

HiFill® PEI 1000 Black

 Techmer Polymer Modifiers - *Polyetherimide*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Appearance	<ul style="list-style-type: none"> Black
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.28		ASTM D792
Melt Mass-Flow Rate (MFR) (337°C/6.6 kg)	7.6	g/10 min	ASTM D1238
Moisture (302°F)	0.060	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	16000	psi	ASTM D638
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	0.83	ft·lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	275	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	650 to 710	°F
Middle Temperature	660 to 720	°F
Front Temperature	670 to 680	°F
Nozzle Temperature	680 to 735	°F
Processing (Melt) Temp	660 to 730	°F
Mold Temperature	250 to 325	°F
Injection Rate	Slow	
Back Pressure	0.00 to 50.0	psi
Screw Speed	Moderate	

