

HiFill® TPX-IONOMER-02035 BK

Techmer Polymer Modifiers - Ionomer

General

Material Status	• Commercial: Active
Availability	• North America
Appearance	• Black
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.29		ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	2.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (0.125 in)	2.0E-3 to 5.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.00E+6	psi	ASTM D638
Tensile Strength (Yield)	6500	psi	ASTM D638
Tensile Strength (Break)	6500	psi	ASTM D638
Tensile Elongation (Break)	1.5	%	ASTM D638
Flexural Modulus	850000	psi	ASTM D790
Flexural Strength	9500	psi	ASTM D790
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	190	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	1.0 to 2.0	hr
Rear Temperature	350 to 380	°F
Middle Temperature	360 to 390	°F
Front Temperature	370 to 400	°F
Nozzle Temperature	380 to 410	°F
Processing (Melt) Temp	350 to 415	°F
Mold Temperature	75 to 150	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

