

HiFill FR® J-1200/30/VO/NatI

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

General

| | |
|------------------------|---|
| Material Status | • Commercial: Active |
| Availability | • Africa & Middle East • Europe • North America • Asia Pacific • Latin America |
| Filler / Reinforcement | • Glass Fiber, 30% Filler by Weight |
| Features | • Flame Retardant • Good Dimensional Stability • Good Impact Resistance |
| RoHS Compliance | • RoHS Compliant |
| Forms | • Pellets |
| Processing Method | • Injection Molding |

ASTM & ISO Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|---|------------------|-------|-------------|
| Density / Specific Gravity | 1.41 | | ASTM D792 |
| Molding Shrinkage - Flow | 6.0E-4 to 1.3E-3 | in/in | ASTM D955 |
| Water Absorption (24 hr) | 0.21 | % | ASTM D570 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Modulus | 870000 | psi | ASTM D638 |
| Tensile Strength (Yield) | 13300 | psi | ASTM D638 |
| Tensile Elongation (Yield) | 2.7 | % | ASTM D638 |
| Flexural Modulus | 1.05E+6 | psi | ASTM D790 |
| Flexural Strength (Yield) | 16600 | psi | ASTM D790 |
| Hardness | Nominal Value | Unit | Test Method |
| Rockwell Hardness (M-Scale) | 64 | | ASTM D785 |
| Thermal | Nominal Value | Unit | Test Method |
| Deflection Temperature Under Load (66 psi, Unannealed) | 224 | °F | ASTM D648 |
| Deflection Temperature Under Load (264 psi, Unannealed) | 214 | °F | ASTM D648 |
| Flammability | Nominal Value | Unit | Test Method |
| Flame Rating (0.06 in) | V-0 | | UL 94 |

Processing Information

| Injection | Nominal Value | Unit |
|------------------------|---------------|------|
| Drying Temperature | 160 to 180 | °F |
| Drying Time | 2.0 to 16 | hr |
| Rear Temperature | 410 to 440 | °F |
| Middle Temperature | 420 to 450 | °F |
| Front Temperature | 400 to 420 | °F |
| Nozzle Temperature | 380 to 420 | °F |
| Processing (Melt) Temp | 440 to 490 | °F |
| Mold Temperature | 150 to 180 | °F |

