

HiFill® J-1200/10 NATL

Techmer Polymer Modifiers - *Acrylonitrile Butadiene Styrene*

General

| | |
|-------------------|----------------------|
| Material Status | • Commercial: Active |
| Availability | • North America |
| Appearance | • Natural Color |
| Processing Method | • Injection Molding |

Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|--|---------------|-----------------------|-------------|
| Melt Mass-Flow Rate (MFR) (230°C/3.8 kg) | 2.0 | g/10 min | ASTM D1238 |
| Mechanical | Nominal Value | Unit | Test Method |
| Tensile Stress (Yield) | 8300 | psi | ISO 527-2 |
| Tensile Strain (Break) | 1.9 | % | ISO 527-2 |
| Flexural Modulus | 624000 | psi | ISO 178 |
| Flexural Stress | 12600 | psi | ISO 178 |
| Impact | Nominal Value | Unit | Test Method |
| Notched Izod Impact Strength (0.125 in) | 3.3 | ft·lb/in ² | 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 | |

