

HiFill® ABS/PBT 1002 GF20

Acrylonitrile Butadiene Styrene

Techmer Engineered Solutions

Message:

HiFill® ABS/PBT 1002 GF20 is an Acrylonitrile Butadiene Styrene (ABS) product filled with 20% glass fiber. It can be processed by injection molding and is available in North America. Primary characteristic: flame rated.

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.33	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	0.12	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	107		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	95.8	MPa	ASTM D638
Tensile Elongation (Break)	3.3	%	ASTM D638
Flexural Modulus	6550	MPa	ASTM D790
Flexural Strength	155	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	69	J/m	ASTM D256
Unnotched Izod Impact (3.18 mm)	400	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	168	°C	
1.8 MPa, Unannealed	107	°C	
CLTE - Flow	2.9E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+16	ohms · cm	ASTM D257
Dielectric Strength ¹	18	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	76.7 to 87.8	°C	
Drying Time	2.0 to 16	hr	
Rear Temperature	216 to 232	°C	

Middle Temperature	221 to 238	°C
Front Temperature	210 to 221	°C
Nozzle Temperature	199 to 221	°C
Processing (Melt) Temp	232 to 260	°C
Mold Temperature	71.1 to 87.8	°C

NOTE

1. Method A (Short-Time)

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