

HiFill® J-30/30 BK

Techmer Polymer Modifiers - *General Purpose Polystyrene*

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.28	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.20 to 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	37.9	MPa	ASTM D638
Tensile Strength (Break)	34.5	MPa	ASTM D638
Tensile Elongation (Break)	0.60	%	ASTM D638
Flexural Modulus	8270	MPa	ASTM D790
Flexural Strength	29.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	43	J/m	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	82	°C
Drying Time	2.0 to 3.0	hr
Rear Temperature	191 to 257	°C
Middle Temperature	196 to 207	°C
Front Temperature	202 to 213	°C
Nozzle Temperature	204 to 218	°C
Processing (Melt) Temp	193 to 218	°C
Mold Temperature	24 to 66	°C
Injection Rate	Slow-Moderate	
Back Pressure	0.172 to 0.517	MPa
Screw Speed	Slow-Moderate	

