HiFill® SMA/PP 2210 3DP

Techmer Polymer Modifiers - *Polypropylene*

General	
Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber
Uses	• Additive Manufacturing (3D Printing)

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity [2]	1.30		ASTM D792
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus [2]	800000	psi	ASTM D638
Tensile Strength [2] (Yield)	4000	psi	ASTM D638
Tensile Elongation [2] (Break)	2.5	%	ASTM D638

Processing Information

Extrusion	Nominal Value	Unit
Drying Temperature	175	°F
Drying Time	2.0 to 3.0	hr
Cylinder Zone 1 Temp.	410 to 450	°F
Cylinder Zone 2 Temp.	420 to 460	°F
Cylinder Zone 3 Temp.	430 to 470	°F
Cylinder Zone 4 Temp.	430 to 470	°F
Melt Temperature	410 to 450	°F
Die Temperature	410 to 450	°F

Extrusion Notes

If material is to remain in dryer for more than 8 hours in dried state, reduce dryer temperature to 120°F to prevent degradation of material.