

HiFill® J-30/30 BK1950

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
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	2.0 to 4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.18 mm)	0.20 to 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10500	MPa	ISO 527-1
Tensile Stress (Yield)	70.0	MPa	ISO 527-2
Tensile Stress (Break)	70.0	MPa	ISO 527-2
Tensile Strain (Break)	0.90	%	ISO 527-2
Flexural Modulus	10000	MPa	ISO 178
Flexural Stress	110	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	100	J/m	ISO 180

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	82	°C
Drying Time	2.0 to 3.0	hr
Rear Temperature	191 to 202	°C
Middle Temperature	196 to 207	°C
Front Temperature	202 to 213	°C
Nozzle Temperature	204 to 216	°C
Processing (Melt) Temp	193 to 216	°C
Mold Temperature	24 to 66	°C
Injection Rate	Slow-Moderate	
Back Pressure	0.172 to 0.517	MPa
Screw Speed	Slow	

