

**HiFill® PEEK CSR CF20 NAT**

 Techmer Polymer Modifiers - *Polyetheretherketone*
**General Information**
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Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber, 20% Filler by Weight
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.37		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.20E+6	psi	ASTM D638
Tensile Strength (Yield)	26000	psi	ASTM D638
Tensile Strength (Break)	26000	psi	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	2.00E+6	psi	ASTM D790
Flexural Strength	39000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.5	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	88		ASTM D2240

**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	0.00 to 50.0	psi
Screw Speed	Slow	

