

HiFill® PEI GF10

 Techmer Polymer Modifiers - *Polyetherimide*
General Information
General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight
Appearance	• Colors Available
Forms	• Pellets
Processing Method	• Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.34		ASTM D792
Molding Shrinkage - Flow (0.125 in)	5.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.22	%	ASTM D570
Mechanical			
Tensile Strength (Break)	17500	psi	ASTM D638
Flexural Modulus	750000	psi	ASTM D790
Flexural Strength	29500	psi	ASTM D790
Impact			
Notched Izod Impact (73°F, 0.125 in)	1.0	ft-lb/in	ASTM D256
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	410	°F	ASTM D648
Flammability			
Flame Rating	V-0		UL 94

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	285	°F
Drying Time	3.0	hr
Rear Temperature	675 to 735	°F
Middle Temperature	675 to 735	°F
Front Temperature	675 to 735	°F
Processing (Melt) Temp	670 to 730	°F
Mold Temperature	275 to 325	°F
Back Pressure	50.0 to 100	psi
Screw Speed	50 to 100	rpm

