

**HiFill® PEEK 0146 B LE BL316**

 Techmer Polymer Modifiers - *Polyetheretherketone*
**General Information**
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Material Status	<ul style="list-style-type: none"> <li>Commercial: Active</li> </ul>
Availability	<ul style="list-style-type: none"> <li>North America</li> </ul>
Features	<ul style="list-style-type: none"> <li>Low Extractables</li> </ul>
Appearance	<ul style="list-style-type: none"> <li>Blue</li> </ul>
Processing Method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>

**Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.52		ASTM D792
Melt Mass-Flow Rate (MFR) (365°C/5.0 kg)	7.5	g/10 min	ASTM D1238
Moisture (347°F)	0.040	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	662000	psi	ASTM D638
Tensile Strength (Yield)	11400	psi	ASTM D638
Tensile Strength (Break)	9800	psi	ASTM D638
Tensile Elongation (Break)	12	%	ASTM D638
Flexural Modulus	693000	psi	ASTM D790
Flexural Strength	21200	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.4	ft·lb/in	ASTM D256

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	300	°F
Drying Time	3.0 to 4.0	hr
Rear Temperature	640 to 700	°F
Middle Temperature	650 to 710	°F
Front Temperature	655 to 715	°F
Nozzle Temperature	660 to 720	°F
Processing (Melt) Temp	650 to 725	°F
Mold Temperature	275 to 350	°F
Injection Rate	Slow-Moderate	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Slow	

