

HiFill® J-30/30 BK

Techmer Polymer Modifiers - *General Purpose Polystyrene*

General Information

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.28		ASTM D792
Molding Shrinkage - Flow (0.125 in)	2.0E-3 to 4.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	5500	psi	ASTM D638
Tensile Strength (Break)	5000	psi	ASTM D638
Tensile Elongation (Break)	0.60	%	ASTM D638
Flexural Modulus	1.20E+6	psi	ASTM D790
Flexural Strength	4200	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.80	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	375 to 495	°F
Middle Temperature	385 to 405	°F
Front Temperature	395 to 415	°F
Nozzle Temperature	400 to 425	°F
Processing (Melt) Temp	380 to 425	°F
Mold Temperature	75 to 150	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow-Moderate	

Notes

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

