

HiFill FR® ABS-1200/GB/10/FR BK

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Bead, 10% Filler by Weight
Additive	• Flame Retardant
Features	• Flame Retardant
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	5000	psi	ASTM D638
Tensile Elongation (Break)	3.2	%	ASTM D638
Flexural Modulus	500000	psi	ASTM D790
Flexural Strength	9200	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.40	ft·lb/in	ASTM D256
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.12 in)	V-0		UL 94

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	

