

HiFill FR® ABS GF30 FR

Acrylonitrile Butadiene Styrene

Techmer Engineered Solutions

Message:

HiFill FR® ABS GF30 FR is an Acrylonitrile Butadiene Styrene (ABS) product filled with 30% glass fiber. It can be processed by injection molding and is available in North America. Primary characteristic: flame retardant.

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	Flame Retardant		
Appearance	Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.44	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.10	%	ASTM D955
Water Absorption (24 hr)	0.12	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	108		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break)	72.4	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	6210	MPa	ASTM D790
Flexural Strength	114	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	64	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	112	°C	
1.8 MPa, Unannealed	103	°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
Injection	Nominal Value	Unit	
Drying Temperature	71.1 to 82.2	°C	
Drying Time	2.0 to 16	hr	
Rear Temperature	210 to 227	°C	
Middle Temperature	216 to 232	°C	

Front Temperature	204 to 216	°C
Nozzle Temperature	193 to 216	°C
Processing (Melt) Temp	227 to 254	°C
Mold Temperature	65.6 to 82.2	°C

NOTE

1.
- Method A (Short-Time)

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