

HiFill FR® J-1200/20/VO/ND BK2

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

General

Material Status	• Commercial: Active
Availability	• North America
Additive	• Flame Retardant
Features	• Flame Retardant
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.37		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	10000	psi	ASTM D638
Tensile Elongation (Break)	1.3	%	ASTM D638
Flexural Modulus	1.20E+6	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.80	ft·lb/in	ASTM D256
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 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-Moderate	
Back Pressure	0.00 to 100	psi
Screw Speed	Slow-Moderate	

