

## HiFill® ABS/PBT 1500 HF BK

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

### General

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

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.16		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	370000	psi	ASTM D638
Tensile Strength (Yield)	7500	psi	ASTM D638
Tensile Strength (Break)	5000	psi	ASTM D638
Tensile Elongation (Break)	10	%	ASTM D638
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	490 to 520	°F
Middle Temperature	500 to 530	°F
Front Temperature	510 to 540	°F
Nozzle Temperature	520 to 550	°F
Processing (Melt) Temp	500 to 550	°F
Mold Temperature	125 to 200	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

