

HiFill FR® J-1200/20/VO/Natl

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, 20% Filler by Weight
Features	• Flame Retardant • Good Impact Resistance • Good Dimensional Stability • High Heat Resistance
RoHS Compliance	• RoHS Compliant
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.37		ASTM D792
Molding Shrinkage - Flow	8.0E-4 to 1.8E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.22	%	ASTM D570
Mechanical			
Tensile Modulus	750000	psi	ASTM D638
Tensile Strength (Yield)	12100	psi	ASTM D638
Tensile Elongation (Yield)	2.7	%	ASTM D638
Flexural Modulus	940000	psi	ASTM D790
Flexural Strength (Yield)	16300	psi	ASTM D790
Hardness			
Rockwell Hardness (M-Scale)	59		ASTM D785
Thermal			
Deflection Temperature Under Load (66 psi, Unannealed)	214	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	212	°F	ASTM D648
Flammability			
Flame Rating (0.06 in)	V-0		UL 94

Processing Information

	Nominal Value	Unit
Injection		
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

