft·lb/in <sup>2</sup> | ISO 180     |

**Processing Information**

| Injection              | Nominal Value | Unit |
|------------------------|---------------|------|
| Drying Temperature     | 180           | °F   |
| Drying Time            | 2.0 to 4.0    | hr   |
| Rear Temperature       | 455 to 480    | °F   |
| Middle Temperature     | 465 to 490    | °F   |
| Front Temperature      | 475 to 500    | °F   |
| Nozzle Temperature     | 475 to 500    | °F   |
| Processing (Melt) Temp | 475 to 525    | °F   |
| Mold Temperature       | 110 to 150    | °F   |
| Injection Rate         | Slow          |      |
| Back Pressure          | 0.00 to 50.0  | psi  |
| Screw Speed            | Slow          |      |

**Notes**
<sup>1</sup> Typical properties: these are not to be construed as specifications.
