

**HiFill® J-1200/10 BK2089**

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
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	

