

HiFill® PEEK 4150 A YAG BK107 - Ver 2

Techmer Polymer Modifiers - *Polyetheretherketone*

General Information

General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.28		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	500000	psi	ASTM D638
Tensile Strength (Yield)	12500	psi	ASTM D638
Tensile Strength (Break)	11000	psi	ASTM D638
Tensile Elongation (Break)	30	%	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.5	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	710 to 750	°F
Middle Temperature	710 to 750	°F
Front Temperature	710 to 750	°F
Nozzle Temperature	710 to 750	°F
Processing (Melt) Temp	710 to 750	°F
Mold Temperature	380 to 400	°F
Injection Rate	Slow-Moderate	
Back Pressure	50.0 to 100	psi
Screw Speed	Slow	

