

## HiFill® J-71/20 BK2791

Techmer Polymer Modifiers - *Polyamide*

### General

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

### Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.27		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.00E+6	psi	ISO 527-1
Tensile Stress (Yield)	17400	psi	ISO 527-2
Tensile Stress (Break)	17400	psi	ISO 527-2
Tensile Strain (Break)	2.5	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	4.3	ft·lb/in	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	735	°F	ISO 75-2/A

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 3.0	hr
Rear Temperature	490 to 520	°F
Middle Temperature	500 to 530	°F
Front Temperature	510 to 540	°F
Nozzle Temperature	520 to 550	°F
Processing (Melt) Temp	500 to 545	°F
Mold Temperature	125 to 200	°F
Injection Rate	Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow-Moderate	

