

HiFill® J-30/30 BK1950

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
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	2.0 to 4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	2.0E-3 to 4.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.52E+6	psi	ISO 527-1
Tensile Stress (Yield)	10200	psi	ISO 527-2
Tensile Stress (Break)	10200	psi	ISO 527-2
Tensile Strain (Break)	0.90	%	ISO 527-2
Flexural Modulus	1.45E+6	psi	ISO 178
Flexural Stress	16000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.9	ft-lb/in	ISO 180

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	375 to 395	°F
Middle Temperature	385 to 405	°F
Front Temperature	395 to 415	°F
Nozzle Temperature	400 to 420	°F
Processing (Melt) Temp	380 to 420	°F
Mold Temperature	75 to 150	°F
Injection Rate	Slow-Moderate	
Back Pressure	25.0 to 75.0	psi
Screw Speed	Slow	

Notes

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

