

HiFill® PEEK CSR GF30 NAT

 Techmer Polymer Modifiers - *Polyetheretherketone*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Appearance	• Natural Color
Processing Method	• Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.52		ASTM D792
Molding Shrinkage - Flow (0.125 in)	4.0E-3 to 6.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.65E+6	psi	ASTM D638
Tensile Strength (Yield)	20700	psi	ASTM D638
Tensile Strength (Break)	20500	psi	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	1.39E+6	psi	ASTM D790
Flexural Strength	33200	psi	ASTM D790
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	660 to 700	°F
Middle Temperature	670 to 710	°F
Front Temperature	680 to 720	°F
Nozzle Temperature	690 to 730	°F
Processing (Melt) Temp	670 to 725	°F
Mold Temperature	350 to 400	°F
Injection Rate	Moderate-Fast	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Moderate	

